VE206 Pipe/Tubing Roll Grooving Tool

REMS AMIGO† 2 COMPACT DRIVE

RIDGID* 700 DRIVE

† Rems Amigo is a trademark of REMS GmbH & Co KG
* Ridgid is a registered trademark of Ridgid, Inc.

⚠ 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 this manual and all warning labels on the tool.**
- **Wear safety glasses, hardhat, foot protection, and hearing protection while working around this tool.**
- **Save this 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 this tool, contact Victaulic, P.O. Box 31, Easton, PA 18044-0031, Phone: 1-800-PICK VIC, E-Mail: pickvic@victaulic.com.

Original Instructions

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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.

⚠ 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.**

⚠ 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

The VE206 Roll Grooving Tool is designed for the sole purpose of roll grooving pipe/tubing. The lessee or owner of this tool is responsible for ensuring that each operator reads this manual and fully understands the operation of this grooving tool PRIOR to working with the tool. These instructions describe safe operation of the tool, including setup and maintenance. Each operator shall become familiar with the tool'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 tool requires dexterity, mechanical skills, and sound safety habits. Although this tool 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.

⚠ DANGER

1. **Avoid using the tool in potentially dangerous environments.** Do not expose the tool to rain, and do not use the tool in damp or wet locations. Do not use the tool on sloped or uneven surfaces. Keep the work area well lit. Allow sufficient space to operate the tool properly.
2. **Ground the power drive to protect the operator from electric shock.** Verify that the power drive is connected to an internally-grounded electrical source.
3. **Disconnect the power cord from the electrical source before servicing the tool.** Only authorized personnel shall perform maintenance on the tool. Always disconnect the power cord from the electrical source before servicing or adjusting the tool. Follow all lockout/tagout procedures.
4. **Prevent accidental startups.** Place the power switch in the "OFF" position before connecting the tool to an electrical source.

⚠ WARNING

1. **Follow all applicable local and national safety regulations.**
2. **Prevent back injury.** Always follow OSHA guidelines, and/or other nationally-recognized standards, for safe lifting techniques when handling tool components.
3. **Wear proper apparel.** Do not wear loose clothing, jewelry, or anything that can become entangled in moving parts.
4. **Wear protective items when working with tools.** Always wear safety glasses, hardhat, foot protection, and hearing protection (sound levels up to 104 decibels can be produced during the grooving process).
5. **Keep hands and tools away from grooving rolls during the grooving operation.** Grooving rolls can crush or cut fingers and hands. Use pipe that is a sufficient length.
6. **Do not reach inside pipe ends during tool operation.** Pipe edges can be sharp and can snag gloves, hands, and shirt sleeves.
7. **Operate the tool opposite the direction of pipe rotation.** The tool shall be operated with a safety foot switch that is located for easy operator access. Never reach across moving parts. DO NOT use the tool if it does not contain a safety foot switch (contact Victaulic).
8. **Do not over-reach.** Maintain proper balance at all times. Verify that the safety foot switch is easily accessible to the operator.
9. **Do not make any modifications to the tool.** DO NOT remove any safety guarding or any components that would affect tool safety or performance.

⚠ CAUTION

1. **The VE206 tool is designed ONLY for roll grooving pipe/tubing sizes, materials, and wall thicknesses specified in this manual.**
2. **Inspect the equipment.** Before using the tool, check moveable parts for obstructions. Verify that tool components are installed and adjusted in accordance with the "Tool Setup" section. Verify that properly matched roll sets are installed and lubricated.
3. **Stay alert.** DO NOT operate the tool if impaired by drugs (medicinal or recreational), medication, alcohol, or fatigue.
4. **Keep visitors, trainees, and observers away from the work area.** All visitors shall be kept a safe distance from equipment at all times, and shall be offered the opportunity to review this manual.
5. **Keep work areas clean.** Keep the work area around the tool clear of any obstructions that could limit movement of the operator. Clean up any spills on the floor to prevent slips or falls.
6. **Secure the work, machine, and accessories.** Verify that the tool is stable. Refer to the "Tool Setup" section.

⚠ CAUTION

7. **Support the work.** Support long pipe/tubing lengths with a pipe stand, in accordance with the "Long Pipe/Tubing Lengths" section.
8. **Do not force the tool.** Do not force the tool or accessories to perform any functions beyond the capabilities described in these instructions. Do not overload the tool.
9. **Maintain tool with care.** Keep the tool clean at all times to ensure proper and safe performance. Follow the instructions for matching and lubricating tool components.
10. **Use only Victaulic replacement parts and accessories**. Use of any other parts may result in a voided warranty, improper operation, and hazardous situations. Refer to the "Parts Ordering Information" and "Accessories" sections.
11. **Do not remove any labels from the tool.** Replace any damaged or worn labels.

INTRODUCTION

NOTICE

- **Drawings and/or pictures in this manual may be exaggerated for clarity.**
- **The tool, along with this operating and maintenance instructions manual, contains trademarks, copyrights, and/or patented features that are the exclusive property of Victaulic.**

The Victaulic VE206 is a portable hydraulic-feed tool for roll grooving pipe/tubing to receive Victaulic grooved pipe/tubing products. The standard VE206 tool is supplied with rolls for grooving 1 ¼ – 6-inch/ DN32 – DN150 carbon steel pipe. VE206 rolls are marked with the size and part number, and are color coded to identify the pipe material. For roll grooving to other specifications and materials, refer to page 37. Grooving rolls for other specifications, sizes, and materials shall be purchased separately.

⚠ WARNING

- **This tool shall be used ONLY for grooving pipe/tubing with specifications that fall within the designated parameters.**
- **Always verify that the upper and lower grooving rolls are a matched set.**

Failure to follow these instructions could damage the tool and cause product failure, resulting in death or serious personal injury and property damage.

RECEIVING THE TOOL

VE206 tools are packed individually in containers that are designed for repeated shipping. Save the original container for return shipment of rental tools.

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

CONTAINER CONTENTS

Qty.	Description
1	Tool Head Assembly
1	Stand Assembly
1	Hydraulic Hand Pump Assembly
1	Power Drive
1	Lower Roll/Main Shaft for 1 ¼ – 3-inch/DN32 – DN80 Carbon Steel Pipe
1	Lower Roll/Main Shaft for 4 – 6-inch/DN100 – DN150 Carbon Steel Pipe*
1	Safety Foot Switch
1	Storage Bag
1	3⁄16-inch Hex Key
1	5⁄16-inch Hex Key
1	9⁄16-inch Hex Key
1	Pipe Diameter Tape
2	Operating and Maintenance Manual

* Installed in the tool head assembly

NOTE: Optional items, such as roll sets for grooving stainless steel pipe or copper tubing, shall be specified on the order and may be shipped separately.

POWER REQUIREMENTS

⚠ DANGER

- **ONLY QUALIFIED ELECTRICIANS SHALL CONNECT INCOMING POWER.**
- **To reduce the risk of electric shock, check the electrical source for proper grounding.**
- **Always disconnect the power cord from the electrical source before servicing or adjusting the tool. Follow all lockout/tagout procedures.**
- **DO NOT alter plugs in any way.**

Failure to follow these instructions could result in death or serious personal injury.

POWER DRIVE REQUIREMENTS

Several power drive options are available for use with the VE206, as shown in the table below. Consult the power drive manufacturer's instructions for proper operation.

Compatible Power Drives
Rems Amigo 2 Compact
Ridgid 700
Ridgid 300
VPD 752

Contact Victaulic before attaching a power drive system not listed above. Alternate drive systems require different mounting hardware.

Power shall be supplied to the power drive through a safety foot switch to ensure safe operation. Verify that the power drive is grounded properly in accordance with Article 250 of the National Electrical Code. Always refer to the operating manual for the power drive for additional information.

If an extension cord is required, refer to the "Extension Cord Requirements" section for cord sizes.

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 tool rating (amps) and cord length (feet). Use of a cord size (gauge) thinner than required will cause significant voltage drop at the power drive or tool motor while the tool is operating. Voltage drops may cause damage to the power drive or tool motor and can result in improper tool operation. **NOTE:** It is acceptable to use a cord size that is thicker than required.

Listed in the chart below are recommended cord size (gauge) for cord lengths up to and including 100 feet/31 meters. Use of extension cords beyond 100 feet/31 meters in length shall be avoided.

