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## VE268 and VE269 Roll Grooving Tools

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### OGS OGS-200 EndSeal™

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#### PARTS ORDERING INFORMATION

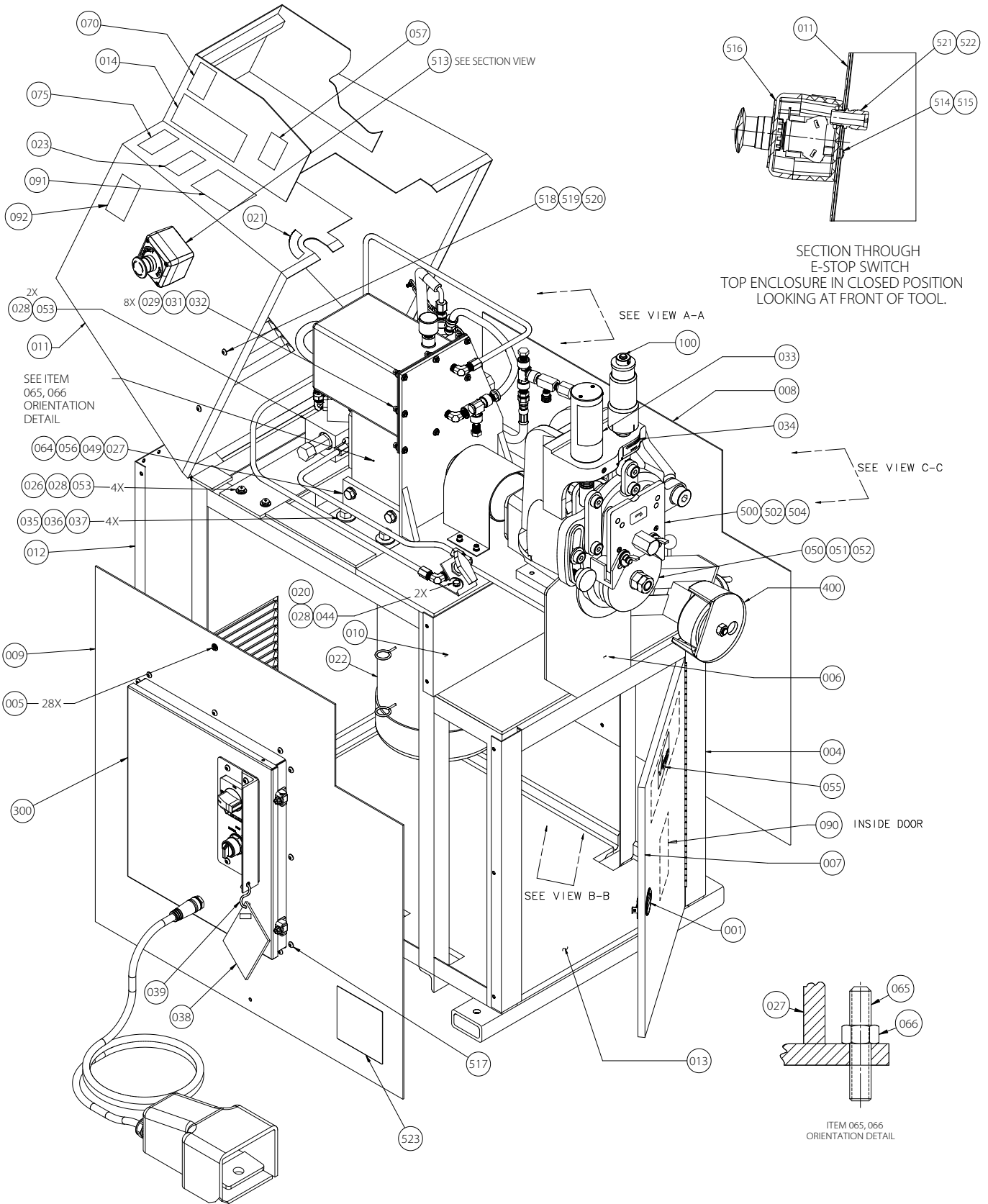
When ordering parts, the following information is necessary for Victaulic to process the order promptly:

1. Tool Model Number – VE268 or VE269
2. Tool Serial Number – The Serial Number can be found on the side of the tool.
3. Quantity\*, Item Number, Part Number, Description
4. Where to send the part(s) – Company Name and Address
5. To whose attention to send the part(s)
6. Purchase Order Number

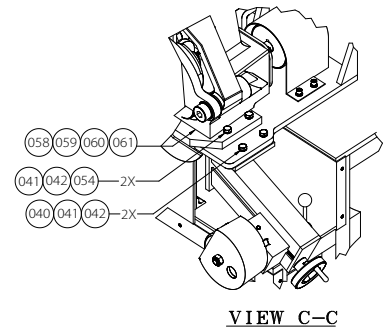
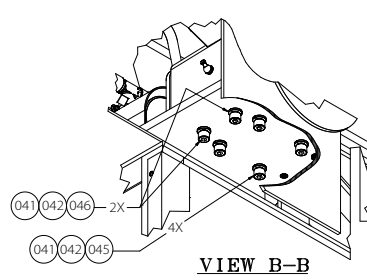
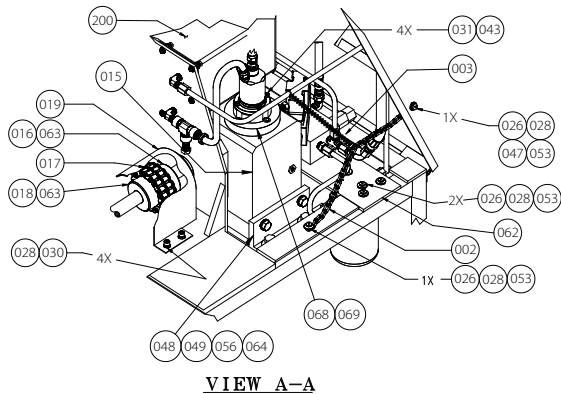
Parts may be ordered from your nearest Victaulic Sales Office.

\* Quantity given in **Qty.** column indicates total number of pieces required per tool

