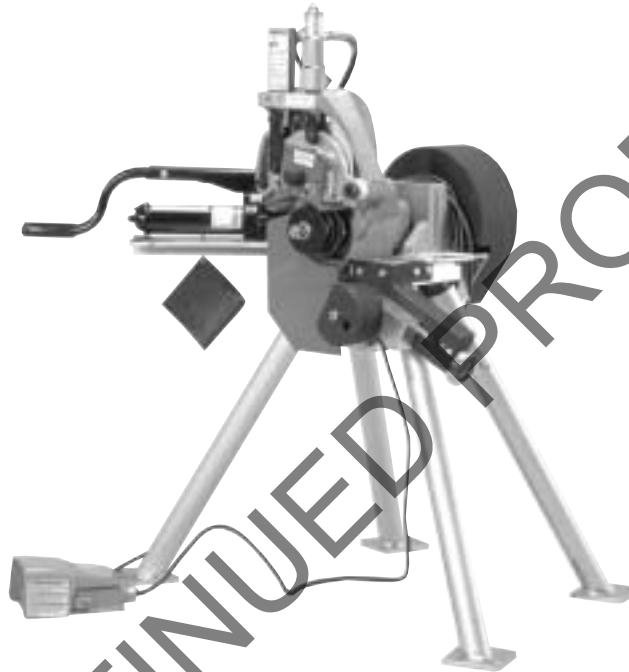


# RP-276FSD

## REPAIR PARTS FOR VE276FSD Roll Grooving Tool



### PARTS ORDERING INFORMATION

When ordering parts the following information is necessary for the Victaulic Tool Company to promptly process the order and send the correct part(s).

1. Tool Model Number. VE276FSD
2. Tool Serial Number.  
The Serial Number can be found on the side of the tool.
3. Quantity, Item Number, Part Number, Description.  
Example: (1), 75, R-105-276-MCH, VE276FSD Main Shaft
4. Where to send the part(s).  
Company Name. Address
5. To whose attention to send the part(s).  
Person's Name.
6. Purchase Order Number

Parts may be ordered from the nearest Victaulic Sales Office.

#### VICTAULIC<sup>®</sup> IS AN ISO 9001 CERTIFIED COMPANY

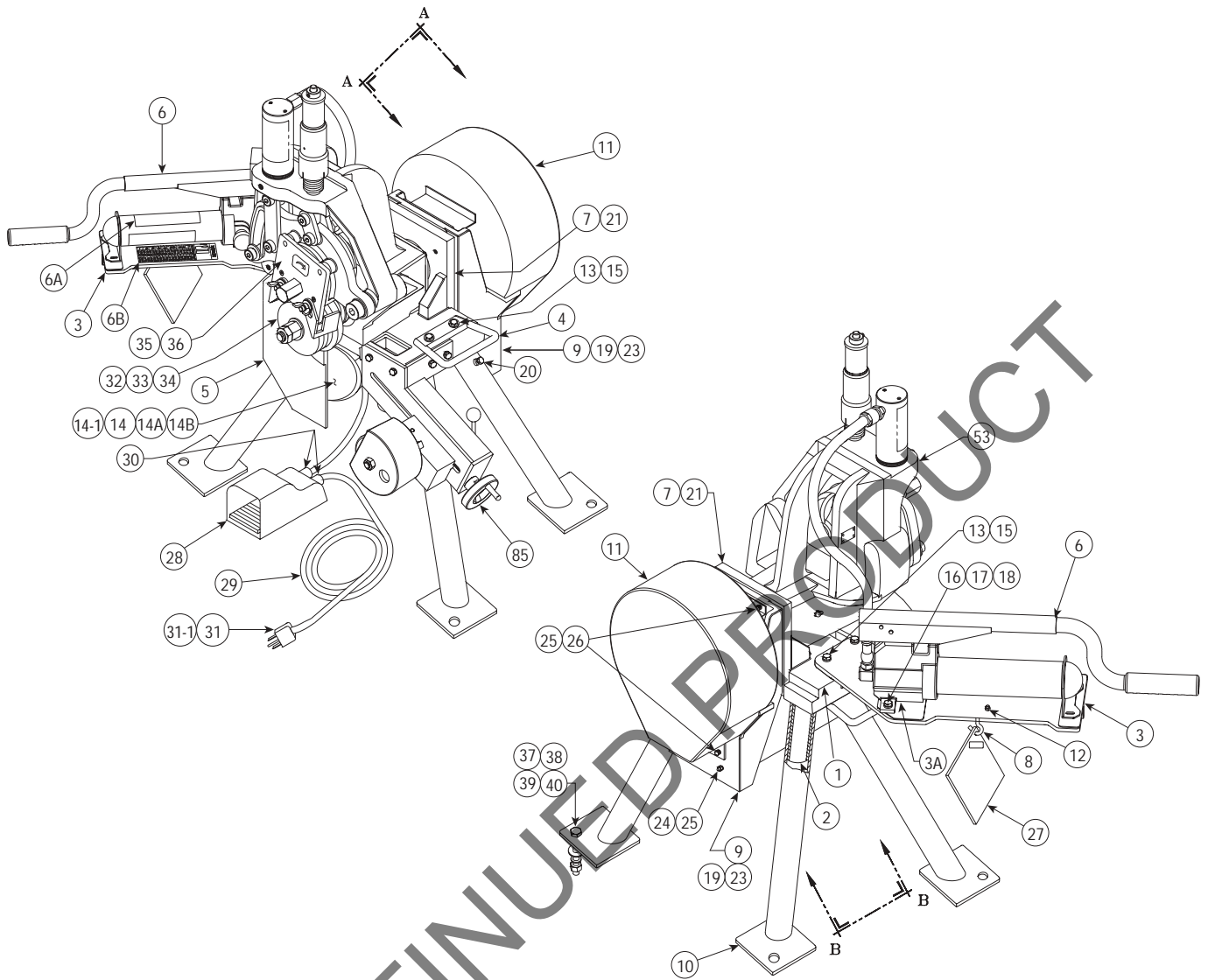
**Victaulic Company of America**  
Phone: 1-800-PICK-VIC (1-800-742-5842)  
Fax: 610-250-8817  
e-mail: pickvic@victaulic.com