Power Drive Rating volts/amps	Cord Lengths		
	25 feet 8 meters	50 feet 15 meters	100 feet 31 meters
110 12	12 gauge	12 gauge	10 gauge
220 6	14 gauge	12 gauge	10 gauge

TOOL NOMENCLATURE

NOTICE

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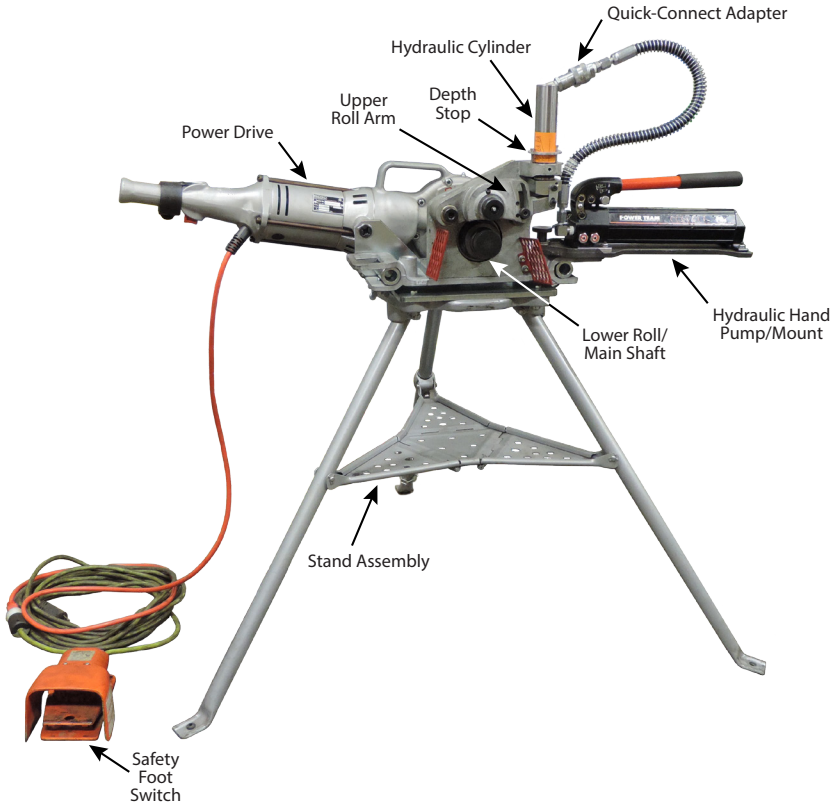
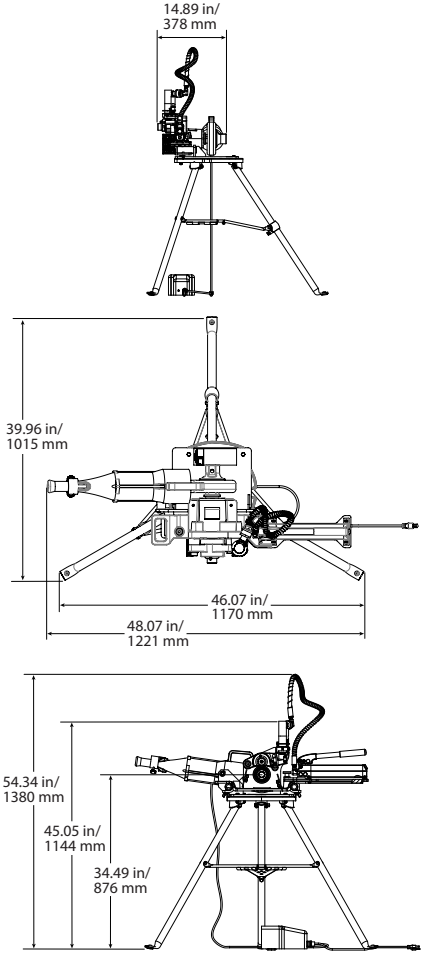
- **The tool, along with this operating and maintenance instructions manual, contains trademarks, copyrights, and/or patented features that are the exclusive property of Victaulic.**

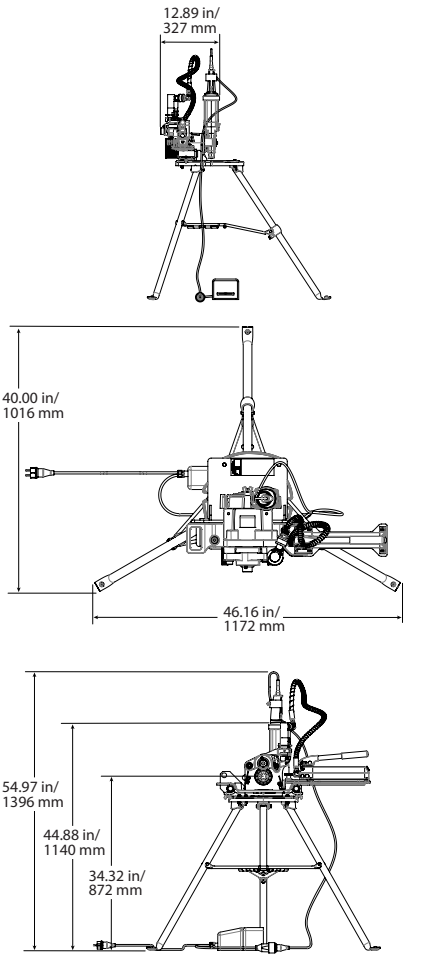


IMPORTANT SAFETY INFORMATION LABELS PROVIDED ON THE TOOL

TOOL DIMENSIONS AND SPECIFICATIONS



Ridgid 700



Rems Amigo 2 Compact

Tool weight is 165 pounds/75 kilograms. Tool weight includes the tool head assembly, power drive, stand assembly, hand pump, and safety foot switch. The tool head assembly alone weighs approximately 63 pounds/29 kilograms.

Tool sound pressure is 103.6 dB(A), while tool sound power is 95.6 dB(A). All measurements taken with a Ridgid 700 power drive.

NOTE: Noise measurements are dependent on the power drive, and will vary based on configuration. Always check the power drive manufacturer's documentation for details.

SETUP OF THE STAND ASSEMBLY

⚠ DANGER

- **DO NOT connect power until instructed otherwise.**

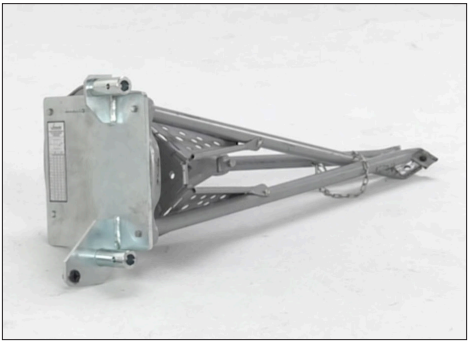
Failure to follow this instruction could result in death or serious personal injury.

The VE206 tool is intended for field or shop setup.

1. Remove all components from the packaging, and verify that all necessary items are included. Refer to the "Receiving the Tool" section.

2. Select a location for the tool by taking into consideration the following factors (refer to "Tool Dimensions And Specifications" for overall dimensions):

- **a.** The required power supply (verify the voltage of the power drive as 110 volt or 220 volt)
- **b.** Adequate space to handle pipe lengths
- **c.** A firm and level surface for the tool and pipe stand
- **d.** Adequate clearance around the tool for adjustment and maintenance.



3. Place the stand assembly in the horizontal position (lying down).

4. Remove the chain from around the three legs.

5. Carefully lift and open the stand into the vertical position (upright), as shown. Verify that each leg is extended completely and that the stand is level and stable before proceeding.

SETUP OF THE TOOL HEAD ASSEMBLY

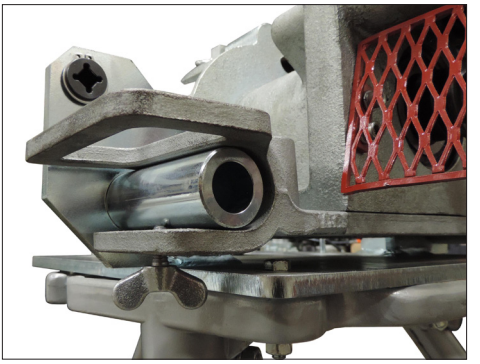
⚠ WARNING

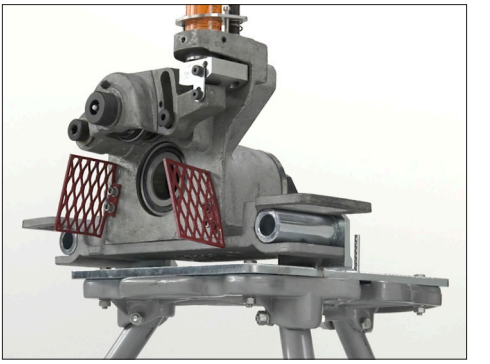
- **Always use proper lifting techniques when handling the tool head assembly.**

Failure to follow this instruction could result in personal injury.

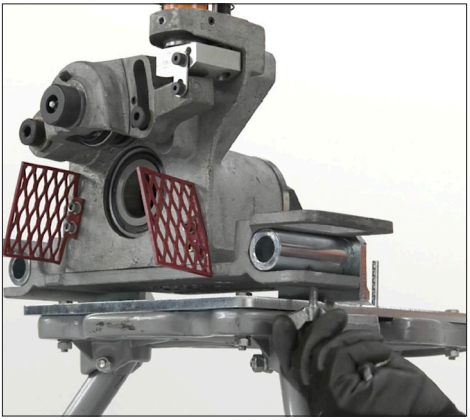
1. Using proper lifting techniques, lift the tool head assembly by the two handles with the roll guards facing toward you, as shown. DO NOT lift the tool head assembly by the roll guards.

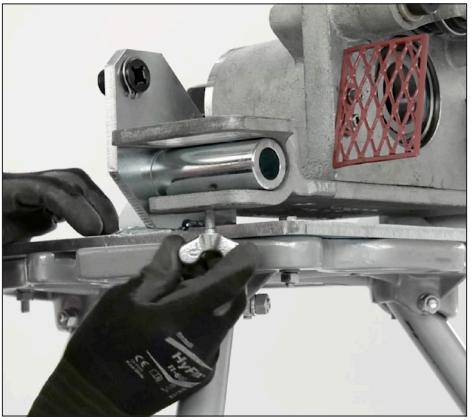
NOTE: Tool head assembly weighs approximately 63 pounds/29 kilograms.