**VE268 MAIN ASSEMBLY**



**VE268 MAIN ASSEMBLY (CONTINUED)**

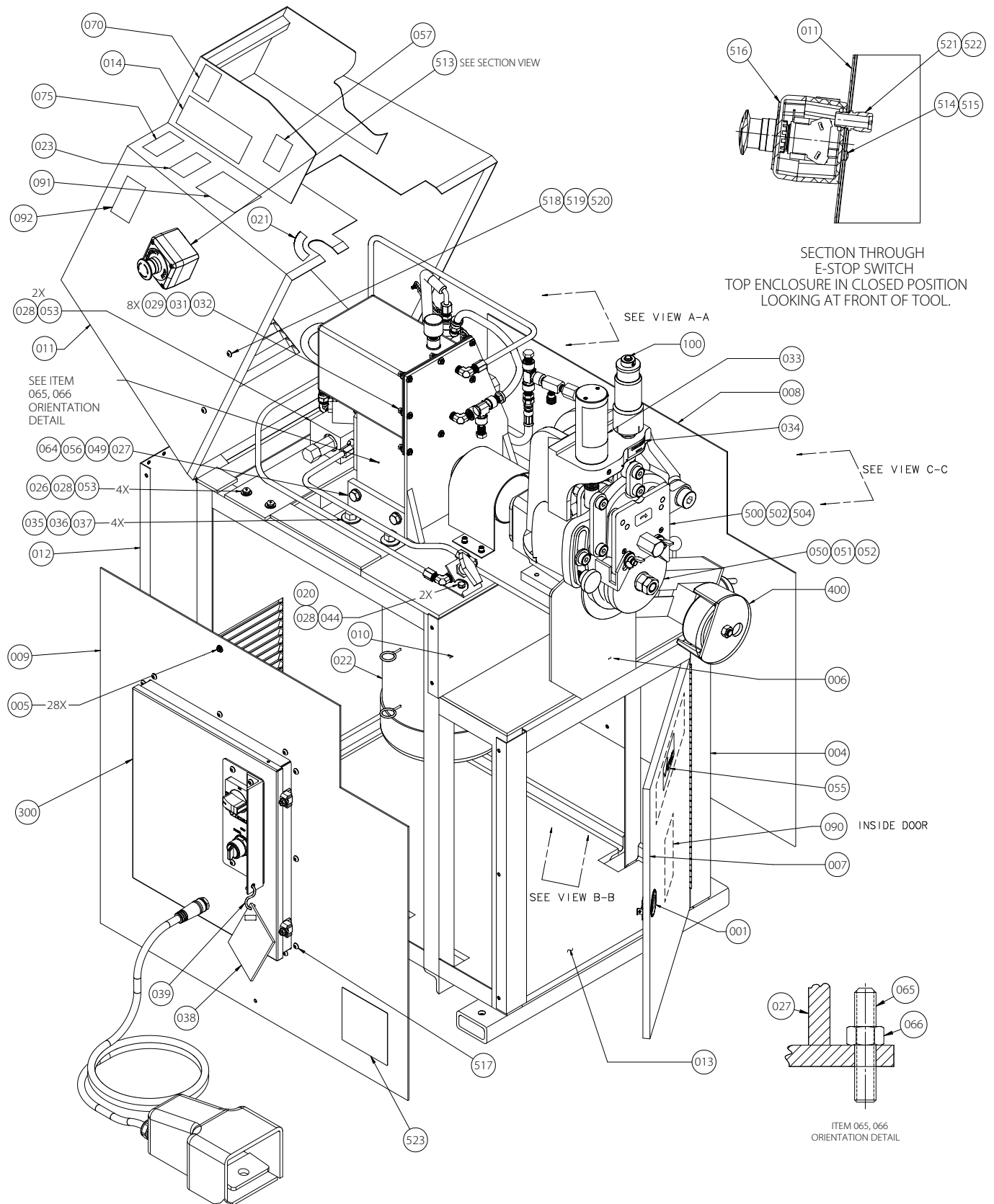


Item #	Part #	Qty.	Description
001	NM07000001	1	Latch
002	NM09000002	14"	Chain, Plated
003	NM03000003	1	Spring
004	R004274PNT	1	Frame
005	NS30012014	28	#12 - 24 x .88 Hvy. Duty Hex Washer Hd. Structural Self-Drilling and Tapping Screw
006	R006274PNT	1	Guard
007	R007274PNT	1	Front Door **
008	R008274PNT	1	Side Panel, RH
009	R009268PNT	1	Side Panel, LH **
010	R010274PNT	1	Front Panel
011	R011268PNT	1	Top Enclosure **
012	R012260PNT	1	Rear Enclosure
013	R013274PNT	1	Plywood Floor
014	R009424LBL	1	"C" Diameter Label #
015	R015274VE0	1	Gear Reducer Assembly
016	NM10000021	1	Chain Coupling ****
017	NM10000022	1	Chain
018	NM10000020	1	Chain Coupling
019	R012414PNT	1	Coupling Guard
020	R020274PNT	1	Ball Valve Mounting Bracket
021	R020260LBL	1	Pressure Setting Label #
022	NE01000025	1	3HP Motor, 220/460 VAC, 60HZ
023	R023268LBL	1	VE268 Series Label #
024	R024268LBL	1	Operating Specifications Label #
026	NW01040000	8	1/4" ID Flat Washer, Pltd.
027	R064274PNT	1	Left Gearbox Foot
028	NW03040000	20	1/4" ID Lock Washer, Split, Pltd.
029	NS06010010	8	#10 - 24 UNC x .63 Pan Head Cap Screw, Pltd.
030	NS03040008	4	1/4 - 20 UNC x .50 Lg. Socket Hd. Cap Screw, Blk. Ox.
031	NW03010000	12	#10 Lock Washer, Split, Pltd.
032	NN01010000	8	#10 - 24 UNC Hex Nut, Pltd.
033	R033274LBL	1	Roll Groove Warning Label #
034	R034272LAB	1	Decrease/Increase Groove Depth Label #
035	NS01080204	4	1/2 - 13 UNC x 2.25 Lg. Hex Hd. Cap Screw, Pltd.
036	NW01080000	4	1/2" ID Flat Washer, Pltd.
037	NN16080000	4	1/2 - 13 UNC Nylok Locking Hex Nut, Pltd.
038	NM07000005	1	S-Hook
039	R0392720FS	1	Guard Setting Pad Assembly
040	NS02060100	2	3/8 - 16 UNC x 1" Hex Hd. Cap Screw, Grd. 8, Pltd.
041	NW03060000	10	3/8" ID Split Lock Washer, Pltd.
042	NW01060000	10	3/8" ID Flat Washer, Pltd.
043	NS03010008	4	#10 - 24 UNC x .50 Socket Hd. Cap Screw, Blk. Ox.
044	NS01040008	2	1/4 - 20 UNC x .50 Lg. Hex Hd. Cap Screw, Blk. Ox.
045	NS03060200	4	3/8 - 16 UNC x 2.00 Socket Hd. Cap Screw, Blk. Ox.
046	NS03060104	2	3/8 - 16 UNC x 1.25 Socket Hd. Cap Screw, Blk. Ox.
047	NN01040000	5	1/4 - 20 UNC Hex Nut, Pltd.
048	R065274PNT	1	Right Gearbox Foot
049	NS02070104	8	7/16 - 14 UNC x 1 1/4" Lg. Hex Hd. Cap Screw, Pltd.
050	R902272L03	1	Lower Roll for 2 - 3 1/2" Steel Pipe

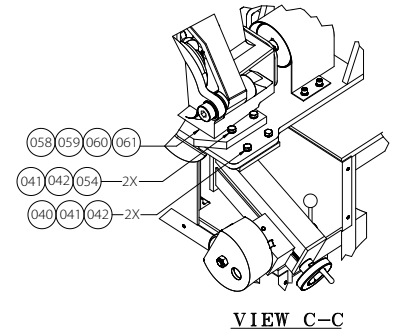
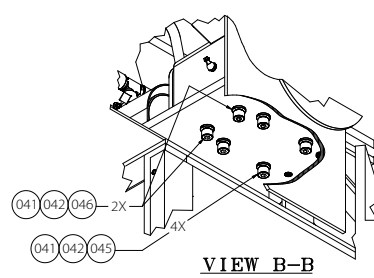
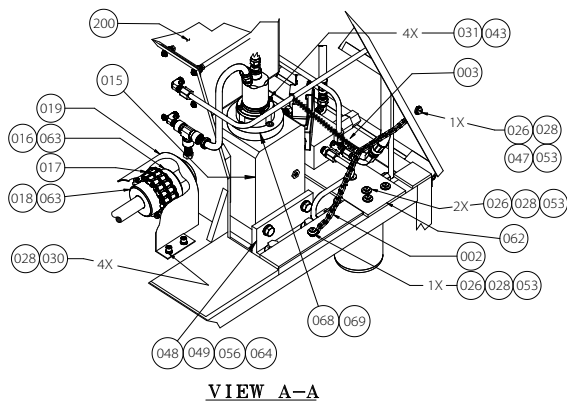
Item #	Part #	Qty.	Description
051	R904272L06	1	Lower Roll for 4 - 6" Steel Pipe
052	R908272L12	1	Lower Roll for 8 - 12" Steel Pipe
053	NS06040012	14	1/4 - 20 UNC x .75 Lg. Pan Hd. Phillips Screw, Pltd.
054	NS02060200	2	3/8 - 16 UNC x 2.00 Hex Hd. Cap Screw, Grd. 8, Pltd.
055	R055260LBL	1	Victaulic Logo Label #
056	NW01070000	4	7/16" ID Flat Washer, Pltd.
057	R010416LAB	1	Standard Wall Thickness Label #
058	R058274MCH	As Req.	Shim, .005 Thick
059	R059274MCH	As Req.	Shim, .007 Thick
060	R060274MCH	As Req.	Shim, .020 Thick
061	R061274MCH	As Req.	Shim, .040 Thick
062	R062274PNT	1	Manifold Mounting Plate
063	NK02004112	2	1/4 x 1.75" Lg. Square Key
064	NW03070000	4	7/16" ID Lock Washer, Pltd.
065	NS81060200	2	3/8 - 16 UNC x 2" Lg. Cup Pt. Set Screw, Blk. Ox.
066	NN01060000	2	3/8 - 16 UNC Hex Nut, Pltd.
068	R016274VE0	1	Gear Reducing Bearing Cover
069	R016274MCH	4	5/16 - 18 UNC x 3/4" Lg. Socket Hd. Cap Screw, Blk. Ox.
070	R070260VE0	1	"C" Diameter Reference Label for Copper #
075	R031272LAB	1	Instruction Warning Label #
090	R090424LAB	1	Electrical Danger Label #
091	R064268LBL	1	Tightening Direction Label #
092	R207264LBL	1	Groove Profile Information Label (Not Shown) #
100	R100268VE0	1	Head Assembly
190	R190272ASY	1	Arbor Assembly for 2 - 12" Pipe ***
200	R260274ASY	1	Hydraulic Assembly
300	R300268ASY	1	Electrical Assembly
400	R400274VE0	1	Stabilizer Assembly
502	R9A2272U06	1	Upper Roll Assembly for 2 - 6" Steel Pipe *
504	R9A8272U12	1	Upper Roll Assembly for 8 - 12" Steel Pipe *
505	R512260VE0	1	Lower Roll Removal Tool (Not Shown)
513	NE10000023	1	EStop Module *****
514	NW03000108	2	Lockwasher #8 *****
515	NS01008275	2	Socket Head Cap Screw 8 - 32 x 3/4" *****
516	NE10000024	2	EStop Legend Plate *****
517	NS02040012	15	Button Head Cap Screw 1/4 - 20 x 3/4" *****
518	NM16000038	3	Loop Clamp *****
519	NW03100002	3	Lockwasher 1/4" *****
520	NN01040000	3	Nut, 1/4 NPT *****
521	NM30000006	3	Cable Gland, 1/4 NPT, .120 - .390 Diameter *****
522	NH12004025	3	Locknut, 1/4 NPT *****
523	NS11921LBL	1	VE268 Specification Plate *****
524	NN01008000	2	Nut, 8 - 32 *****

