



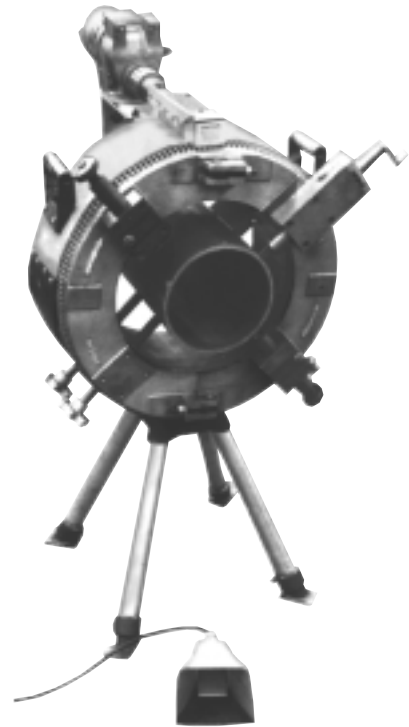
VG-412 Orbital Pipe Machining Tool for Cutting/Grooving 4 - 12" Ductile Iron Pipe

The Victaulic VG-412 Orbital Pipe Machining Tool is a complete, modular pipe end preparation system. The tool quickly, accurately and economically cuts and grooves 4" through 12" ductile iron pipe to meet AWWA and other industry specifications for mechanical couplings. The Victaulic VG-412 features uniform groove depth machining heads which assure repeated accuracy.

This versatile tool can be located at any point along the pipe length, even on continuous pipelines, to cut and groove in a single set up. Ruggedly engineered for reliability and minimum maintenance, the Victaulic VG-412 is designed for performance under many adverse conditions encountered in actual job operations. The tool offers manual backup capabilities. All machining surfaces are clearly visible and accessible to permit inspection. Blade setting and replacement is quickly and easily accomplished.

Tool Features

- 1. Pinion Drive** – Consists of a pinion gear mounted on a ball bearing supported pinion shaft which has a 1" hex male end to accept power or manual drive sources. This drive rotates the gear plate. Power drive is supplied (120 volt, 11.5 amp).
- 2. Hinged Frame** – Centers and supports the rotating gear plate which carries the various cutting heads. Use in closed position over an accessible pipe end or hinged open for installation at any point on the pipe.
- 3. Gear Plate** – Carries cut-off and/or grooving heads around the circumference of the pipe in order to perform required machining operations. The gear plate is in two halves so that it can be assembled over the frame mounted rollers.
- 4. Cut-off Head** – Carries a cut-off blade(s) which is automatically fed into the cut a small amount with each revolution of the gear plate. The automatic feed is operated as an actuator bar contacts the blade feed star wheel. A manually operated crank permits rapid in-out feed. Ductile iron pipe requires the use of only one cut-off head.
- 5. Groove Head** – Two 180° opposed groove heads are required for all grooving operations. Use of only one head can result in severe chatter and a rough finish.
- 6. Riser Blocks** – Centers the tool on the pipe as closely as pipe diameter and ovality tolerance will permit. Riser blocks are clearly identified by diameter and type of pipe.
- 7. Clamp Screws** – Secures the tool to the pipe during machining operations.



CAUTION		
Before setting up and operating Victaulic pipe preparation tools, read and understand the Operator's Instruction Manual supplied with each tool. Additional copies are available at no charge from Victaulic Tool Company.		
Learn the operation, application and potential hazards peculiar to this tool.		
Failure to do so could result in personal injury, property damage, improper installation, joint leakage or joint failure.		