2. Slide the tool head assembly onto the stand assembly. The grooving rolls shall be facing outward, as shown above.





3. Tighten each wing head thumb screw to secure the tool head assembly onto the stand assembly. Verify that the bolts are tightened evenly on both the left and right sides of the tool head assembly.

4. Level the tool from the top of the stand assembly, as shown above.

SETUP OF THE RIDGID 700 POWER DRIVE

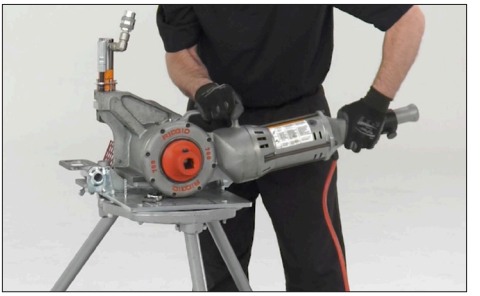
⚠ DANGER

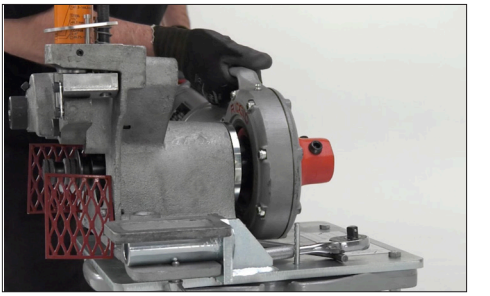
- **DO NOT connect power until instructed otherwise.**

Failure to follow this instruction could result in death or serious personal injury.

NOTICE

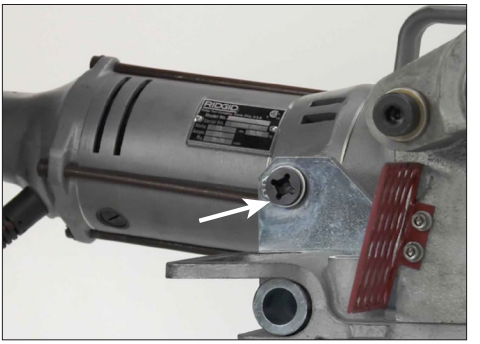
- **The VE206 requires drive-specific mounting hardware. Verify that the power drive is compatible with the provided hardware before mounting.**

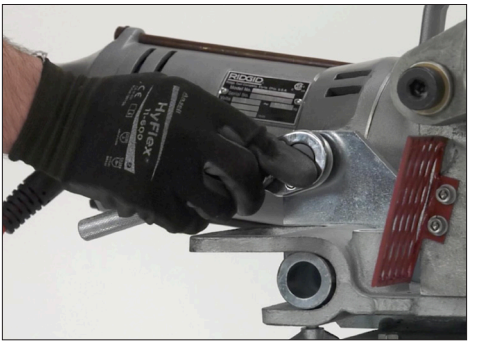




1. Place the Ridgid 700 Power Drive on the back of the stand assembly. Align the tapped hole in the Ridgid 700 Power Drive's body with the hole in the mounting bracket on the base plate.

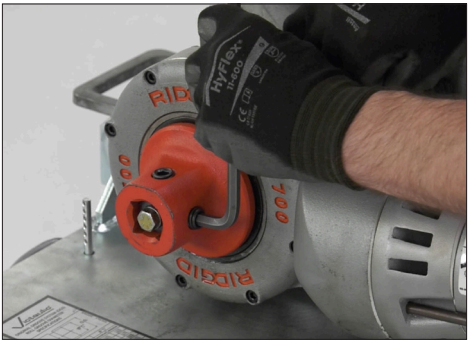
2. Align the square drive adapter of the Ridgid 700 Power Drive with the square drive of the tool head assembly, then push the power drive toward the tool head assembly, as shown above.

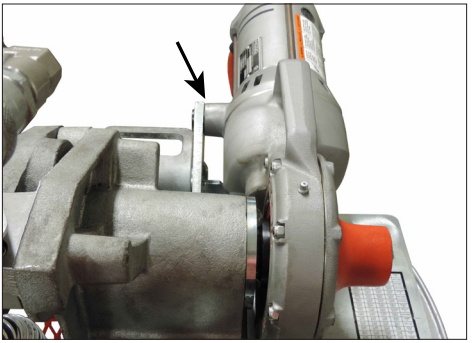




3. Align the mounting screw (attached to a mounting plate on the stand assembly) through the tapped hole in the body of the Ridgid 700 power drive, as shown above.

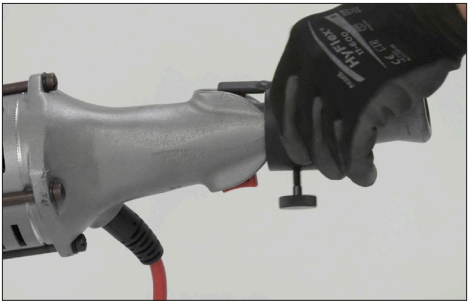
4. Using a ⅜-inch square drive ratchet, tighten the mounting screw to secure the Ridgid 700 power drive to the stand assembly.

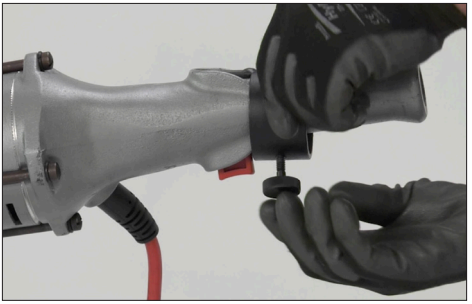




5. Using a 5⁄16-inch hex key, tighten each set screw on the square drive adapter of the Ridgid 700 power drive.

6. Verify that the Ridgid 700 power drive is properly aligned with the tool head assembly. The edge of the tapped hole on the power drive shall lie flush against the mounting plate on the stand assembly, as shown above.





7. Install the trigger lock onto the power drive, as shown above. Tighten the mounting screw on the underside of the trigger lock.

NOTE: It is important that the trigger lock's tab depresses the trigger so that the lower roll rotates away from the operator when viewed from the top of the tool. (See Figure 2 on page 20 for more information.)

If rotation of the lower roll is toward the operator, turn the trigger lock upside-down and reattach it so that the tab depresses the switch on the underside of the power drive.

⚠ WARNING

- **DO NOT operate the power drive without a safety foot switch. If the tool does not contain a safety foot switch, contact Victaulic.**

Operating the tool without a safety foot switch could result in serious personal injury.

⚠ DANGER

- **To reduce the risk of electric shock, check the electrical source for proper grounding.**
- **Before performing any maintenance on the tool, disconnect the power cord from the electrical source.**

Failure to follow these instructions could result in death or serious personal injury.

8. Remove the safety foot switch from the storage box.

9. Plug the Ridgid 700 power drive cord into the safety foot switch, as shown. Plug the safety foot switch cord into a grounded electrical outlet. Refer to the power drive manufacturer's operating manual for additional information.

10. Depress the safety foot switch. Verify that the lower roll rotates away from the operator when viewed from the top of the tool. If the lower roll rotates toward the operator, reverse the trigger lock as outlined in step 7. Remove foot from the safety foot switch.

11. Verify that the tool is stable. If the tool wobbles, verify that the legs are adjusted correctly and that the tool is level. If the wobble persists, the tool shall be relocated to a more level surface.

SETUP OF THE REMS AMIGO 2 COMPACT POWER DRIVE

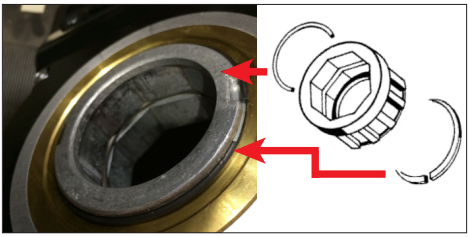
⚠ DANGER

- **DO NOT connect power until instructed otherwise.**

Failure to follow this instruction could result in death or serious personal injury.

NOTICE

- **The VE206 requires drive-specific mounting hardware. Verify that the power drive is compatible with the provided hardware before mounting.**



1. The Rems Amigo 2 Compact Power Drive shall be equipped with the stop ring (Rems No. 522005R) and the locking ring (Rems No. 522018) prior to assembly with the VE206.

2. Hold the Rems Amigo 2 Compact Power Drive with the motor handle facing upwards. Align the drive bushing of the tool head assembly with the retaining ring of the power drive. Push the power drive over the drive bushing.

⚠ WARNING

- **DO NOT operate the power drive without a safety foot switch. If the tool does not contain a safety foot switch, contact Victaulic.**

Operating the tool without a safety foot switch could result in serious personal injury.

⚠ DANGER

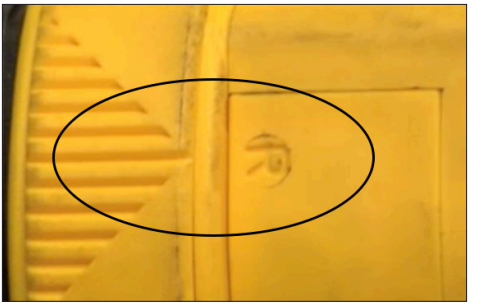
- **To reduce the risk of electric shock, check the electrical source for proper grounding.**
- **Before performing any maintenance on the tool, disconnect the power cord from the electrical source.**

Failure to follow these instructions could result in death or serious personal injury.