\* Standard. Refer to pages 7 - 9 for optional upper roll cover/guard assemblies for grooving 3/4 - 1 1/2" pipe sizes and other pipe materials.  
 \*\* Indicates additional items required or recommended when ordering.  
 \*\*\* Standard, not shown. Refer to page 11 for optional arbor assemblies for grooving 3/4" and 1 - 1 1/2" pipe sizes.  
 \*\*\*\* Chain includes the master link, pin, and set cotter pin.  
 \*\*\*\*\* Updated design.  
 # Refer to pages 20 - 23 for images of product labels.

VE269 MAIN ASSEMBLY



**VE269 MAIN ASSEMBLY (CONTINUED)**

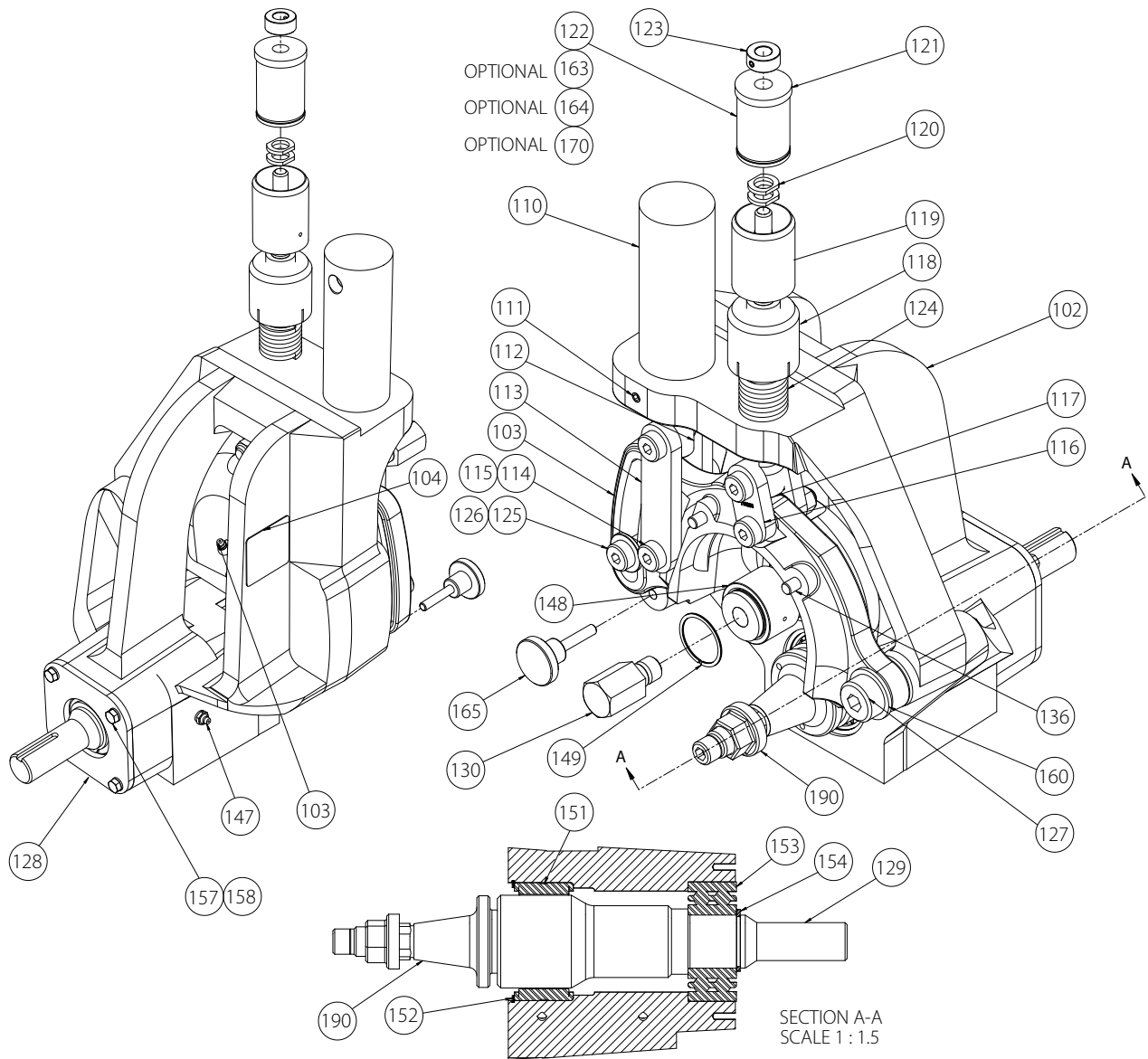


Item #	Part #	Qty.	Description
001	NM07000001	1	Latch
002	NM09000002	14"	Chain, Plated
003	NM03000003	1	Spring
004	R004274PNT	1	Frame
005	NS30012014	28	#12 - 24 x .88 Hvy. Duty Hex Washer Hd. Structural Self-Drilling and Tapping Screw
006	R006274PNT	1	Guard
007	R007274PNT	1	Front Door **
008	R008274PNT	1	Side Panel, RH
009	R009268PNT	1	Side Panel, LH **
010	R010274PNT	1	Front Panel
011	R011268PNT	1	Top Enclosure **
012	R012260PNT	1	Rear Enclosure
013	R013274PNT	1	Plywood Floor
014	R009424LBL	1	"C" Diameter Label #
015	R015274VE0	1	Gear Reducer Assembly
016	NM10000021	1	Chain Coupling ****
017	NM10000022	1	Chain
018	NM10000020	1	Chain Coupling
019	R012414PNT	1	Coupling Guard
020	R020274PNT	1	Ball Valve Mounting Bracket
021	R020260LBL	1	Pressure Setting Label #
022	NE01000030	1	3HP Motor
023	R023269LBL	1	VE269 Series Label #
024	R024268LBL	1	Operating Specifications Label #
026	NW01040000	8	1/4" ID Flat Washer, Pltd.
027	R064274PNT	1	Left Gearbox Foot
028	NW03040000	20	1/4" ID Lock Washer, Split, Pltd.
029	NS06010010	8	#10 - 24 UNC x .63 Pan Head Cap Screw, Pltd.
030	NS03040008	4	1/4 - 20 UNC x .50 Lg. Socket Hd. Cap Screw, Blk. Ox.
031	NW03010000	12	#10 Lock Washer, Split, Pltd.
032	NN01010000	8	#10 - 24 UNC Hex Nut, Pltd.
033	R033274LBL	1	Roll Groove Warning Label #
034	R034272LAB	1	Decrease/Increase Groove Depth Label #
035	NS01080204	4	1/2 - 13 UNC x 2.25 Lg. Hex Hd. Cap Screw, Pltd.
036	NW01080000	4	1/2" ID Flat Washer, Pltd.
037	NN16080000	4	1/2 - 13 UNC Nylok Locking Hex Nut, Pltd.
038	NM07000005	1	S-Hook
039	R0392720FS	1	Guard Setting Pad Assembly
040	NS02060100	2	3/8 - 16 UNC x 1" Hex Hd. Cap Screw, Grd. 8, Pltd.
041	NW03060000	10	3/8" ID Split Lock Washer, Pltd.
042	NW01060000	10	3/8" ID Flat Washer, Pltd.
043	NS03010008	4	#10 - 24 UNC x .50 Socket Hd. Cap Screw, Blk. Ox.
044	NS01040008	2	1/4 - 20 UNC x .50 Lg. Hex Hd. Cap Screw, Blk. Ox.
045	NS03060200	4	3/8 - 16 UNC x 2.00 Socket Hd. Cap Screw, Blk. Ox.
046	NS03060104	2	3/8 - 16 UNC x 1.25 Socket Hd. Cap Screw, Blk. Ox.
047	NN01040000	5	1/4 - 20 UNC Hex Nut, Pltd.
048	R065274PNT	1	Lower Roll for 2 - 3 1/2" Steel Pipe
049	NS02070104	1	Lower Roll for 4 - 6" Steel Pipe
050	R908272L12	1	Lower Roll for 8 - 12" Steel Pipe