**Victaulic Company of Canada**  
Phone: 416-675-5575  
Fax: 416-675-5565  
e-mail: viccanada@victaulic.com

**Victaulic Europe**  
Phone: 32-9-381-1500  
Fax: 32-9-380-4438  
e-mail: viceuro@victaulic.be

**Victaulic America Latina**  
Phone: 610-559-3300  
Fax: 610-559-3608  
e-mail: vical@victaulic.com

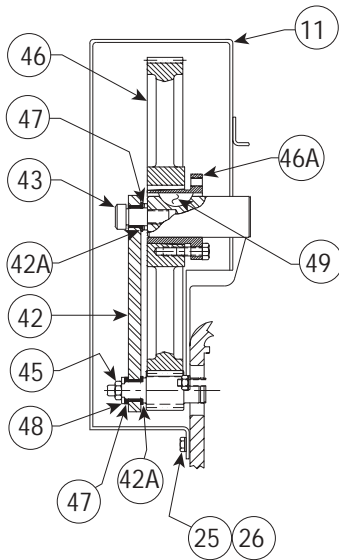
**Victaulic Asia Pacific**  
Phone: 65-6235-3035  
Fax: 65-6235-0535  
e-mail: vicap@victaulic.com



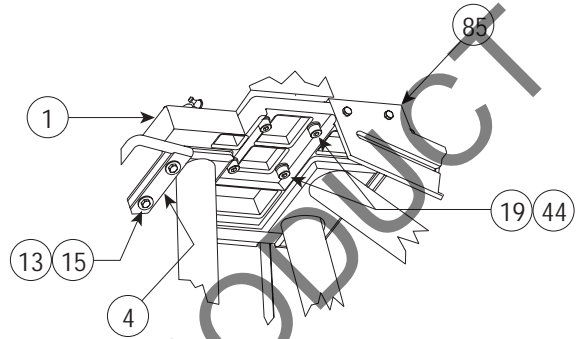
Item #	Part #	Qty.	Description
01	R-001-276-MCH	1	Table
02	R-003-416-PLT	4	Upper Leg
03	R-004-272-PLT	1	Pump Bracket **
03A	R-009-424-LAB	1	"C" Diameter Label for Standard Pipe
04	R-005-272-PLT	2	Base Handle
05	R-006-276-PNT	1	Guard
06	R-201-261-0FS	1	Hydraulic Pump Assembly **
06A	R-062-260-0FS	1	Hydraulic Pump Label
06B	R-031-272-LAB	1	Instructions Warning Label
07	R-004-276-MCH	1	Vertical Plate
08	N-S40-040-000	1	1/4" X 2.62 Lg. Hook Bolt with 1/4 - 20 UNC Nut, Pltd.
09	R-012-417-MAC	1	Motor Mounting Bracket
10	R-013-417-PLT	4	Lower Leg
11	R-015-417-PNT	1	Gear Guard
12	N-N01-040-000	1	1/4 - 20 UNC Hex Nut, Pltd.
13	N-S01-060-100	6	3/8 - 16 UNC X 1.00 Lg. Hex Head Screw, Pltd.
14	R-019-416-FSD	1	Gearmotor ** (110V)
14-1	R-19A-416-FSD	1	Gearmotor (220V)
14A	R-020-417-FSD	1	Gearmotor Filter
14B	R-022-417-LAB	1	Gearmotor Label
15	N-W01-060-000	6	3/8" Flat Washer, Pltd.
16	N-S01-050-108	2	5/16 - 18 UNC X 1.50 Lg. Hex Head Screw, Pltd.
17	N-W01-050-000	4	5/16" Flat Washer, Pltd.
18	N-N01-050-000	2	5/16 - 18 UNC Hex Nut, Pltd.
19	N-W03-060-000	8	3/8" Lock Washer, Pltd.

Item #	Part #	Qty.	Description
20	N-S01-050-012	4	5/16 - 18 UNC X 0.75 Lg. Hex Head Screw, Grade 5, Pltd.
21	N-S03-060-100	6	3/8 - 16 UNC X 1.00 Lg. Socket Hd. Cap Screw, Blk. Ox.
22	N-M02-000-001	-	Lubriplate Grease (as required)
23	N-S01-060-104	4	3/8 - 16 UNC X 1.25 Lg. Hex Hd. Screw, Pltd.
24	N-N02-040-000	4	1/4 - 28 UNF Hex Nut, Pltd.
25	N-W03-040-000	8	1/4" Lock Washer, Pltd.
26	N-S01-040-010	4	1/4 - 20 UNC X 0.63 Lg. Hex Hd. Screw, Pltd.
27	R-039-272-0FS	1	Guard Setting Pad Assembly
28	N-E03-000-002	1	Footswitch
29	N-E04-000-001	1	#14/3 Line Cord X 20 Ft. Lg.
30	N-E06-000-001	2	Cord Grip Connector
31	N-E08-000-003	1	Plug (110V)
31-1	N-E08-000-004	1	Plug (220V)
32	R-902-272-L03	1	2 - 3 1/2" Lower Roll for Steel Pipe
33	R-904-272-L06	1	4 - 6" Lower Roll for Steel Pipe
34	R-908-272-L12	1	8 - 12" Lower Roll for Steel Pipe
35	R-9A2-268-U06	1	Upper Roll Cover/Guard Assy. for 2 - 6" Steel Pipe
36	R-9A8-268-U12	1	Upper Roll Cover/Guard Assy. for 8 - 12" Steel Pipe
37	N-S01-080-204	4	1/2 - 13UNC X 2.25 Lg. Hex Head Cap Screw, Pltd.
38	N-W01-080-000	4	1/2" SAE Flat Washer, Pltd.
39	N-W03-080-000	4	1/2" Lock Washer, Pltd.
40	N-N01-080-000	4	1/2 - 13 UNC Hex Nut, Pltd.
41	R-512-260-VE0	1	Lower Roll Removal Tool (Not Shown)

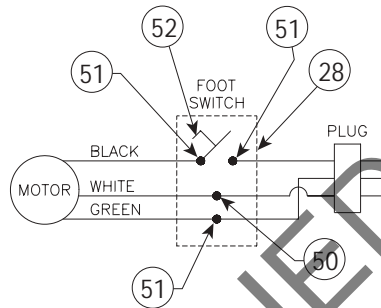
\*\* Indicates additional items required and/or recommended when ordering.