3. Plug the Rems Amigo 2 Compact Power Drive cord into a grounded electrical outlet. Refer to the power drive manufacturer's operating manual for additional information.

4. Depress the safety foot switch. Verify that the lower roll rotates away from the operator when viewed from the front of the tool. (See Figure 2 on page 20 for more information.) If the lower roll rotates toward the operator, reverse the rotation collar as outlined in step 7. Remove foot from the safety foot switch.

5a. Locate the rotation collar at the base of the Rems Amigo 2 Compact Power Drive body.

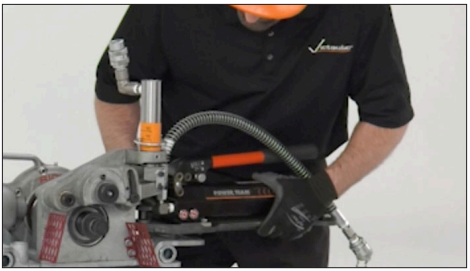


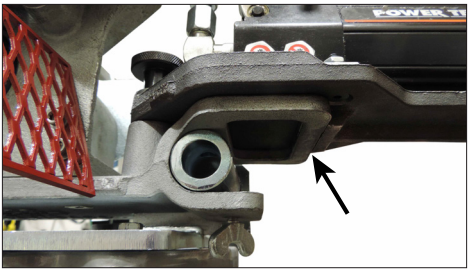
5b. The body features **L** (left) and **R** (right) markings. To reverse the direction of rotation, twist the collar to align the arrow with the opposite marking.

6. Verify that the tool is stable. If the tool wobbles, verify that the legs are adjusted correctly and that the tool is level. If the wobble persists, the tool shall be relocated to a more level surface.

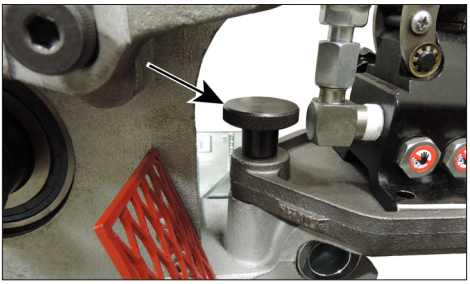
SETUP OF THE HYDRAULIC HAND PUMP

The hydraulic hand pump can be installed on either the left-hand or right-hand side of the tool.





1. Place the hydraulic hand pump over one of the lifting handles on the tool head assembly. Verify that the lip on the underside of the pump's mounting plate aligns with the edge of the lifting handle.



2. Tighten the thumbscrew to secure the hydraulic hand pump to the tool head assembly.

3. Confirm that the hydraulic hand pump valve is not holding any residual pressure by rotating the hydraulic hand pump valve **counterclockwise** to open the valve.

4. Remove the cap and install the quick-connect adapter onto the hydraulic cylinder connection, tightening completely. If the collar is not fully seated and tightened, the ball check may not operate properly, allowing hydraulic fluid to flow back through the hose.

PRE-OPERATION CHECKS AND ADJUSTMENTS

Every Victaulic roll grooving tool is checked, adjusted, and tested at the factory prior to shipment. However, before operating the tool, the following checks and adjustments shall be made to ensure proper tool operation. In addition, the tool shall be inspected for any damage that may have occurred during shipping and handling.

⚠ DANGER

- **Before making any tool adjustments, disconnect the power cord from the electrical source.**

Accidental startup of the tool could result in death or serious personal injury.

GROOVING ROLLS

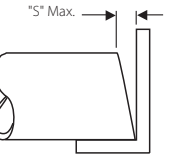
Verify that the proper roll set is installed on the tool for the pipe/tubing size and material to be grooved. Roll sets are marked with the pipe/tubing size and part number, and they are color coded for the pipe/tubing material. Refer to page 36. If the proper rolls are not installed on the tool, refer to the “Roll Changing” section.

PIPE/TUBING PREPARATION

For proper tool operation and production of grooves that are within Victaulic specifications:

1. Victaulic recommends square-cut pipe. **Square-cut pipe SHALL be used with Victaulic products containing FlushSeal™ and EndSeal™ gaskets.** Beveled-end pipe may be used, provided that the wall thickness is standard wall (ANSI B36.10) or less and that the bevel meets ANSI B16.25 (37½°) or ASTM A-53 (30°). **NOTE:** Roll grooving beveled-end pipe may result in unacceptable flare, leaks, or joint failure.

The maximum allowable tolerance from square-cut pipe ends is:
1/32 inch/0.8 mm for 1¼ – 3-inch/DN32 – DN80 sizes
1/16 inch/1.6 mm for 4-inch/DN100 and larger sizes
This is measured from the true square line.



2. Any internal and external weld beads or seams shall be ground flush to the pipe surface 2 inches/51 mm back from the pipe ends.

3. The inside diameter of the pipe end shall be cleaned to remove coarse scale, dirt, and other foreign material that might interfere with or damage grooving rolls.

4. The front edge of the pipe end shall be uniform with no concave/convex surface features that will cause improper grooving roll tracking and result in difficulties during coupling assembly.

⚠ CAUTION

- **For maximum grooving roll life, remove foreign material and loose rust from the interior and exterior surfaces of the pipe/tubing ends. Rust is an abrasive material that will wear the surface of grooving rolls.**

Foreign material may interfere with or damage grooving rolls, resulting in distorted grooves and grooves that are out of Victaulic specifications.

PIPE/TUBING LENGTHS SUITABLE FOR GROOVING

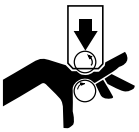
The VE206 tool is capable of grooving short pipe lengths without the use of a pipe stand. Refer to the "Short Pipe/Tubing Lengths" section on this page.

Pipe that exceeds the maximum lengths listed in Table 1 on this page (and up to 20 feet/6 meters in length) requires the use of a pipe stand. Refer to the "Long Pipe/Tubing Lengths" section.

Pipe lengths from 20 feet/6 meters up to double-random lengths (approximately 40 feet/12 meters) shall be supported with two pipe stands.

SHORT PIPE/TUBING LENGTHS

⚠ WARNING



- **Grooving rolls can crush or cut fingers and hands.**

Never groove pipe that is shorter than the recommended lengths listed in this manual.

Table 1 identifies the minimum pipe lengths that can be grooved safely by using Victaulic Roll Grooving Tools. In addition, this table identifies the maximum pipe lengths that can be roll grooved without the use of a pipe stand. Refer to the "Grooving Operation" section for instructions on how to groove short pipe lengths.

NOTICE

- **Grooved pipe nipples, shorter than those listed in Table 1, are available from Victaulic.**

TABLE 1: PIPE LENGTHS SUITABLE FOR GROOVING

Nominal Pipe Size inches/DN	Actual Pipe Outside Diameter inches/mm	Minimum Length that can be Grooved Safely with Victaulic Tool inches/mm	Maximum Length that can be Grooved Without Use of Pipe Stand inches/mm
1¼ – 4 DN32 – DN100	1.660 – 4.500 42.4 – 114.3	8 205	36 915
4½ – 5	5.000 – 5.563 127.0 – 141.3	8 205	32 815
	6.000 152.4	10 255	30 765
6 DN150	6.625 168.3	10 255	28 715

If pipe is required that is shorter than the minimum length listed in Table 1, shorten the next-to-last piece so that the last piece is as long (or longer) than the minimum length specified.

EXAMPLE: A 20-foot, 4-inch/6.2-m length of 6-inch/DN150 diameter carbon steel pipe is required to finish a section and only 20-foot/6.1-m lengths are available. Instead of roll grooving a 20-foot/6.1-m length of carbon steel pipe and a 4-inch/102-mm length of carbon steel pipe, follow these steps:

1. Refer to Table 1 above, and note that for 6-inch/DN150 diameter carbon steel pipe, the minimum length that can be roll grooved is 10 inches/255 mm.

2. Roll groove a 19-foot, 6-inch/5.9-m length of pipe and a 10-inch/255-mm length of pipe. Refer to the "Long Pipe/Tubing Lengths" section.

LONG PIPE/TUBING LENGTHS

When roll grooving pipe that exceeds the maximum length shown in Table 1, a roller-type pipe stand shall be used. The pipe stand shall be capable of handling the weight of the pipe, while allowing the pipe to rotate freely.

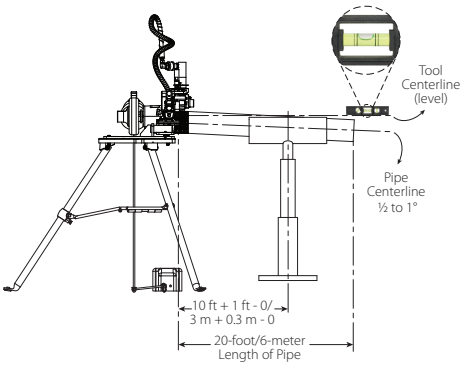


FIGURE 1: SUPPORT OF PIPE

1. Verify that the tool is level. Refer to the "Tool Setup" section for leveling requirements. Set the pipe stand height to produce a ½ to 1° pitch on the pipe away from the tool (refer to Figure 1). This will promote tracking and reduce pipe-end flare.