Item #	Part #	Qty.	Description
053	NS06040012	14	1/4 - 20 UNC x .75 Lg. Pan Hd. Phillips Screw, Pltd.
054	NS02060200	2	3/8 - 16 UNC x 2.00 Hex Hd. Cap Screw, Grd. 8, Pltd.
055	R055260LBL	1	Victaulic Logo Label #
056	R065274PNT	1	Right Gearbox Foot
057	R010416LAB	1	Standard Wall Thickness Label #
058	R058274MCH	As Req.	Shim, .005 Thick
059	R059274MCH	As Req.	Shim, .007 Thick
060	R060274MCH	As Req.	Shim, .020 Thick
061	R061274MCH	As Req.	Shim, .040 Thick
062	R062274PNT	1	Manifold Mounting Plate
063	NK02004112	2	1/4 x 1.75" Lg. Square Key
064	NS02070104	4	7/16 - 14 UNC x 1 1/4" Lg. Hex Hd. Cap Screw, Pltd.
065	NW01070000	4	7/16" ID Flat Washer, Pltd.
066	NW03070000	4	7/16" ID Lock Washer, Pltd.
068	NS81060200	2	3/8 - 16 UNC x 2" Lg. Cup Pt. Set Screw, Blk. Ox.
069	NN01060000	2	3/8 - 16 UNC Hex Nut, Pltd.
070	R070260VE0	1	"C" Diameter Reference Label for Copper #
071	R016274VE0	1	Gear Reducing Bearing Cover
072	R016274MCH	4	3/16 - 18 UNC x 3/4" Lg. Socket Hd. Cap Screw, Blk. Ox.
075	R031272LAB	1	Instruction Warning Label #
090	R090424LAB	1	Electrical Danger Label #
091	R064268LBL	1	Tightening Direction Label #
092	R207264LBL	1	Groove Profile Information Label (Not Shown) #
100	R100268VE0	1	Head Assembly
190	R190272ASY	1	Arbor Assembly for 2 - 12" Pipe ***
200	R260274ASY	1	Hydraulic Assembly
300	R300268ASY	1	Electrical Assembly
400	R400274VE0	1	Stabilizer Assembly
502	R9A2272U06	1	Upper Roll Assembly for 2 - 6" Steel Pipe *
504	R9A8272U12	1	Upper Roll Assembly for 8 - 12" Steel Pipe *
505	R512260VE0	1	Lower Roll Removal Tool (Not Shown)
513	NE10000023	1	EStop Module *****
514	NW03000108	2	Lockwasher #8 *****
515	NS01008275	2	Socket Head Cap Screw 8 - 32 x 3/4" *****
516	NE10000024	2	EStop Legend Plate *****
517	NS02040012	15	Button Head Cap Screw 1/4 - 20 x 3/4" *****
518	NM16000038	3	Loop Clamp *****
519	NW03100002	3	Lockwasher 1/4" *****
520	NN01040000	3	Nut, 1/4 NPT *****
521	NM30000006	3	Cable Gland, 1/4 NPT, .120 - .390 Diameter *****
522	NH12004025	3	Locknut, 1/4 NPT *****
523	NS11922LBL	1	VE269 Specification Plate *****
524	NN01008000	2	Nut, 8 - 32 *****

\* Standard. Refer to pages 7 - 9 for optional upper roll cover/guard assemblies for grooving 3/4 - 1 1/2" pipe sizes and other pipe materials.  
 \*\* Indicates additional items required or recommended when ordering.  
 \*\*\* Standard, not shown. Refer to page 11 for optional arbor assemblies for grooving 3/4" and 1 - 1 1/2" pipe sizes.  
 \*\*\*\* Chain includes the master link, pin, and set cotter pin.  
 \*\*\*\*\* Updated design.  
 # Refer to pages 20 - 23 for images of product labels

**VE268/VE269 TOOL HEAD ASSEMBLY**

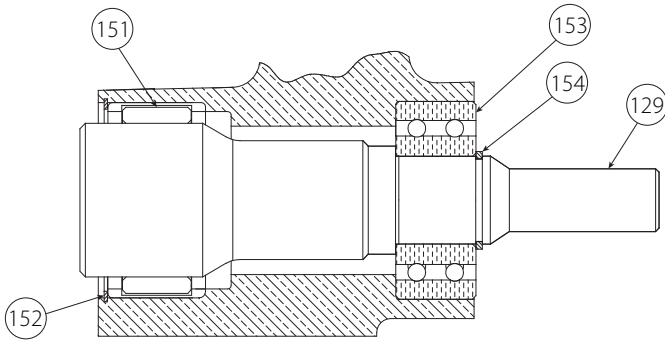


Item #	Part #	Qty.	Description
102	R0022720FS	1	Body **
103	R003268MCH	1	Arm **
104	R069272LAB	1	Name Plate
110	NH01000008	1	Cylinder **
111	NS80060008	1	3/8 - 16 UNC x 1/2" Lg. Brass Tip Set Screw
112	R0122720FS	1	Cylinder Adapter
113	R0132720FS	2	Link, Cylinder to Arm
114	NS05100110	4	.625 x 1.63 Lg. Socket Hd. Shoulder Screw, Blk. Ox.
115	NN08080000	4	1/2 - 13 UNC Heavy Hex Nylon Insert Locking Nut, Pltd.
116	R116268PLT	2	Link, Depth Adjuster to Arm
117	R0172720FS	1	Shaft, Depth Adjuster
118	R0182720FS	1	Depth Adjuster Lock
119	R0192720FS	1	Depth Adjuster
120	R0202720FS	2	Pipe Size Indicator Calibrator
121	R0212720FS	1	Pipe Size Indicator Barrel **
122	R122268LBL	1	Pipe Size Groove Depth Label #
123	NS95040000	1	Collar with Set Screw
124	NM03000015	1	Spring
125	R0252720FS	1	Guide Washer
126	R019226MCH	1	3/8" x 1.00 Shoulder Screw