VIEW A-A



VIEW B-B

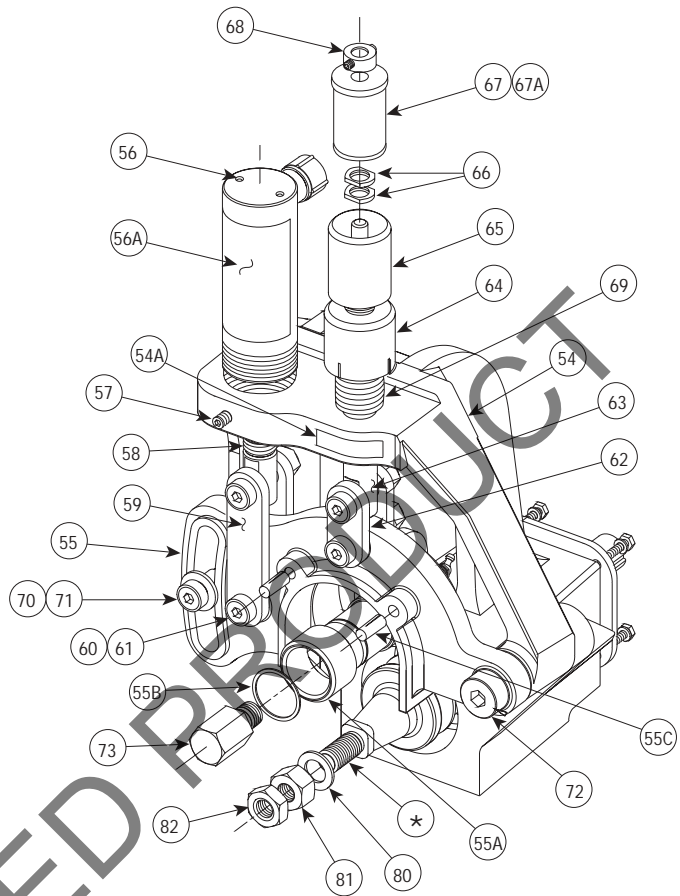
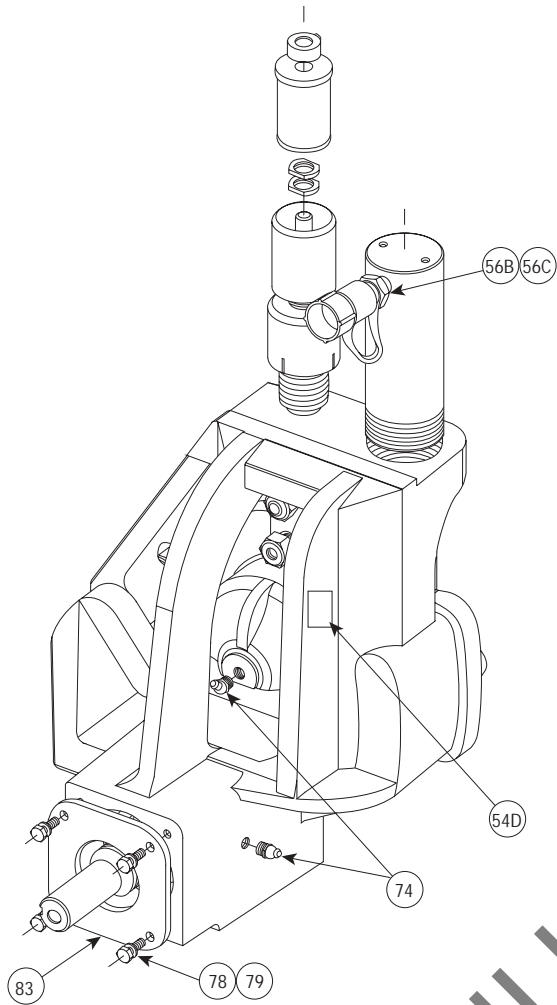


ELECTRICAL SCHEMATIC

Item #	Part #	Qty.	Description
42	R-014-417-PLT	1	Tie Bar **
42A	N-B21-062-001	2	Flange Bushing
43	N-S05-100-012	1	.625 X .75 Lg. Shoulder Bolt, Blk. Ox.
44	N-S03-060-200	4	3/8 - 16 UNC X 2.00 Lg. Socket Hd. Cap Screw, Blk. Ox.
45	N-N05-060-000	1	3/8 - 16 UNC Thin Elastic Locknut, Pltd.
46	R-037-417-MAC	1	Spur Gear **
46A	N-M38-000-001	1	P1 Bushing with 0.375 Wide Keyway

Item #	Part #	Qty.	Description
47	N-B22-062-001	2	Thrust Bushing
48	N-B40-048-001	1	Tongued Washer
49	N-K01-121-000	1	#1210 Woodruff Key
50	N-E07-000-001	1	Wire Nut, #72 B
51	N-E05-000-018	4	Fork Wire Terminal, #TRB-14
52	N-E02-000-027	1	Micro Switch

\*\* Indicates additional items required and/or recommended when ordering.