2. Keep pipe straight and square to the lower roll flange. The pipe may be adjusted up to ½° off-center if the initial setup is not providing sufficient tracking (refer to Figure 2). When flare is excessive, right-to-left tracking shall be kept to a minimum.

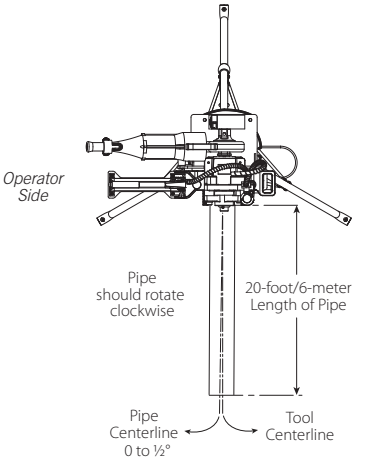
3. Installation of couplings on pipe that exceeds the maximum allowable flare may prevent pad-to-pad closure of the housings and may cause damage to the coupling gasket. Refer to page 37 for details.

4. If the tool is properly set up in a level position, but the back end of the pipe is higher than the end being grooved, the pipe may not track. As a result, excessive flare may occur on the pipe end. Refer to the "Tool Setup" section and to Figures 1 and 2 for tool setup and pipe positioning requirements.

5. Position the pipe stand at a distance slightly beyond half the pipe length from the tool. Refer to Figure 1.

6. Position the pipe stand approximately 0 to ½° to the left for the tracking angle. Refer to Figure 2.

Hydraulic Hand Pump Mounted on Left Side of Tool



Hydraulic Hand Pump Mounted on Right Side of Tool

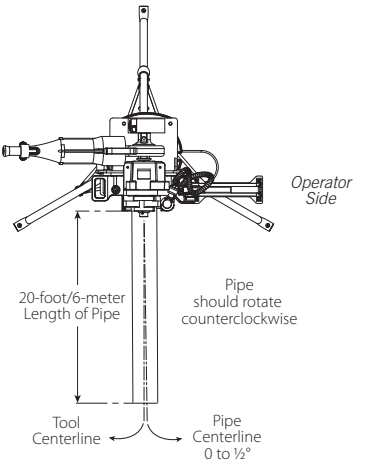


FIGURE 2: TRACKING ANGLE

GROOVING OPERATION

⚠ DANGER

- **To reduce the risk of electric shock, check the electrical source for proper grounding.**
- **Before operating the tool, review the "Operator Safety Instructions" section of this manual.**

Failure to follow these instructions could result in death or serious personal injury.

⚠ CAUTION

- **This tool shall be used ONLY for grooving pipe/tubing with specifications that fall within the designated parameters.**
- **Verify that the upper and lower grooving rolls are a matched set.**

Failure to follow these instructions could damage the tool and cause product failure, resulting in property damage or personal injury.

NOTICE

- **Pipe coatings, particularly galvanization, can become impacted in the knurling of the lower roll and cause the pipe to slip during the grooving process.**
- **It may become necessary to clean the lower roll with a wire brush periodically. Pay particular attention to any buildup during the grooving process that may impact the ability to effectively clean the knurling.**

1. Before grooving, verify that all instructions in the previous sections of this manual have been followed.
2. Plug the power drive cord into the safety foot switch, as shown. Plug the safety foot switch cord into a grounded electrical outlet. Refer to the power drive manufacturer's operating manual for additional information.

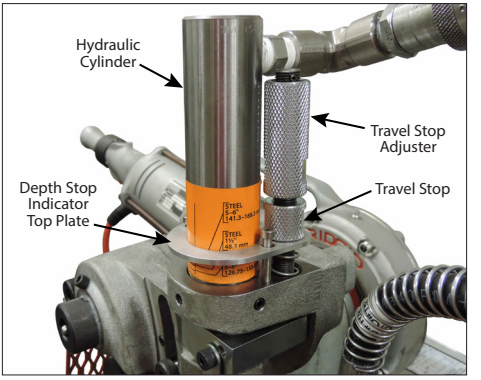
⚠ WARNING

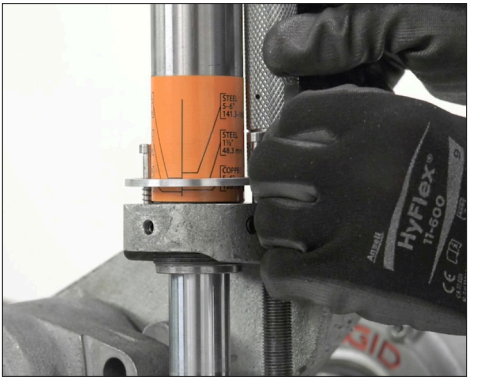
- **DO NOT operate the power drive without a safety foot switch. If the tool does not contain a safety foot switch, contact Victaulic.**

Operating the tool without a safety foot switch could result in serious personal injury.

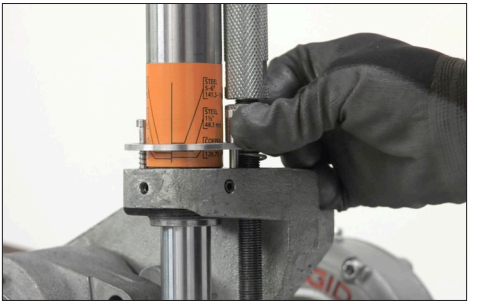
3. Depress the safety foot switch. Verify that the lower roll rotates away from the operator when viewed from the top of the tool. If the lower roll rotates toward the operator, see the appropriate power drive section for instructions to reverse rotation. Remove foot from the safety foot switch.

4. Rotate the hydraulic hand pump valve **counterclockwise** to open the valve and raise the upper roll to provide clearance for pipe insertion.



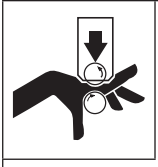


5. Back off the groove diameter stop by loosening the travel stop adjuster.



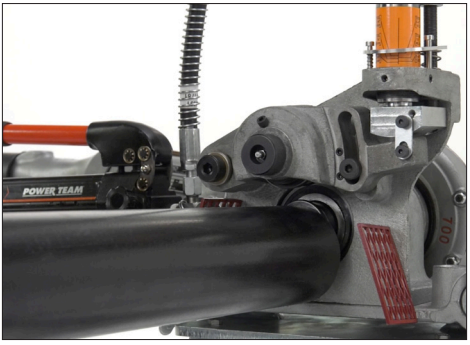
6. Turn the travel stop **counterclockwise** several turns.

⚠ WARNING

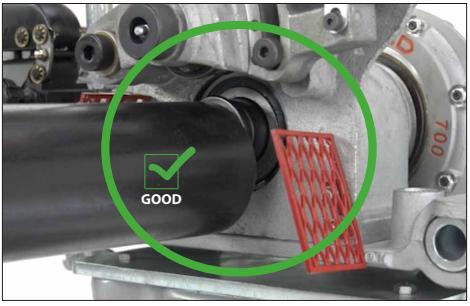


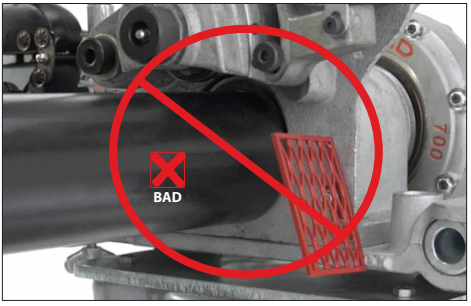
Grooving rolls can crush or cut fingers and hands.

- **Before making any tool adjustments, always disconnect the power cord from the electrical source.**
- **Loading and unloading pipe will place your hands close to the rollers. Keep hands away from the grooving rolls during operation.**
- **Never reach inside the pipe end or across the tool during operation.**
- **Always groove pipe with rotation away from the operator.**
- **Never groove pipe that is shorter than the recommended lengths listed in this manual.**
- **Never wear loose clothing, loose gloves, or anything that can become entangled in moving parts.**



7. Insert a length of pipe that is the correct size and thickness onto the lower roll.



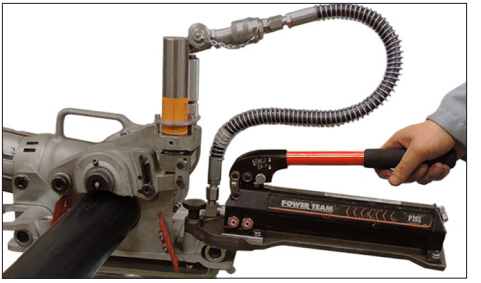


8. Verify that the pipe end contacts the lower-roll backstop flange completely, but does not cover the flange.

NOTICE

- **Using the tool with the pipe covering the flange will damage the tool. Verify that the pipe is positioned correctly before starting the grooving process.**

9. Rotate the hydraulic hand pump valve **clockwise** to close the valve.

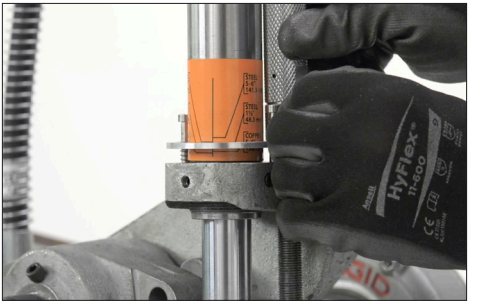


10a. While supporting the pipe, pump the handle of the hydraulic hand pump to place the upper roll into light contact with the pipe.