Item #	Part #	Qty.	Description
127	NS05160014	1	1.00 x .875 Lg. Socket Hd. Shoulder Screw, Blk. Ox.
128	R0282720FS	1	Back Cover Plate
129	R129268MCH	1	Main Shaft
130	R0302720FS	1	Upper Roll Guard Cover Screw
136	NP11006100	2	.375 x 1.00 Lg. Type "H" Alloy Steel Groove Pin
147	NM01000002	1	1/8" NPT Straight Grease Fitting
148	NB04156002	1	Inner Race
149	NT03000017	1	Snap Ring
150	NM01000001	1	1/8" NPT 65° Grease Fitting
155	-	1	.75 ID SAE HighStrength Washer, Pltd.
156	-	1	3/4 - 10 UNC Nut, Grd. 5, Pltd.
157	-	4	1/4 - 20 UNC x .63 Lg. Hex Hd. Cap Screw, Pltd.
158	-	4	1/4" ID Helical Split Lock Washer, Pltd.
159	-	1	3/4 - 10 UNC Jam Nut, Pltd.
163	R163274LBL	1	Groove Depth Label for ISO65 and JIS Pipe#
164	R164274LBL	1	Groove Depth Label for DIN Pipe#
165	R110268ASY	1	Travel Stop Assembly
170	R170272LBL	1	Groove Depth Label for ISO65 Pipe#

\*\* Indicates additional items required or recommended when ordering.  
# Refer to pages 20 - 23 for images of product labels

**VE268/VE269 MAIN SHAFT**

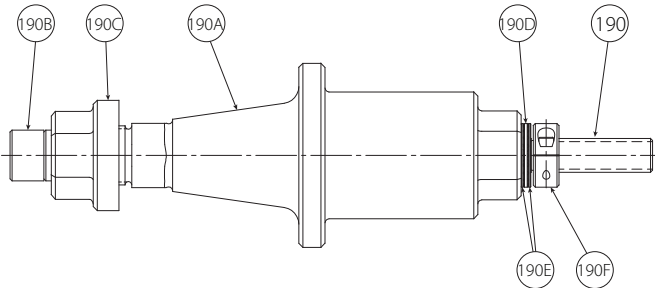


Item #	Part #	Qty.	Description
129	R129268MCH	1	Main Shaft
151	NB02275002	1	Needle Bearing
152	NT03000015	1	Snap Ring
153	NB01157002	1	40Mm ID x 90Mm OD x 36.5Mm Wide Double Row Ang. Contact Ball Bearing
154	NT03000017	1	Snap Ring

**NOTICE**

- Design "A" of the square drive arbor assembly for 2 - 12" pipe, shown below, supersedes Design "B".
- Components for Design "A" are not interchangeable with components of Design "B".

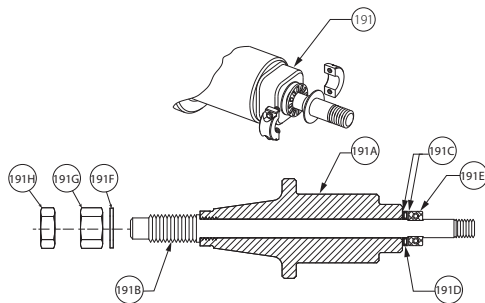
**DESIGN "A" - SQUARE DRIVE ARBOR ASSEMBLY FOR 2 - 12" PIPE**



Item #	Part #	Qty.	Description
190	R190272ASY	1	Arbor Assembly for 2 - 12" Pipe (Updated) *
190A	R195272MCH	1	Square Drive Tapered Roll Shaft for 2 - 12" Pipe
190B	R192272MCH	1	Retaining Stud, Tapered Roll Shaft
190C	R191272FNH	1	Lower Roll Nut
190D	NB03050001	1	.500 Bore Needle Thrust Bearing
190E	NB05050001	2	.500 Bore x 0.32 Thk. Thrust Washer
190F	NM13000002	1	Split Shaft Collar

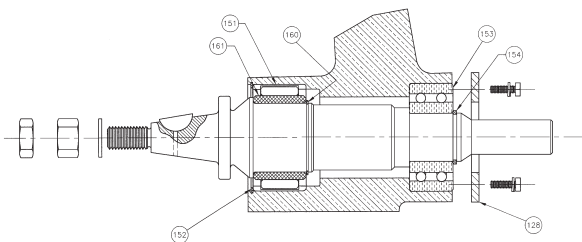
\* Indicates additional items required or recommended when ordering.