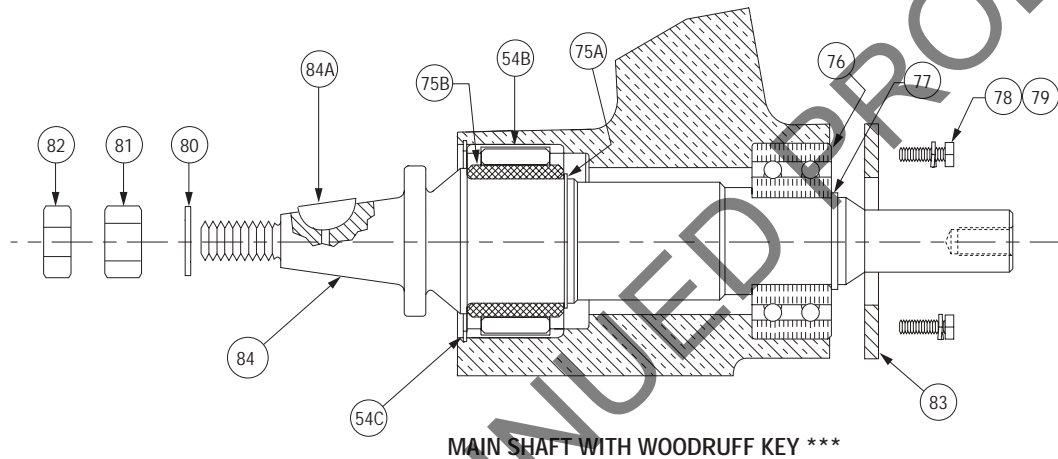
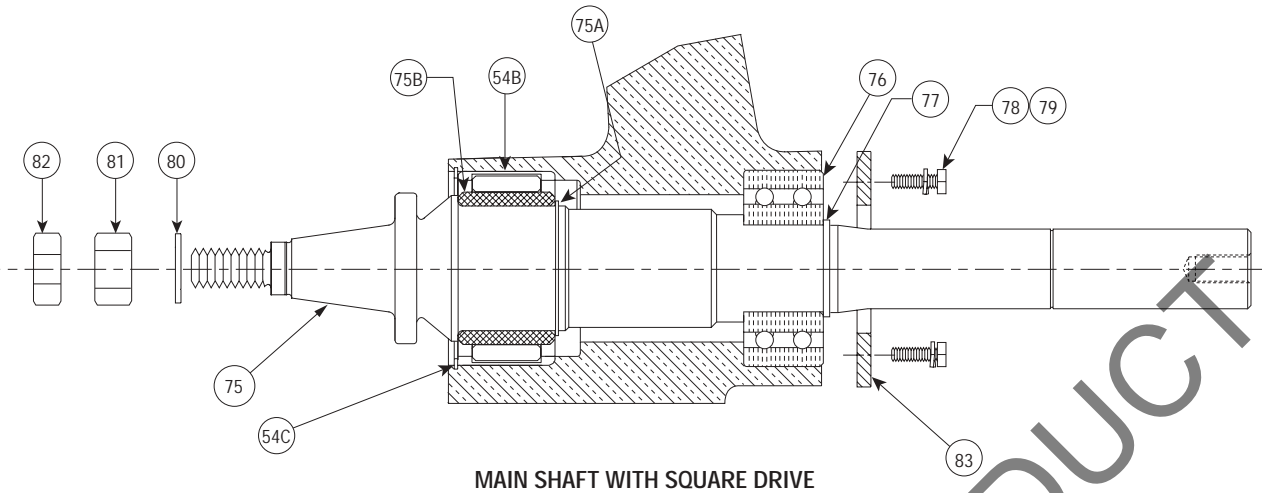


\*SEE PAGE 4 FOR MAIN SHAFT CONFIGURATIONS

Item #	Part #	Qty.	Description
53	R-100-276-FSD	1	Tool Head Assembly
54	R-002-272-OFS	1	Body **
54A	R-034-272-LAB	1	Depth Stop Adjustment Direction Label
54B	N-B02-275-002	1	Needle Bearing
54C	N-T03-000-015	1	Snap Ring
54D	R-069-272-LAB	1	Name Plate
55	R-003-268-MCH	1	Arm **
55A	N-B04-156-002	1	Inner Race
55B	N-T03-000-017	1	Snap Ring
55C	N-P11-006-100	2	Groove Pin
56	N-H01-000-008	1	Hydraulic Cylinder **
56A	R-007-276-LBL	1	Roll Warning Label
56B	N-H50-000-018	1	Ram Half Coupler
56C	N-H50-000-015	1	Dust Cap
57	N-S80-000-008	1	3/8 - 16 UNC x .50 Lg. Brass Tip Set Screw
58	R-012-272-OFS	1	Cylinder Adapter
59	R-013-272-OFS	2	Link - Cylinder to Arm
60	N-S05-100-110	4	.625 X 1.63 Lg. Hex Socket Head Shoulder Screw per ANSI/ASME B18.3, Blk. Ox.

Item #	Part #	Qty.	Description
61	N-N08-080-000	4	1/2 - 13 UNC Heavy Hex Nylon Insert Locking Nut
62	R-116-268-PLT	2	Link - Depth Adjuster to Arm
63	R-017-272-OFS	1	Depth Adjuster Shaft
64	R-018-272-OFS	1	Depth Adjuster Lock
65	R-019-272-OFS	1	Depth Adjuster
66	R-020-272-OFS	2	Pipe Size Indicator Calibrator
67	R-021-272-OFS	1	Pipe Size Indicator Barrel **
67A	R-122-268-LBL	1	Pipe Size Groove Depth Label
68	N-S95-040-000	1	Collar with Set Screw
69	N-M03-000-015	1	Spring
70	R-025-272-OFS	1	Guide Washer
71	R-019-226-MCH	1	.625 X 1.00 Lg. Socket Hd. Shoulder Screw, Blk. Ox.
72	N-S05-160-014	1	1.00 X .875 Lg. Socket Hd. Shoulder Screw, Blk. Ox.
73	R-030-272-OFS	1	Upper Roll Guard Cover Screw
74	N-M01-000-001	2	65° Grease Fitting, 1/8" NPT

\*\* Indicates additional items required and/or recommended when ordering.