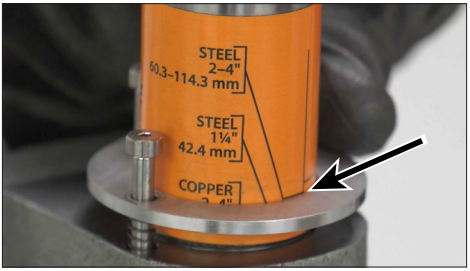
10b. Remove hands from the pipe. For long pipe lengths supported with a pipe stand, verify that the pipe is pitched and positioned properly. Refer to the “Long Pipe/Tubing Lengths” section.

NOTICE

- **The groove diameter stop shall be adjusted for changes in pipe size or wall thickness.**
- **The groove diameter is identified as the “C” dimension. Refer to page 37 for details.**
- **To perform the following adjustments, use several scrap sections of pipe that are the proper material, diameter, and thickness. Verify that the scrap sections meet the length requirements listed in Table 1.**

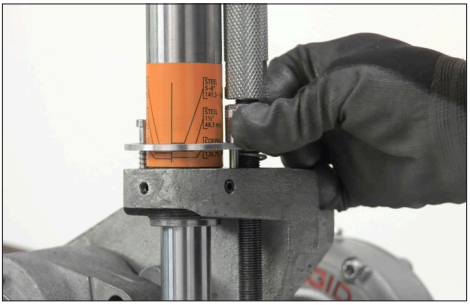


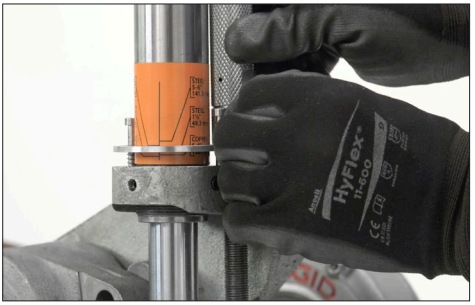
11. Loosen the travel stop adjuster.



12. Check the depth reference decal for the pipe size and material to be grooved. Find the horizontal line that corresponds to that pipe size and material.

To ensure the correct starting position, the upper edge of the depth stop indicator top plate shall be adjusted to meet that horizontal line.



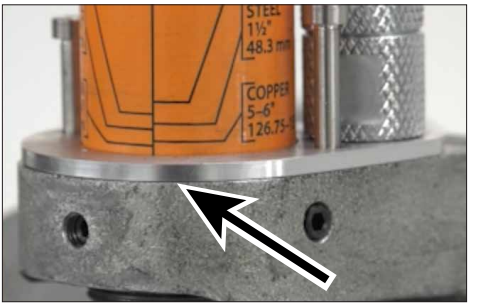


13. Turn the travel stop to adjust the height of the depth stop indicator top plate.

14. When the depth stop indicator top plate is properly aligned, tighten the travel stop adjuster to lock in the setting.

15. Depress and hold down the safety-foot-switch pedal.

16. As the pipe rotates, begin the grooving process by pumping the handle of the hydraulic hand pump at a slow, steady rate. Verify that the pipe remains against the lower-roll backstop flange. If the pipe does not remain against the lower-roll backstop flange, remove foot from the safety foot switch and re-position the pipe.



17. Continue the grooving process until the depth stop indicator top plate makes firm contact with the top edge of the tool head assembly.

18. Without pumping the hand pump, continue to rotate the pipe for one to three revolutions to ensure groove completion.

19. Remove foot from the safety foot switch.

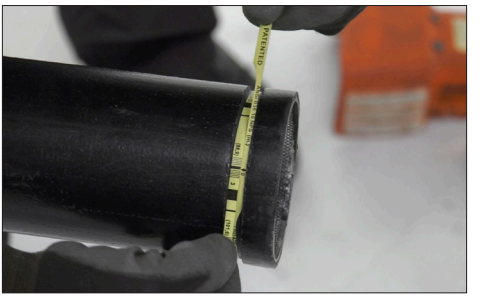
⚠ WARNING

- **DO NOT place hands inside the pipe end or in the area of the grooving rolls while the pipe is still rotating.**

Failure to follow this instruction could result in serious personal injury.

20. If a pipe stand is not being used, manually support the pipe during removal to prevent it from falling as it releases from the tool.

21. Rotate the hydraulic hand pump valve **counterclockwise** to open the valve and release the pipe from the tool.



22. After the pipe is grooved and removed from the tool, carefully check the groove diameter (“C” dimension). Refer to page 37 for details. A pipe diameter tape, supplied with the tool, is the best method for checking the “C” dimension. A vernier caliper or narrow-land micrometer can also be used to check this dimension at two locations (90° apart) around the groove. The average reading shall be within the required groove diameter specification.

⚠ CAUTION

- **The "C" dimension (groove diameter) and maximum allowable flare shall conform to Victaulic specifications to ensure proper joint performance.**
- **The "C" dimension (groove diameter) shall be within specification for the diameter and wall thickness of pipe. The groove diameter shall be checked and adjusted, as necessary, to ensure that grooves remain within specification.**

Failure to follow these instructions could cause joint failure, resulting in personal injury and/or property damage.

23. If the groove diameter ("C" dimension) is not within Victaulic specifications, the diameter stop shall be readjusted. Return to steps 9 through 14 and make the following changes:

a. To DECREASE the groove diameter (increase groove depth), readjust the upper edge of the depth stop indicator top plate so that it is slightly above the horizontal line previously used.

b. To INCREASE the groove diameter (decrease groove depth), readjust the upper edge of the depth stop indicator top plate so that it is slightly below the horizontal line previously used.

NOTE: A quarter turn either way of the travel stop will change the groove diameter by 0.025 inch/0.635 mm.

24. Prepare another trial groove, and re-check the groove diameter ("C" dimension), as described in step 22. Repeat these steps, as necessary, until the groove diameter is within specification.

ROLL CHANGING

⚠ DANGER

- **Before making any tool adjustments, disconnect the power cord from the electrical source.**

Accidental startup of the tool could result in death or serious personal injury.

The VE206 is designed with rolls to accommodate several pipe sizes, which eliminates the need for frequent roll changes. However, different pipe materials may require different rolls. For proper roll selection, refer to page 36.

LOWER ROLL/MAIN SHAFT REMOVAL

When preparing to groove stainless steel pipe, copper tubing, or pipe to “ES” specifications, the lower roll/main shaft for carbon steel pipe shall be removed.

When preparing to groove copper tubing or pipe to “ES” specifications, the carbon steel upper roll shall also be removed (refer to the “Upper Roll Removal” and “Upper Roll Installation” sections). The upper roll shall be installed prior to installation of the lower roll/main shaft in the tool body.

1. Disconnect and lock out power to the tool.

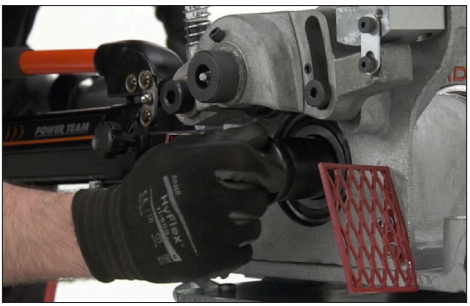
2. Raise the upper roll arm to its maximum position by rotating the hydraulic hand pump valve **counterclockwise** to open the valve.

3. Using a 5⁄16-inch socket, loosen and remove the hex bolt and lock washer at the rear of the shaft.

⚠ WARNING

- **DO NOT strike the lower roll/main shaft with a hammer or other blunt object.**

Striking the lower roll/main shaft can cause fragmentation, resulting in serious personal injury.



4. Pull the lower roll/main shaft out from the front of the tool head. Using a soft cloth, remove any debris and excess grease from the lower roll/main shaft.

5. Store the lower roll/main shaft in the provided tool bag to prevent damage.

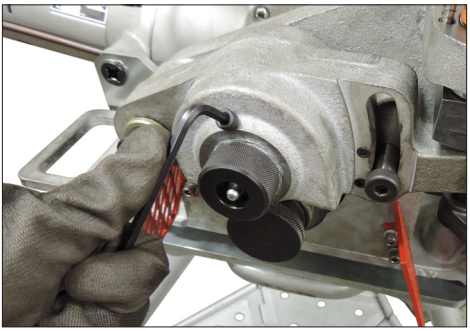
UPPER ROLL REMOVAL

The same upper roll is used for standard grooving of carbon steel pipe and stainless steel pipe.

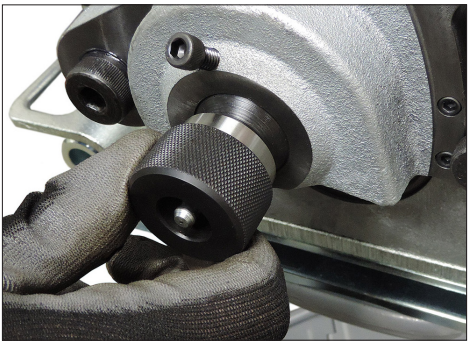
When preparing to groove copper tubing or pipe to "ES" specifications, the upper roll for carbon steel/ stainless steel pipe shall be removed and the appropriate upper roll shall be installed.