**DESIGN "B" - SQUARE DRIVE ARBOR ASSEMBLY FOR 2 - 12" PIPE \*\***



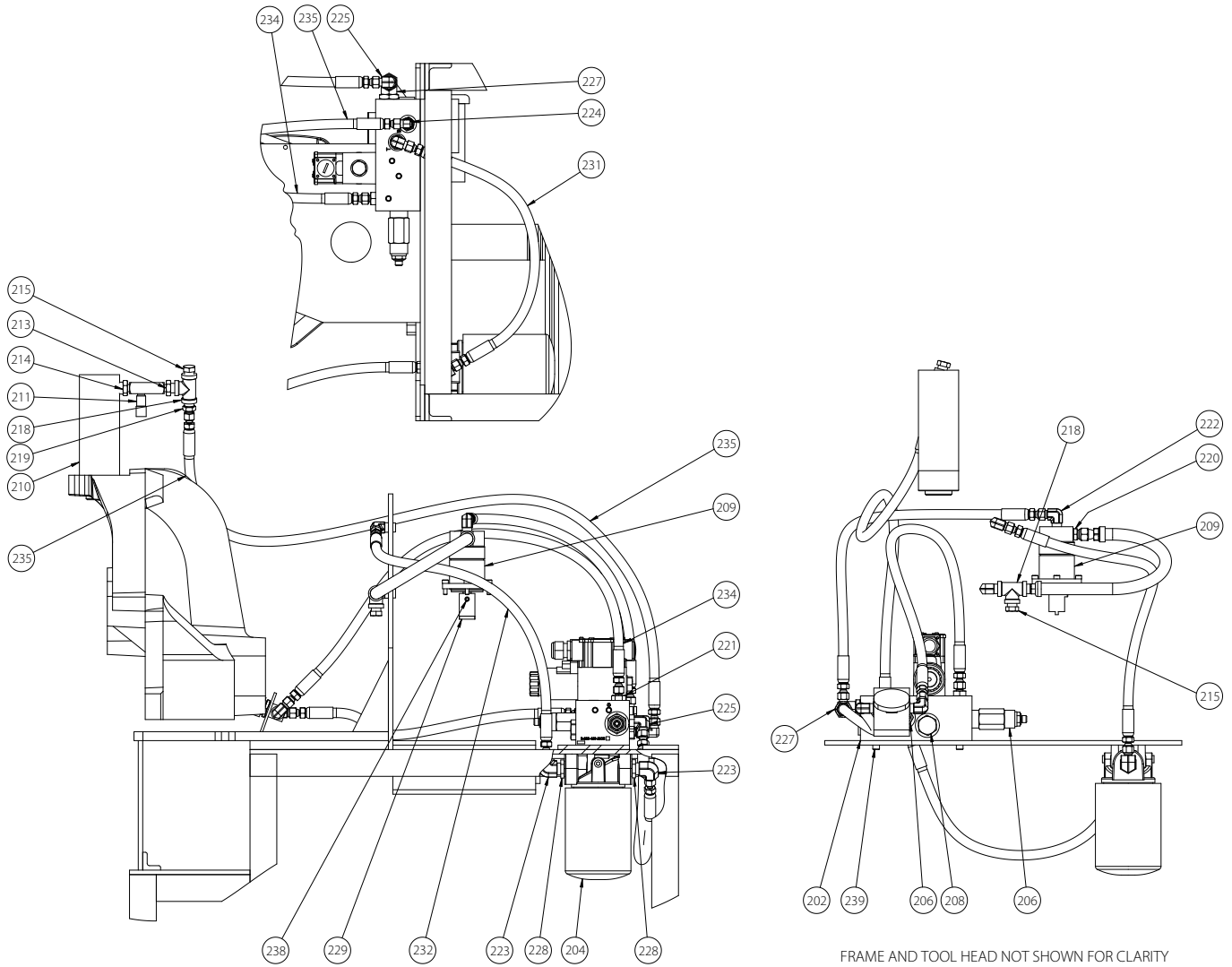
\*\* For reference only

**DESIGN "C" - KEY DRIVEN ARBOR ASSEMBLY FOR 2 - 12" PIPE \*\*\***

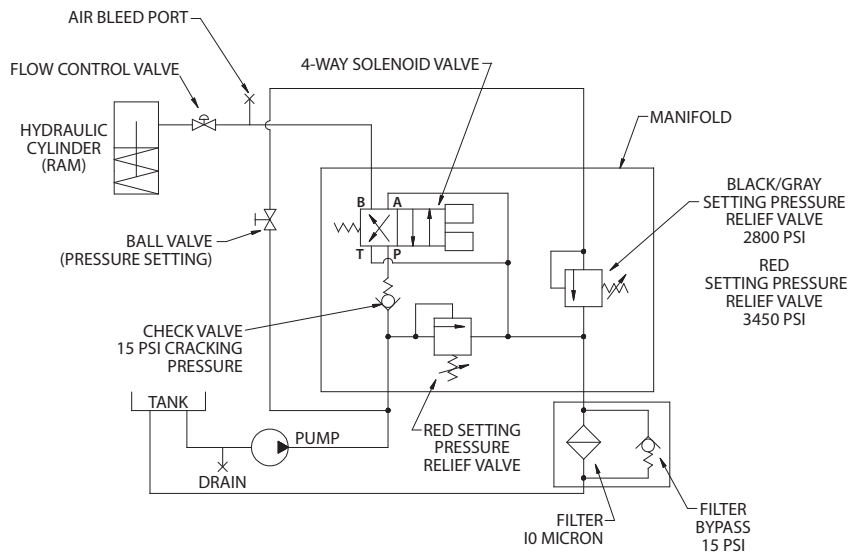


\*\*\* For reference only. Use part number R195268KIT (includes Design A arbor item # 190) with 2-12" lower rolls (items # 50, 51, 52).