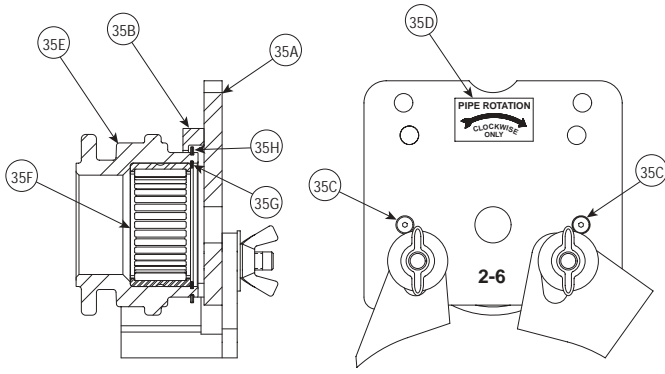
Item #	Part #	Qty.	Description
75	R-105-276-MCH	1	Main Shaft with Square Drive ** ****
75A	N-T03-000-016	1	Snap Ring
75B	N-B04-225-002	1	Inner Race
76	N-B01-157-002	1	40mm ID X 90mm OD X 36.5mm Wide Bearing
77	N-T03-000-018	1	Snap Ring
78	N-S01-040-010	4	1/4 - 20 UNC X .63 Lg. Hex Head Screw, Pltd.
79	N-W03-040-000	4	1/4" Lock Washer, Pltd.
80	N-W06-120-000	1	3/4" ID SAE High Strength Flat Washer, Pltd.
81	N-N01-120-000	1	3/4 - 10 UNC Hex Nut, Grade 5, Pltd.
82	N-N03-120-000	1	3/4 - 10 UNC Hex Jam Nut, Pltd.
83	R-028-272-0FS	1	Back Cover Plate

Item #	Part #	Qty.	Description
84	R-101-276-MCH	1	Main Shaft with Woodruff Key ** ****
84A	N-K01-060-900	1	#609 Woodruff Key
75A	N-T03-000-016	1	Snap Ring
75B	N-B04-225-002	1	Inner Race
76	N-B01-157-002	1	40mm ID X 90mm OD X 36.5mm Wide Bearing
77	N-T03-000-018	1	Snap Ring
78	N-S01-040-010	4	1/4 - 20 UNC X .63 Lg. Hex Head Screw, Pltd.
79	N-W03-040-000	4	1/4" Lock Washer, Pltd.
80	N-W06-120-000	1	3/4" ID SAE High Strength Flat Washer, Pltd.
81	N-N01-120-000	1	3/4 - 10 UNC Hex Nut, Grade 5, Pltd.
82	N-N03-120-000	1	3/4 - 10 UNC Hex Jam Nut, Pltd.

\*\* Indicates additional items required and/or recommended when ordering.

\*\*\* Discontinued item. Shown only to clarify tool configuration.

\*\*\*\* When upgrading to square drive shaft, lower roll with square drive feature must be used.



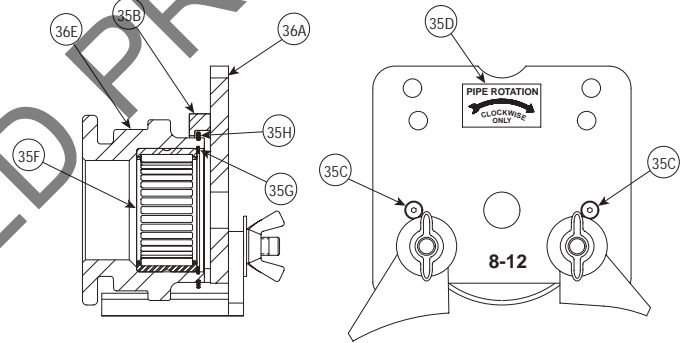
Item #	Part #	Qty.	Description
35	R-9A2-272-U06	1	2" - 6" Upper Roll Cover/Guard Assembly
35A	R-510-268-WLD	1	Upper Roll Guard
35B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
35C	N-S09-008-010	2	#8-32 UNC X 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
35D	R-040-416-LAB	1	Pipe Rotation Label
35E *	R-902-272-U06	1	2" - 6" Upper Roll for Steel Pipe
35F	N-B02-200-001	1	Needle Bearing
35G	N-T03-000-014	1	Snap Ring
35H	N-T03-000-022	1	Snap Ring

\* Not a saleable item – assembly must be ordered.

**UPPER ROLL COVER/GUARD ASSEMBLY  
FOR 2 - 6" STEEL PIPE  
(Item 35)**

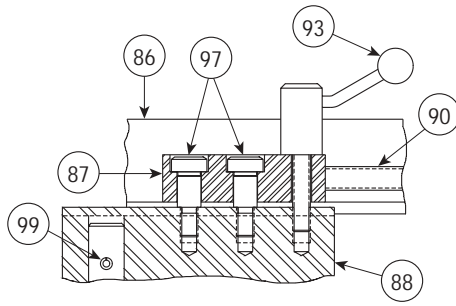
Item #	Part #	Qty.	Description
36	R-9A8-272-U12	1	8" - 12" Upper Roll Cover/Guard Assembly
36A	R-520-268-WLD	1	Upper Roll Guard
35B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
35C	N-S09-008-010	2	#8-32 UNC X 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
35D	R-040-416-LAB	1	Pipe Rotation Label
36E *	R-908-272-U12	1	8" - 12" Upper Roll for Steel Pipe
35F	N-B02-200-001	1	Needle Bearing
35G	N-T03-000-014	1	Snap Ring
35H	N-T03-000-022	1	Snap Ring

\* Not a saleable item – assembly must be ordered.