NOTICE

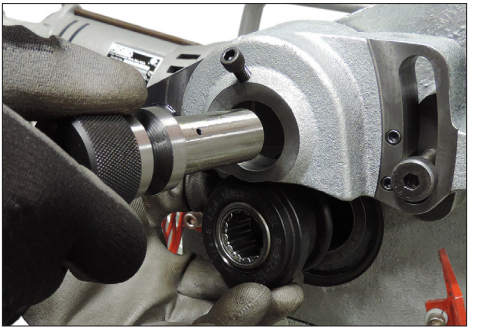
- **The lower roll/main shaft shall be removed prior to removal of the upper roll from the upper roll shaft/arm casting.**



1. Using a 3⁄16-inch hex key, loosen the set screw located on the top of the arm casting.



2. Prepare to support the upper roll while sliding the upper shaft out of the arm casting.

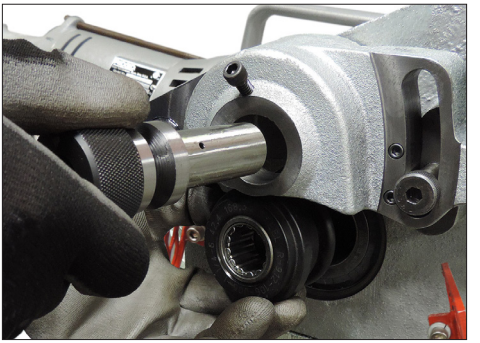


3. Remove the upper roll. Store the upper roll in the provided tool bag to prevent damage.

UPPER ROLL INSTALLATION

NOTICE

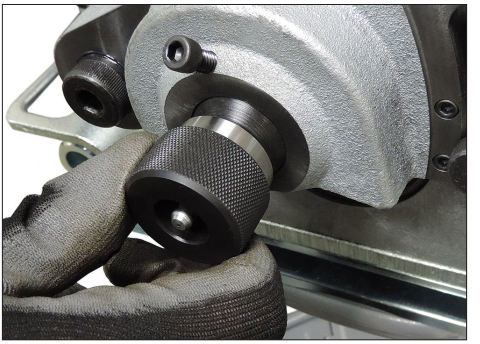
- **The upper roll shall be installed prior to installation of the lower roll/main shaft.**



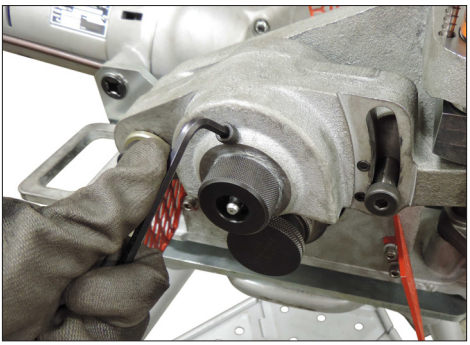
1. Select the proper upper roll for the pipe size and material to be grooved. Refer to page 36.

2. Position the upper roll in the pocket of the arm casting.

NOTE: The flange portion of the upper roll shall face toward the rear of the tool, as shown.



3. Insert the upper shaft into the arm casting and upper roll.



4. Using a 3⁄16-inch hex key, tighten the set screw to secure the upper shaft in position. Verify that the upper roll rotates freely.

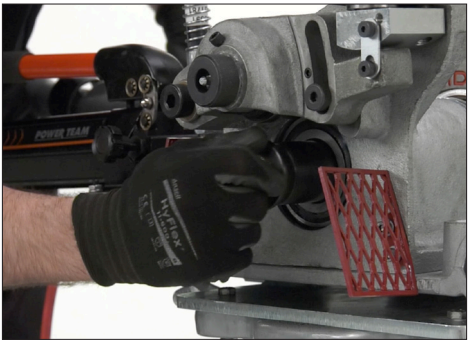
LOWER ROLL/MAIN SHAFT INSTALLATION

1. Disconnect and lock out power to the tool.

2. Select the proper lower roll/main shaft for the pipe size and material to be grooved. Refer to page 36.

NOTICE

- **Upper roll installation shall be completed before proceeding with lower roll/main shaft installation.**



3. Apply dry graphite spray to the lower roll/main shaft bore and main shaft.

4. Install the lower roll/main shaft into the tool head. While maintaining a grip on the knurled end (lower roll) of the main shaft, verify that the flats on the drive end of the main shaft align with the flats in the power drive adapter.

5. Using a 5⁄16-inch socket, install and tighten the hex bolt and lock washer at the rear of the shaft.

6. Rotate the hydraulic hand pump valve **clockwise** to close the valve.

7. Lower the arm casting by pumping the handle of the hydraulic hand pump. Verify that the upper roll aligns properly with the lower roll/main shaft.

MAINTENANCE

⚠ DANGER

- **Before performing any maintenance on the tool, disconnect the power cord from the electrical source.**

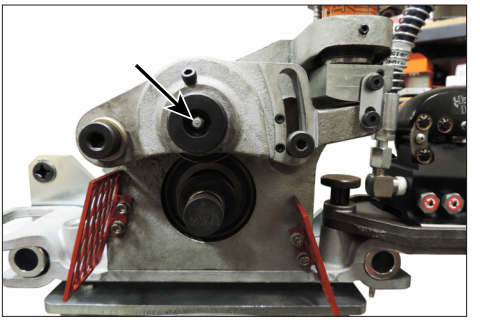
Failure to follow this instruction could result in death or serious personal injury.

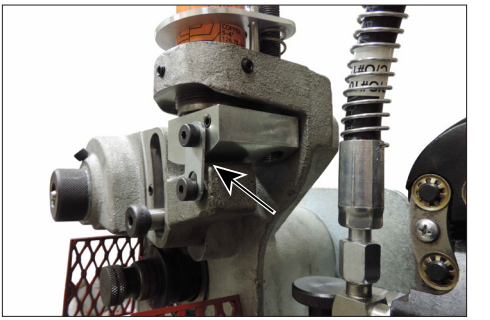
NOTICE

- **Pipe coatings, particularly galvanization, can become impacted in the knurling of the lower roll and cause the pipe to slip during the grooving process.**
- **It may become necessary to clean the lower roll with a wire brush periodically. Pay particular attention to any buildup during the grooving process that may impact the ability to effectively clean the knurling.**

This section provides information about keeping tools in proper operating condition. Replacement parts shall be ordered from Victaulic to ensure proper and safe operation of the tool.

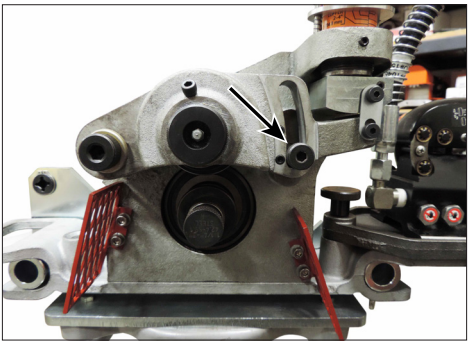
LUBRICATION

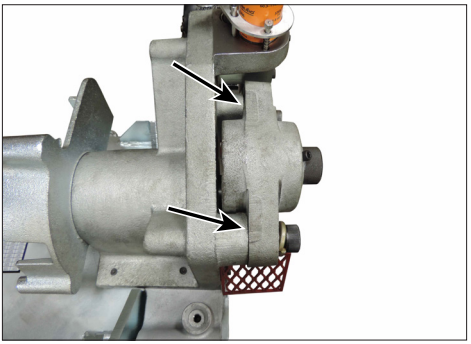




1. After every 8 hours of operation, apply grease to the grease fitting of the upper roll shaft.

2. Apply grease under the pivot block.





3. Apply grease to all locations where the roll arm slides against the tool body.

RECOMMENDED LUBRICANTS

BEARING AND SLIDE GREASE

(General Purpose EP Lithium Base Grease)

Manufacturer	Product
BP Amoco	Energrease LC-EP2
Gulf Oil Corp.	Gulfcrown Grease EP#2
Lubriplate	No. 630-2
Mobil Oil Corp.	Mobilux EP2
Pennzoil Products Co.	Pennlith EP 712 Lube
Shell Oil Co.	Alvania EP2
Sun Refining	Sun Prestige 742 EP
Texaco Inc.	Multifak EP2

HYDRAULIC OIL

(High Pressure, Anti-Wear/Anti-Foam Hydraulic Oil ISO Grade 32)

Manufacturer	Product
BP Amoco	Energol HLP-HM32
Gulf Oil Corp.	Harmony 32 AW
Kendall Refining Co.	Kenoil R&O AW-32
Lubriplate	HO-o
Mobil Oil Corp.	Mobil DTE 24
Pennzoil Products Co.	Pennzbell AW32
Shell Oil Co.	Tellus 32
Sun Refining	Survis 832
Texaco Inc	Rando

PARTS ORDERING INFORMATION

When ordering parts, the following information is required for Victaulic to process the order and send the correct part(s). Request the RP-VE206 Repair Parts List for detailed information. Parts can be ordered by calling 1-800-PICK VIC.

1. Tool Model Number – VE206
2. Tool Serial Number – The serial number is stamped onto the tool body
3. Quantity, Part Number, and 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

ACCESSORIES

VAPS112 VICTAULIC ADJUSTABLE PIPE STAND

The Victaulic VAPS112 is a portable, adjustable, roller-type pipe stand that contains four legs for additional stability. Ball transfer rollers, adjustable for 2 – 12-inch/DN50 – DN300 pipe, and the "V" rest for ¾ – 1 ½-inch/DN20 – DN40 pipe, accommodate linear and rotational movement. The turnstile design permits ease of grooving for both pipe ends. Contact Victaulic for details.