**VE268/VE269 HYDRAULIC ASSEMBLY (UPDATED DESIGN)**

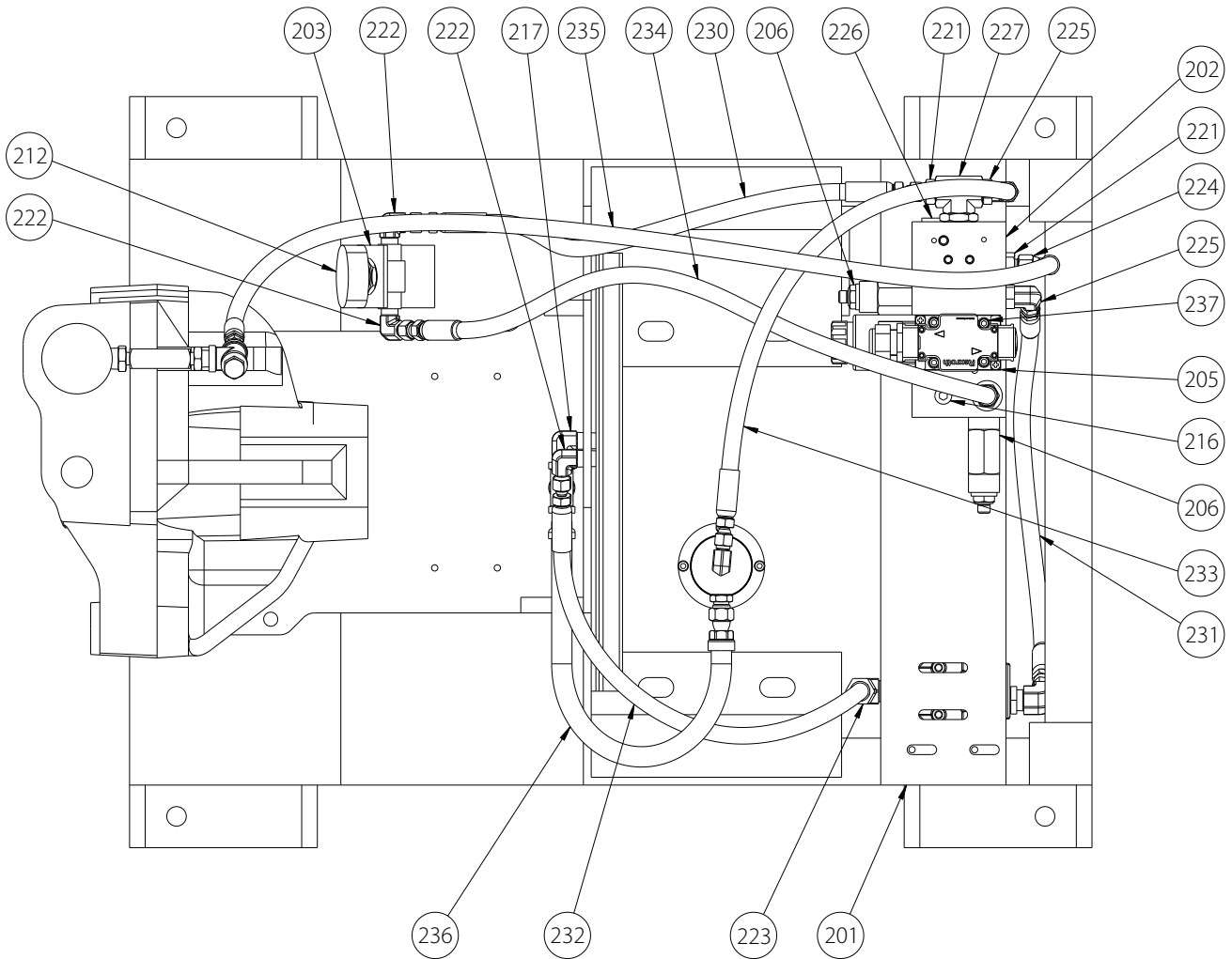


**VE268/VE269 HYDRAULIC SCHEMATIC (UPDATED DESIGN)**





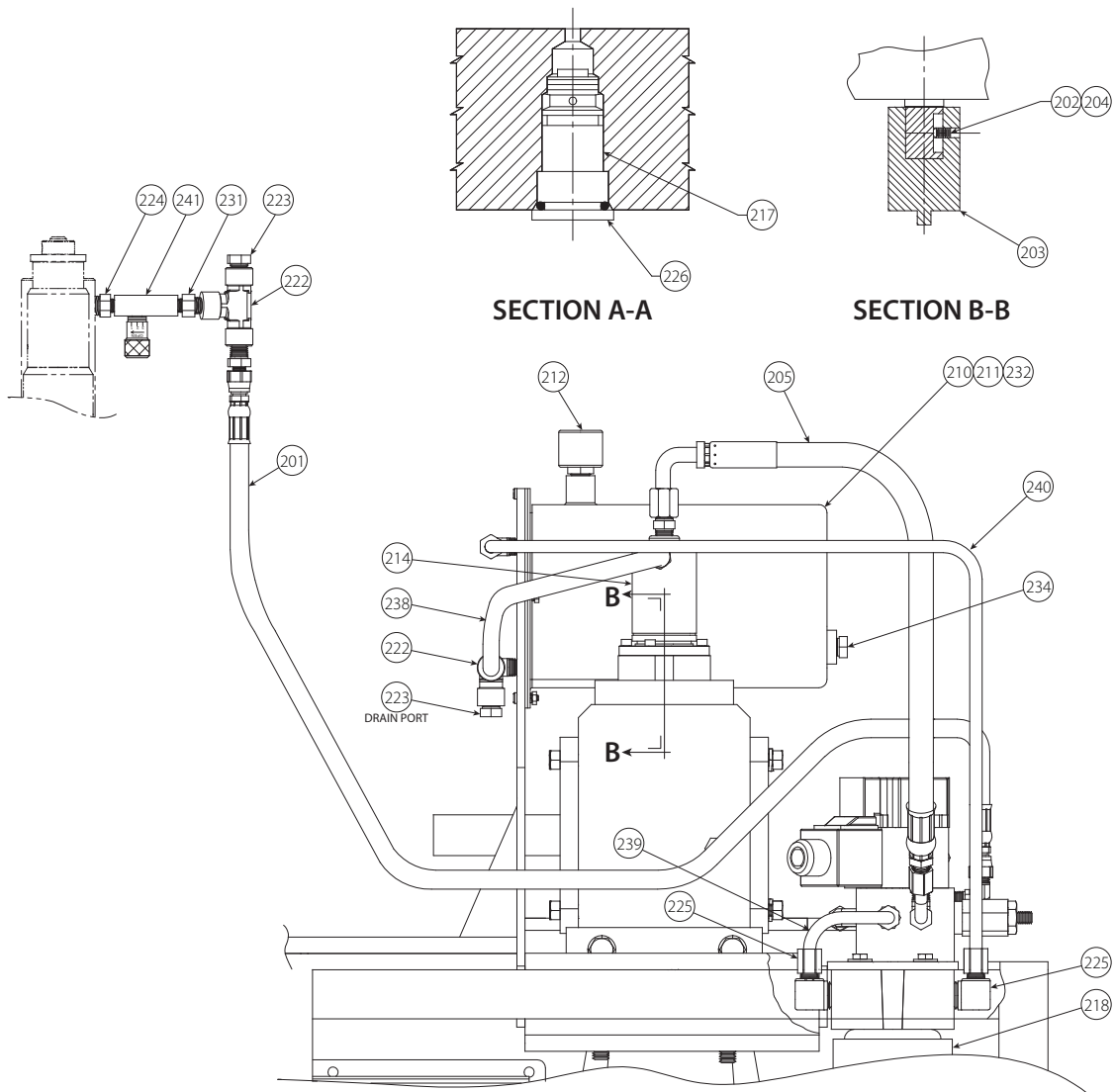
**VE268/VE269 HYDRAULIC ASSEMBLY (UPDATED DESIGN) (CONTINUED)**



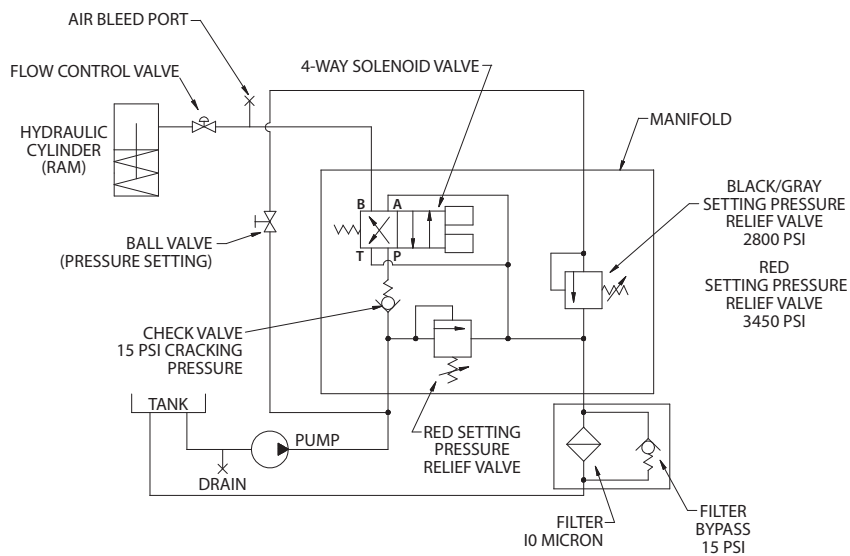
Item #	Part #	Qty.	Description
201	R063274PNT	1	Manifold Mounting Plate
202	R221268ASY	1	Hydraulic Manifold
203	R020274PNT2	1	Ball Valve Mounting Bracket
204	NH08000002	1	Filter
205	NH04000036	1	Flow Control Valve
206	NHYD000017	2	Cartridge Pressure Relief Valve
208	NHYD000029	1	Cartridge Check Valve
209	NH01000001	1	Hydraulic Piston Pump
210	NH01000008	1	Hydraulic Cylinder
211	NHYD000031	1	Flow Control Valve
212	NH04000007	1	Ball Valve
213	NH11004010	1	Nipple, Hex Head, 1/4 NPT x 1/8 NPT x 1.260
214	NH11006006	1	Nipple, Hex Head, 3/8 NPT x 1/8 NPT x 1.260
215	NH16004001	2	Plug, Hex Head, 1/4 NPT Male
216	NHYD000019	1	Plug, Countersunk Head, 1/4 NPT Male
217	NH12004011	1	Elbow, Straight, 90 Degree, 1/4 NPT Male
218	NH14004001	2	Tee, Straight, 1/4 NPT Female
219	NH11004001	1	Male Connector, 7/1620 SAE 37 Degree Flare Male x 1/4 NPT Male x 1.420
220	558F190000	1	Male Connector, 9/1618 SAE 37 Degree Flare Male x 1/4 NPT Male x 1.430
221	NHYD000014	3	Male Connector, 7/1620 SAE 37 Degree Flare Male x 9/1618 SAE Straight Male with O-Ring x 1.230
222	NH12004004	4	Elbow, 90 Degree Male, 7/1620 SAE 37 Degree Flare Male x 1/4 NPT Male
223	558F350000	2	Elbow, 90 Degree Male, 7/1620 SAE 37 Degree Flare Male x 3/8 NPT Male

Item #	Part #	Qty.	Description
224	NHYD000020	1	Elbow, 90 Degree Swivel, 7/1620 SAE 37 Degree Flare Female Swivel x 7/1620 SAE 37 Degree Flare Male
225	NH12004007	2	Elbow, 90 Degree Male, 7/1620 SAE 37 Degree Flare Male x 9/1618 SAE Straight Thread Male with O-Ring
226	NHYD000021	1	Plug, Hex Socket, Straight Thread O-Ring, 3/16
227	NHYD000022	1	Tee, Straight Thread Branch, 9/16 SAE Straight Female x 9/16 SAE Straight Female x 9/16 SAE Straight Male with O-Ring
228	NH11004030	2	Bushing, Hex Head, 1/2 NPT Male x 3/8 NPT Female
229	R003274MCH2	1	Coupling, Pump Drive
230	NHYD000023	1	Hose Assembly
231	NHYD000023	1	Hose Assembly
232	NHYD000024	1	Hose Assembly
233	NHYD000024	1	Hose Assembly
234	NHYD000025	1	Hose Assembly
235	NHYD000025	1	Hose Assembly
236	R238274VEO	1	Hose Assembly
237	NS03010200	1	Screw, #1024 x 2 x 7/8 Thread Hex Socket Head Cap
238	NS03040008	1	Screw, 1/420 x 1/2 Hex Socket Set, Half Dog Point
239	NS06040012	2	Screw, 1/420 x 3/4 Hex Socket Head Cap
-	NH07000001	1	260/424 Breather Lenz #BF6

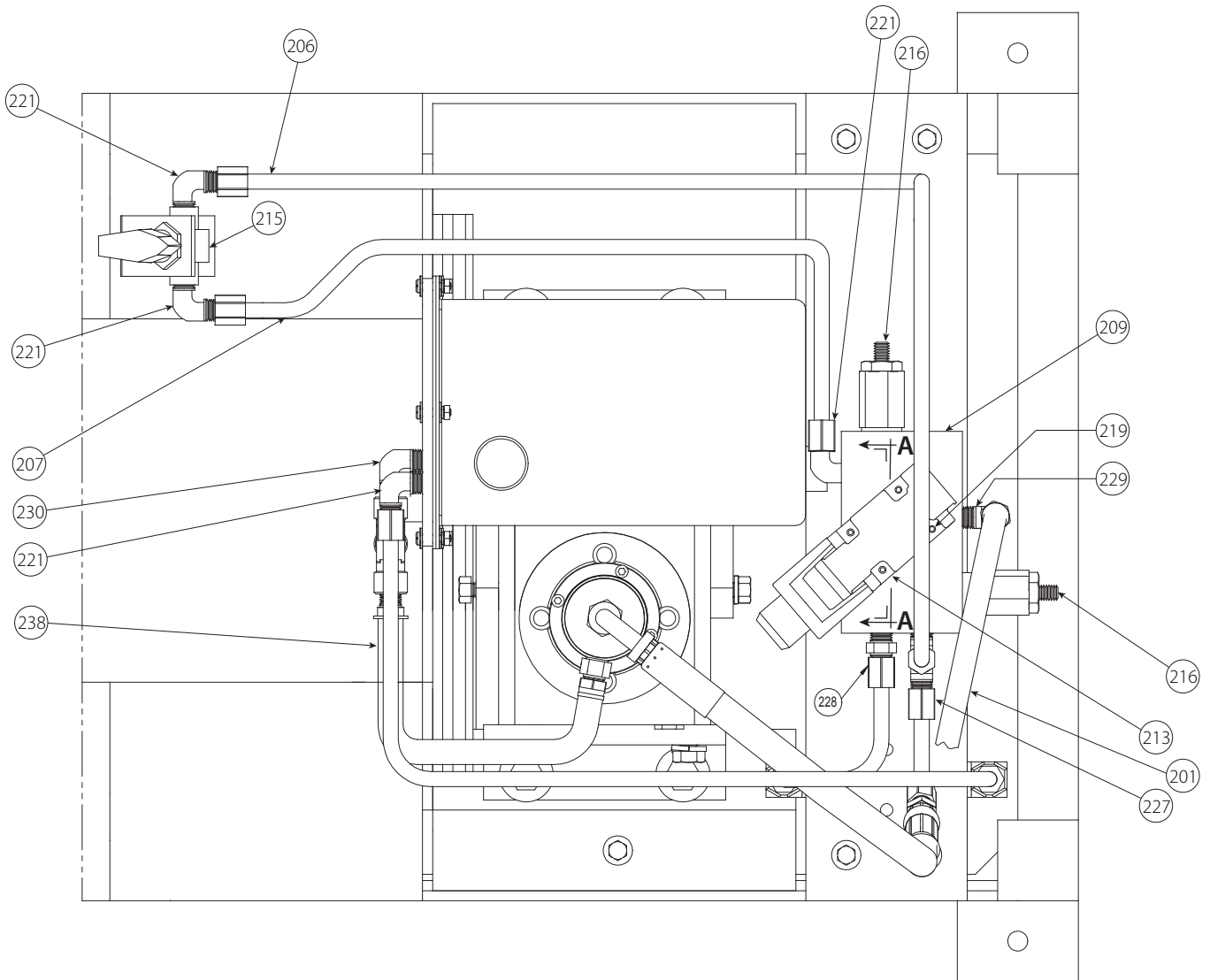
**VE268/VE269 HYDRAULIC ASSEMBLY (ORIGINAL DESIGN)**