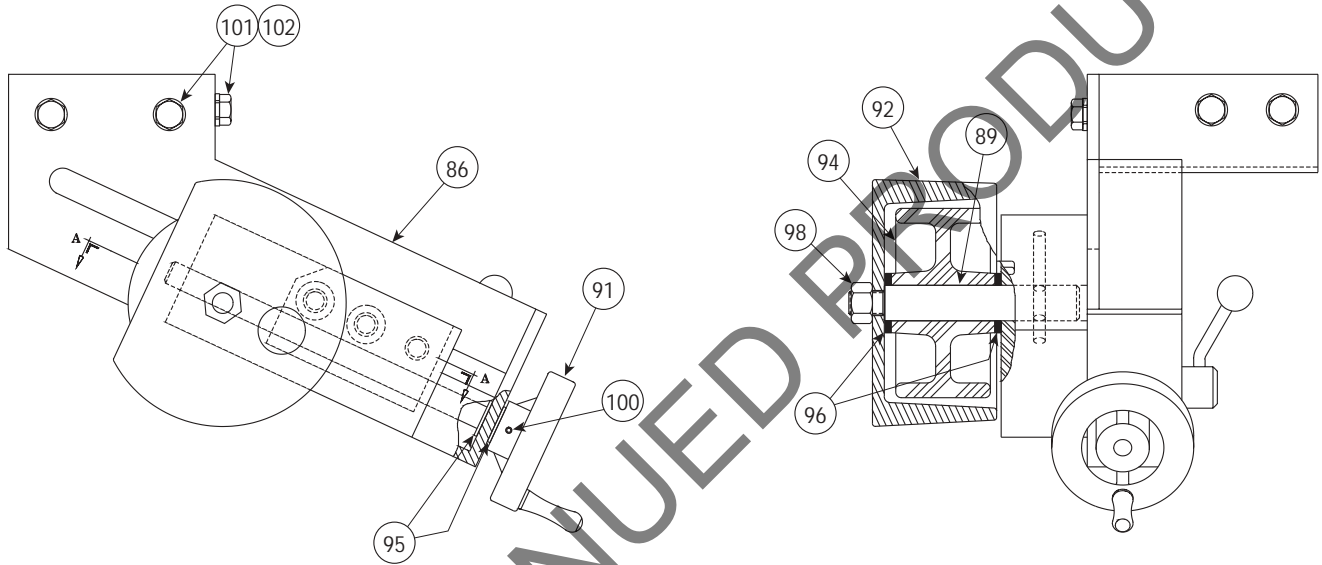


**UPPER ROLL COVER/GUARD ASSEMBLY  
FOR 8 - 12" STEEL PIPE  
(Item 36)**

DISCONTINUED PRODUCT



VIEW A-A



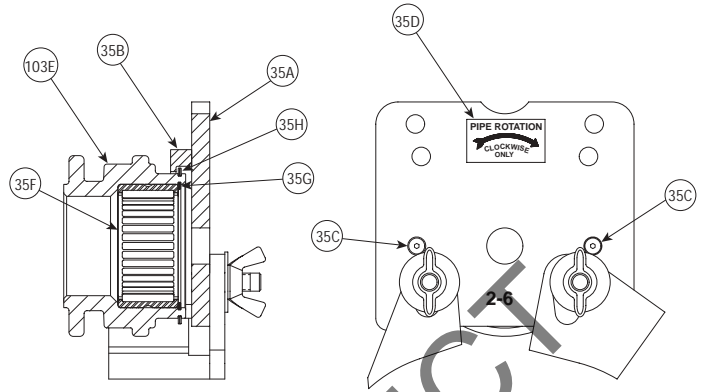
Item #	Part #	Qty.	Description
85	R-400-276-FSD	-	Stabilizer Assembly (Optional)
86	R-401-276-PNT	1	Stabilizer Body
87	R-402-416-PLT	1	Stabilizer Guide Nut
88	R-403-276-PLT	1	Stabilizer Guide
89	R-404-416-MAC	1	Stabilizer Roller Shaft
90	R-405-276-MCH	1	Stabilizer Adjusting Screw
91	R-406-416-MAC	1	Stabilizer Handwheel
92	R-407-416-PNT	1	Stabilizer Wheel Guard
93	R-450-416-ASY	1	Stabilizer Locking Handle Assembly
94	N-M05-000-004	1	4 x 2 Polyurethane Wheel
95	N-B05-037-002	2	Thrust Washer
96	N-B05-075-004	2	Thrust Washer
97	N-S05-080-012	2	Socket Head Shoulder Bolt, $\varnothing$ .50 x 0.75 Long, Blk. Ox.
98	N-N02-080-000	1	Hex Nut, $\frac{1}{2}$ - 20UNF, Pltd.
99	N-P01-004-208	1	Roll Pin, $\varnothing$ .25 x 2.50 Long
100	N-P01-002-102	1	Roll Pin, $\varnothing$ .125 x 1.125 Long
101	N-S02-060-100	4	$\frac{3}{8}$ - 16UNC Hex Head Cap Screw x 1.0 Long Grade 8, Pltd.
102	N-W03-060-000	4	$\frac{3}{8}$ " Lock Washer, Pltd.

\*\* Indicates additional items required and/or recommended when ordering.