VAPS224 VICTAULIC ADJUSTABLE PIPE STAND

The Victaulic VAPS224 contains features that are similar to the VAPS112, but it is suitable for 2 – 24-inch/DN50 – DN600 pipe sizes. Contact Victaulic for details.

OPTIONAL ROLLS

The following optional rolls are available for purchase. Contact Victaulic for details.

- Lower Roll/Main Shaft for Grooving 1 ¼ – 6-inch/DN32 – DN150 Schedule 5S and 10S Stainless Steel Pipe (**NOTE:** The same upper roll is used for grooving carbon steel pipe and stainless steel pipe)
- Lower Roll/Main Shaft and Upper Roll for Grooving 2 – 6-inch ASTM Drawn Copper Tubing to CTS US Standard
- Lower Roll/Main Shaft and Upper Roll for 2 – 3-inch/DN50 – DN80 "ES" Grooves
- Lower Roll/Main Shaft and Upper Roll for 4 – 6-inch/DN100 – DN150 "ES" Grooves

TROUBLESHOOTING

PROBLEM	POSSIBLE CAUSE	SOLUTION
Pipe/tubing will not stay in grooving rolls.	Incorrect pipe/tubing positioning of long pipe/tubing length.	Refer to the "Long Pipe/Tubing Lengths" section.
	Lower roll/main shaft and pipe/tubing are not aligned properly with the grooving direction.	Flip over the trigger-lock switch on the power drive to depress the opposite trigger. Refer to the power drive manufacturer's operating and maintenance instructions for additional information.
Pipe/tubing stops rotating during grooving.	Rust or dirt buildup is present on the lower roll.	Remove rust or dirt accumulation from the lower roll with a stiff wire brush.
	Rust or dirt is excessively heavy inside the pipe/tubing end.	Remove heavy rust and dirt from inside the pipe/tubing end.
	Worn lower roll.	Inspect the lower roll for worn knurls. Replace the lower roll/main shaft if excessive wear is present.
	The circuit breaker/GFI has tripped or a fuse has blown out on the electrical circuit that supplies the power drive.	Test/reset the jobsite GFI/breaker, or replace the fuse.
	The trigger-lock switch clamp is loose.	Tighten the trigger-lock switch thumb screw.
While grooving, loud squeaks echo through the pipe/tubing.	Incorrect pipe/tubing support positioning of long pipe/tubing length. Pipe/tubing is "over-tracking."	Move the pipe support to the right. Refer to the "Long Pipe/Tubing Lengths" section.
	Pipe/tubing end is not cut square.	Cut the pipe/tubing end squarely.
	Pipe/tubing is rubbing excessively on the lower-roll backstop flange.	Remove the pipe/tubing from the tool, and apply a light coating of saw blade wax or water-soluble non-hydrocarbon lubricant to the face of the lower-roll backstop flange, as needed.
During grooving, loud thumps or bangs occur approximately once every revolution of the pipe/tubing.	Pipe/tubing has a pronounced weld seam.	Grind the raised welds flush with the interior and exterior pipe/tubing surfaces 2 inches/51 mm back from the pipe/tubing end.
Pipe/tubing flare is excessive.	Pipe/tubing support adjusted too high for long pipe/tubing length.	Refer to the "Long Pipe/Tubing Lengths" section.
	Tool is tilted forward (out of level) while grooving long pipe/tubing length.	Refer to the "Tool Setup" section.
	Incorrect pipe/tubing support positioning.	Move the pipe support to the right. Refer to the "Long Pipe/Tubing Lengths" section.
The tool will not groove the pipe/tubing.	Pipe/tubing is beyond the wall thickness capacity of the tool, or the pipe/tubing material is too hard.	Refer to page 36.
Pipe/tubing grooves do not conform with Victaulic specifications.	Groove diameter stop is not adjusted correctly.	Refer to the "Groove Diameter Stop Adjustment" section.
	Pipe/tubing is beyond the wall thickness capacity of the tool, or the pipe/tubing material is too hard.	Refer to page 36.
The "A" gasket seat or "B" groove width dimensions do not conform with Victaulic specifications.	Incorrect upper roll, lower roll, or both installed on the tool.	Install the correct rolls. Refer to page 36.

In the event of tool malfunction outside the scope of the troubleshooting section, contact Victaulic for assistance.

ORIGINAL GROOVE SYSTEM (OGS) AND "ES" ROLL PART NUMBERS

STEEL AND STAINLESS STEEL PIPE – COLOR-CODED BLACK

Pipe Size inches or mm	OGS Roll Part Numbers	"ES" Roll Part Numbers
1¼ - 1 ½ 30 – 40	Lower Roll R912106L03 Upper Roll R912106UA6	—
2 - 3 50 – 80		Lower Roll RZ02106L03 Upper Roll RZ02106UA3
4 – 6 100 – 150	Lower Roll R904106L06 Upper Roll R912106UA6	Lower Roll RZ04106L06 Upper Roll RZ04106UA6

ORIGINAL GROOVE SYSTEM (OGS) ROLL PART NUMBERS

SCHEDULES 5S AND 10S STAINLESS STEEL PIPE – COLOR-CODED SILVER

Pipe Size inches or mm	Schedule 5S and Schedule 10S RX Roll Part Numbers
1¼ - 6 30 – 150	Lower Roll RX12106L06 Upper Roll R912106UA6

CTS US STANDARD – ROLL PART NUMBERS

ASTM-DRAWN COPPER TUBING – COLOR-CODED COPPER

Pipe Size inches	Copper Roll Part Numbers
2-6	Lower Roll RR02106L06 Upper Roll RR02106UA6

OGS GROOVE SPECIFICATIONS

For the most up-to-date information regarding OGS roll groove specifications, reference the current revision of Victaulic publication 25.01, which can be viewed/downloaded by scanning the mobile QR code link to the right, or by clicking on this desktop link: https://www.victaulic.com/assets/uploads/literature/25.01.pdf

ENDSEAL “ES” GROOVE SPECIFICATIONS

For the most up-to-date information regarding EndSeal “ES” roll groove specifications, reference the current revision of Victaulic publication 25.02, which can be viewed/downloaded by scanning the mobile QR code link to the right, or by clicking on this desktop link: https://www.victaulic.com/assets/uploads/literature/25.02.pdf

COPPER TUBING GROOVE SPECIFICATIONS

For the most up-to-date information regarding copper tubing roll groove specifications, reference the current revision of Victaulic publication 25.06, which can be viewed/downloaded by scanning the mobile QR code link to the right, or by clicking on this desktop link: https://www.victaulic.com/assets/uploads/literature/25.06.pdf

ADDITIONAL RESOURCES

For additional information on 24-inch/DN600 and smaller Victaulic mechanical piping products for carbon steel, stainless steel, aluminum, and CPVC/PVC pipe, reference the current revision of the I-100 Field Installation Handbook, which can be viewed/downloaded by scanning the mobile QR code link to the right, or by clicking on this desktop link: https://www.victaulic.com/assets/uploads/literature/I-100.pdf

For additional information on Victaulic Copper Connection Products, reference the current revision of the I-600 Field Installation Handbook, which can be viewed/downloaded by scanning the mobile QR code link to the right, or by clicking on this desktop link: https://www.victaulic.com/assets/uploads/literature/I-600.pdf

EC DECLARATION OF INCORPORATION

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 Model:	VE206
Serial No. :	Refer to Machinery Nameplate
Product Description:	Portable Pipe Roll Grooving Tool
Conformity Assessment:	2006/42/EC, Annex I
Technical Documentation:	The relevant technical documentation prepared in accordance with Annex VII (B) of the Machinery Directive 2006/42/EC, will be made available upon request to the governing authorities.
Compatible Power Drives:	When installed with any of the following power drive units, each having an appropriate EC Declaration of Conformity in accordance with Annex II (A) of the Directive 2006/42/EC, the VE-206 may be commissioned for its full intended purpose:

REMS Amigo 2 Compact	Ridgid* 300	Ridgid* 700

Authorized Representative:

Victaulic Company
c/o Victaulic Europe BV
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: February 7, 2024

MD_DoI_RGT_002_020724_en

UK DECLARATION OF INCORPORATION

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: VE206

Serial No. : Refer to Machinery Nameplate

Product Description: Portable Pipe Roll Grooving Tool

Conformity Assessment: 2008 No. 1597, Annex I

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.

Compatible Power Drives: When installed with any of the following power drive units, each having an appropriate UK Declaration of Conformity in accordance with The Supply of Machinery (Safety) Regulations 2008 No. 1597, the VE206 may be commissioned for its full intended purpose:

REMS Amigo 2 Compact	Ridgid 700	Ridgid 300

Authorized Representative:

Victaulic Company
c/o Victaulic Europe BVBA
Units B1 & B2
Cockerell Close off Gunnels
Wood Road
Stevenage, Hertfordshire
SG1 2NB, United Kingdom

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: May 17, 2021

VE206 Pipe/Tubing Roll Grooving Tool

TM-VE206 7917 REV F UPDATED 04/2024 RM00206000