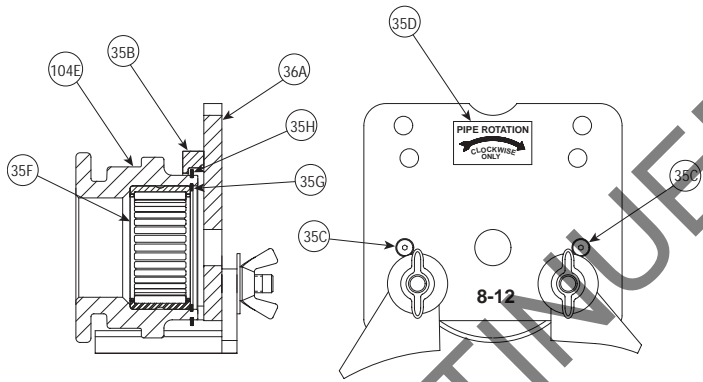
# ADDITIONAL ROLL SETS

Item #	Part #	Qty.	Description
103	R-XA2-268-U06	1	Upper Roll Cover/Guard Assembly
35A	R-510-268-WLD	1	Upper Roll Guard
35B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
35C	N-S09-008-010	2	#8-32 UNC X 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
35D	R-040-416-LAB	1	Pipe Rotation Label
103E *	R-X02-272-U06	1	2" - 6" Upper Roll for Stainless Steel Pipe
35F	N-B02-200-001	1	Needle Bearing
35G	N-T03-000-014	1	Snap Ring
35H	N-T03-000-022	1	Snap Ring
103J	R-X02-272-L03	1	2 - 3 1/2" Lower Roll for Stainless Steel Pipe (not shown)
103K	R-X04-272-L06	1	4 - 6" Lower Roll for Stainless Steel Pipe (not shown)

\* Not a saleable item – assembly must be ordered.



**UPPER ROLL COVER/GUARD ASSEMBLY  
FOR 2 - 6" SCHEDULE 5S/10S  
STAINLESS STEEL PIPE  
(Item 103)**

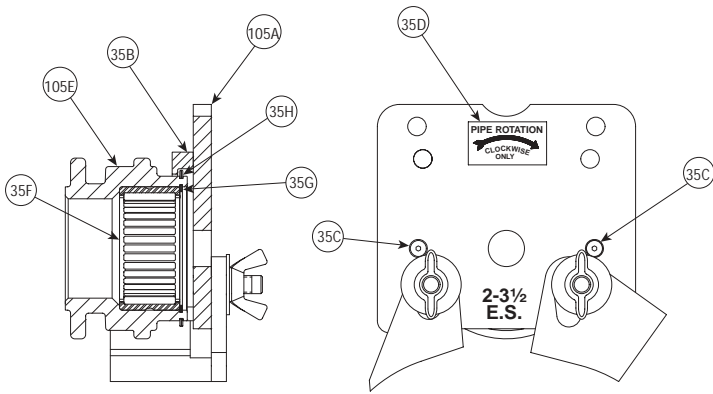


**UPPER ROLL COVER/GUARD ASSEMBLY  
FOR 8 - 12" SCHEDULE 5S/10S  
STAINLESS STEEL PIPE  
(Item 104)**

Item #	Part #	Qty.	Description
104	R-XA8-268-U12	1	Upper Roll Cover/Guard Assembly
36A	R-520-268-WLD	1	Upper Roll Guard
35B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
35C	N-S09-008-010	2	#8-32 UNC X 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
35D	R-040-416-LAB	1	Pipe Rotation Label
104E *	R-X08-272-U12	1	8" - 12" Upper Roll for Stainless Steel Pipe
35F	N-B02-200-001	1	Needle Bearing
35G	N-T03-000-014	1	Snap Ring
35H	N-T03-000-022	1	Snap Ring
104J	R-X08-272-L12	1	8 - 12" Lower Roll for Stainless Steel Pipe (not shown)

\* Not a saleable item – assembly must be ordered.





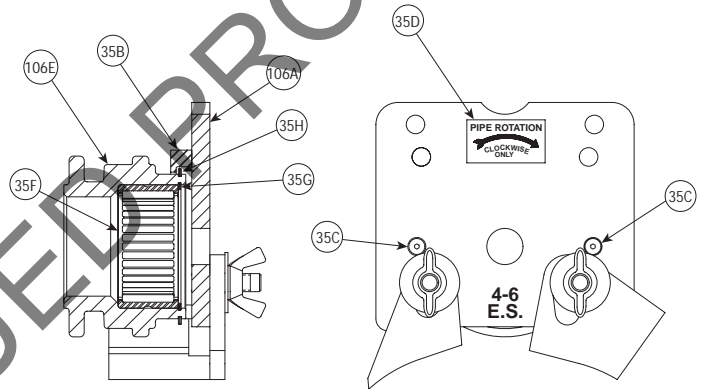
Item #	Part #	Qty.	Description
105	R-ZA2-268-U03	1	Upper Roll Cover/Guard Assembly
105A	R-Z00-268-WLD	1	Upper Roll Guard
35B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
35C	N-S09-008-010	2	#8-32 UNC X 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
35D	R-040-416-LAB	1	Pipe Rotation Label
105E *	R-Z02-272-U03	1	2" - 3 1/2" Upper Roll for EndSeal® Pipe
35F	N-B02-200-001	1	Needle Bearing
35G	N-T03-000-014	1	Snap Ring
35H	N-T03-000-022	1	Snap Ring
105J	R-Z02-272-L03	1	2" - 3 1/2" Lower Roll for EndSeal Pipe (Not Shown)

\* Not a saleable item – assembly must be ordered.

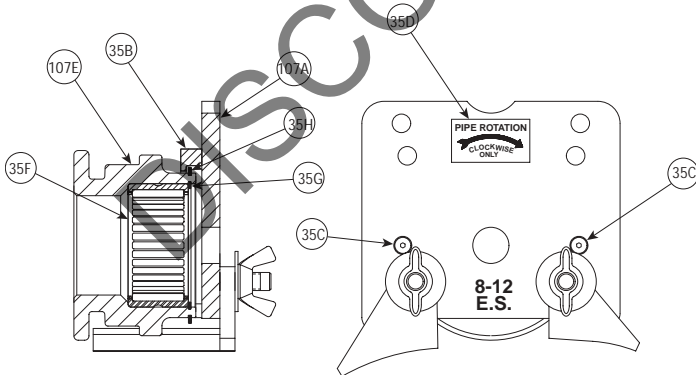
### UPPER ROLL COVER/GUARD ASSEMBLY FOR 2 - 3 1/2" ENDSEAL PIPE (Item 105)

Item #	Part #	Qty.	Description
106	R-ZA4-268-U06	1	Upper Roll Cover/Guard Assembly
106A	R-Z10-268-WLD	1	Upper Roll Guard
35B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
35C	N-S09-008-010	2	#8-32 UNC X 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
35D	R-040-416-LAB	1	Pipe Rotation Label
106E *	R-Z04-272-U06	1	4" - 6" Upper Roll for EndSeal Pipe
35F	N-B02-200-001	1	Needle Bearing
35G	N-T03-000-014	1	Snap Ring
35H	N-T03-000-022	1	Snap Ring
106J	R-Z04-272-L06	1	4" - 6" Lower Roll for EndSeal Pipe (Not Shown)

\* Not a saleable item – assembly must be ordered.



### UPPER ROLL COVER/GUARD ASSEMBLY FOR 4 - 6" ENDSEAL PIPE (Item 106)



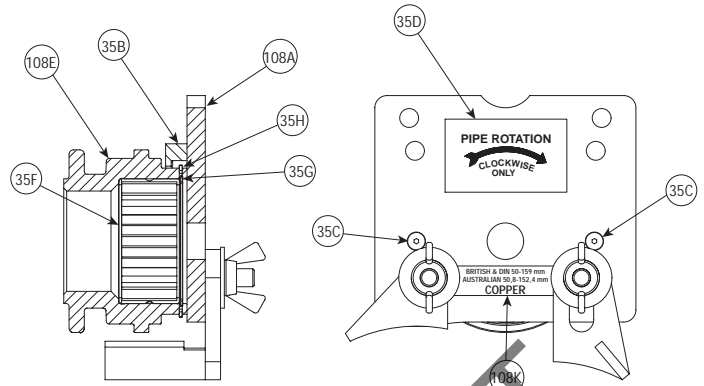
### UPPER ROLL COVER/GUARD ASSEMBLY FOR 8 - 12" ENDSEAL PIPE (Item 107)

Item #	Part #	Qty.	Description
107	R-ZA8-268-U12	1	Upper Roll Cover/Guard Assembly
107A	R-Z20-268-WLD	1	Upper Roll Guard
35B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
35C	N-S09-008-010	2	#8-32 UNC X 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
35D	R-040-416-LAB	1	Pipe Rotation Label
107E *	R-Z08-272-U12	1	8" - 12" Upper Roll for EndSeal Pipe
35F	N-B02-200-001	1	Needle Bearing
35G	N-T03-000-014	1	Snap Ring
35H	N-T03-000-022	1	Snap Ring
107J	R-Z08-272-L12	1	8" - 12" Lower Roll for EndSeal Pipe (Not Shown)

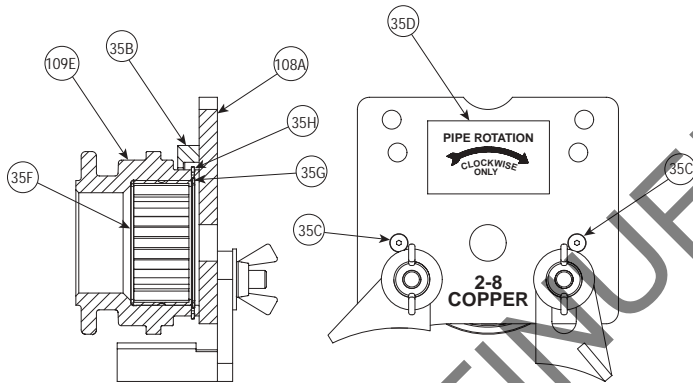
\* Not a saleable item – assembly must be ordered.

Item #	Part #	Qty.	Description
108	R-RE1-268-U06	1	Upper Roll Cover/Guard Assembly
108A	R-R00-268-WLD	1	Upper Roll Guard
35B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
35C	N-S09-008-010	2	#8-32 UNC X 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
35D	R-040-416-LAB	1	Pipe Rotation Label
108E *	R-RE1-272-U06	1	Upper Roll for Copper Pipe
35F	N-B02-200-001	1	Needle Bearing
35G	N-T03-000-014	1	Snap Ring
35H	N-T03-000-022	1	Snap Ring
108J	R-RE1-272-L06	1	Lower Roll for Copper Pipe (Not Shown)
108K	R-157-272-LBL	1	Roll Guard Cover Label (Export)

\* Not a saleable item – assembly must be ordered.



**UPPER ROLL COVER/GUARD ASSEMBLY  
FOR 50,8-152,4 mm AUSTRALIAN,  
50-159 mm BRITISH/DIN  
COPPER PIPE  
(Item 108)**



**UPPER ROLL COVER/GUARD ASSEMBLY  
FOR 2 - 8\"/>**

Item #	Part #	Qty.	Description
109	R-RA2-268-U08	1	Upper Roll Cover/Guard Assembly
108A	R-R00-268-WLD	1	Upper Roll Guard
35B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
35C	N-S09-008-010	2	#8-32 UNC X 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
35D	R-040-416-LAB	1	Pipe Rotation Label
109E *	R-R02-272-U08	1	2" - 8" Upper Roll for Copper Pipe
35F	N-B02-200-001	1	Needle Bearing
35G	N-T03-000-014	1	Snap Ring
35H	N-T03-000-022	1	Snap Ring
109J	R-R02-272-L06	1	2" - 6" Lower Roll for Copper Pipe (Not Shown)
109K	R-R08-272-L08	1	8" Lower Roll for Copper Pipe (Not Shown)

\* Not a saleable item – assembly must be ordered.

DISCONTINUED PRODUCT

**Victaulic® Factory Representatives and Distributor Stocks Worldwide**

Victaulic reserves the right to change product specifications, designs and standard equipment without notice and without obligation.