**VE268/VE269 HYDRAULIC SCHEMATIC (ORIGINAL DESIGN)**



**VE268/VE269 HYDRAULIC ASSEMBLY (ORIGINAL DESIGN) (CONTINUED)**

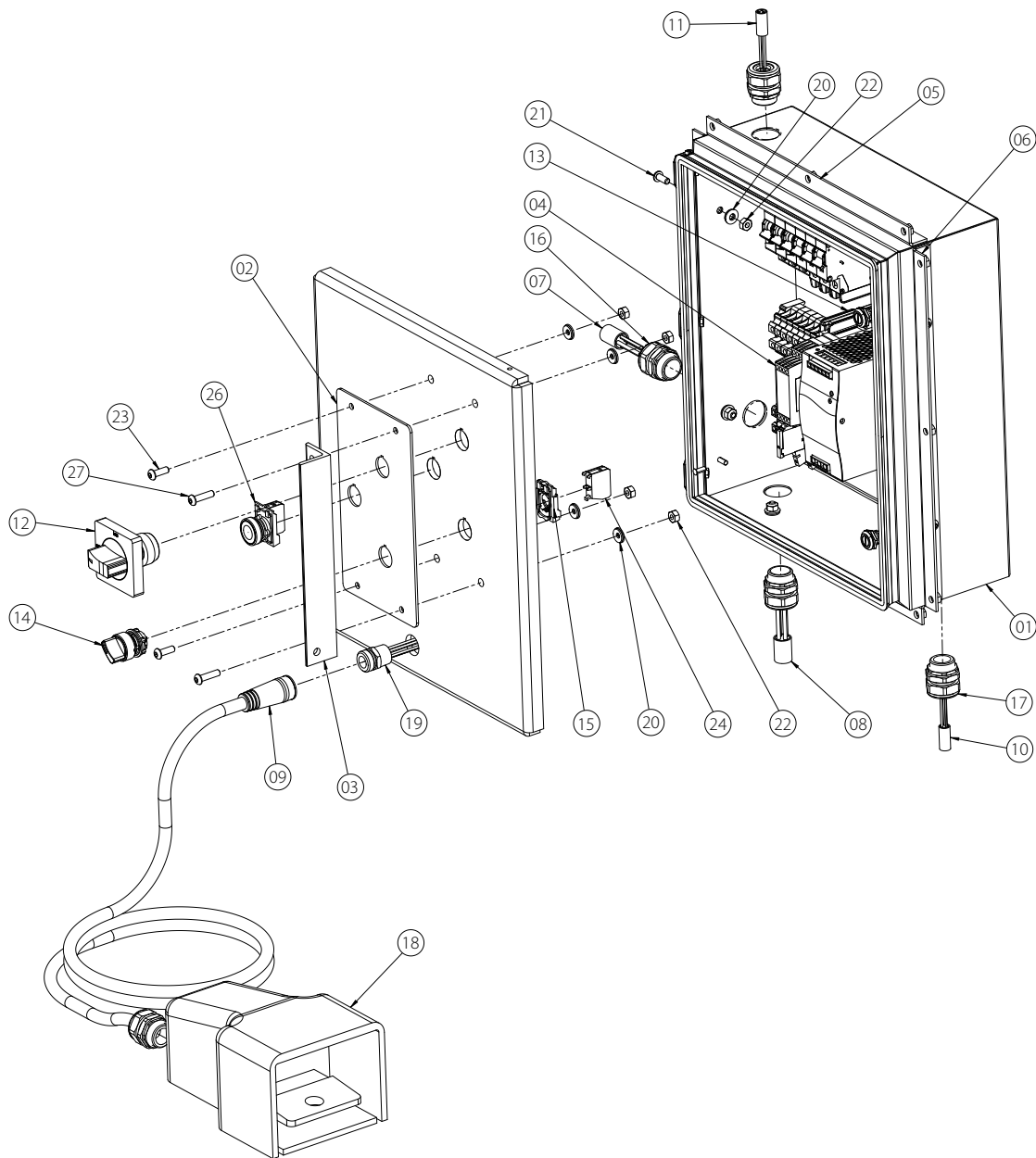


Item #	Part #	Qty.	Description
201	R201274VE0	1	Hose Assembly, Manifold-Cylinder
202	-	As Req.	Loctite #271
203	R003274MCH	1	Pump Drive Coupling
204	NS90040008	1	¼ - 20 UNC x ½" Lg. Dog Point Set Screw
205	R205274VE0	1	Hose Assembly, PumpManifold *
206	R206274VE0	1	Tubing Detail, Manifold-Ball Valve
207	R207274VE0	1	Tubing Detail, Ball ValveManifold
209	R209274MCH	1	Manifold
210	R201260PNT	1	Tank
211	-	6 Qt.	ISO 32 Hydraulic Oil, or Equivalent
212	NH07000001	1	Breather
213	NH04000004	1	**
214	NH01000001	1	Pump
215	NH04000007	1	Ball Valve
216	NH04000030	2	Relief Valve
217	NH04000003	1	Check Valve
218	NH03000003	1	Return Line Filter
219	NS03010200	4	#10 - 24 UNC x 2" Lg. Socket Hd. Cap Screw
221	NH12006002	4	90° Elbow
222	NH14004001	2	¼" Female Branch Tee

Item #	Part #	Qty.	Description
223	NH16004001	2	¼" Hex Hd. Plug
224	NH11006006	1	Reducing Hex Nipple
225	NH12006003	2	90° Elbow
226	NH16010001	1	Plug
227	NH14006002	1	Male Run Tee
228	NH11006001	1	Connector
229	NH12004002	1	90° Elbow
230	NH12004011	1	Male Elbow
231	NH11004010	1	Reducing Hex Nipple
232	R232274GSK	1	Hydraulic Reservoir Gasket
233	-	As Req.	Permacel P-412 Ribbon Dope or Equivalent
234	NH16006001	1	Hex Hd. Plug
238	R238274VE0	1	Hose Assembly, TankPump Inlet
239	R239274VE0	1	Tubing Detail, Manifold-Filter
240	R240274VE0	1	Tubing Detail, FilterTank
241	NH04000012	1	Flow Control Valve

\* When purchasing item 205, also purchase item 227 (Male Run Tee)  
 \*\* Item 213 on 220/440Volt, 3Phase tool to be Vickers #DG4V-32A-W-B-10 or Rexroth #4WE6-D51/W120-60 ND.

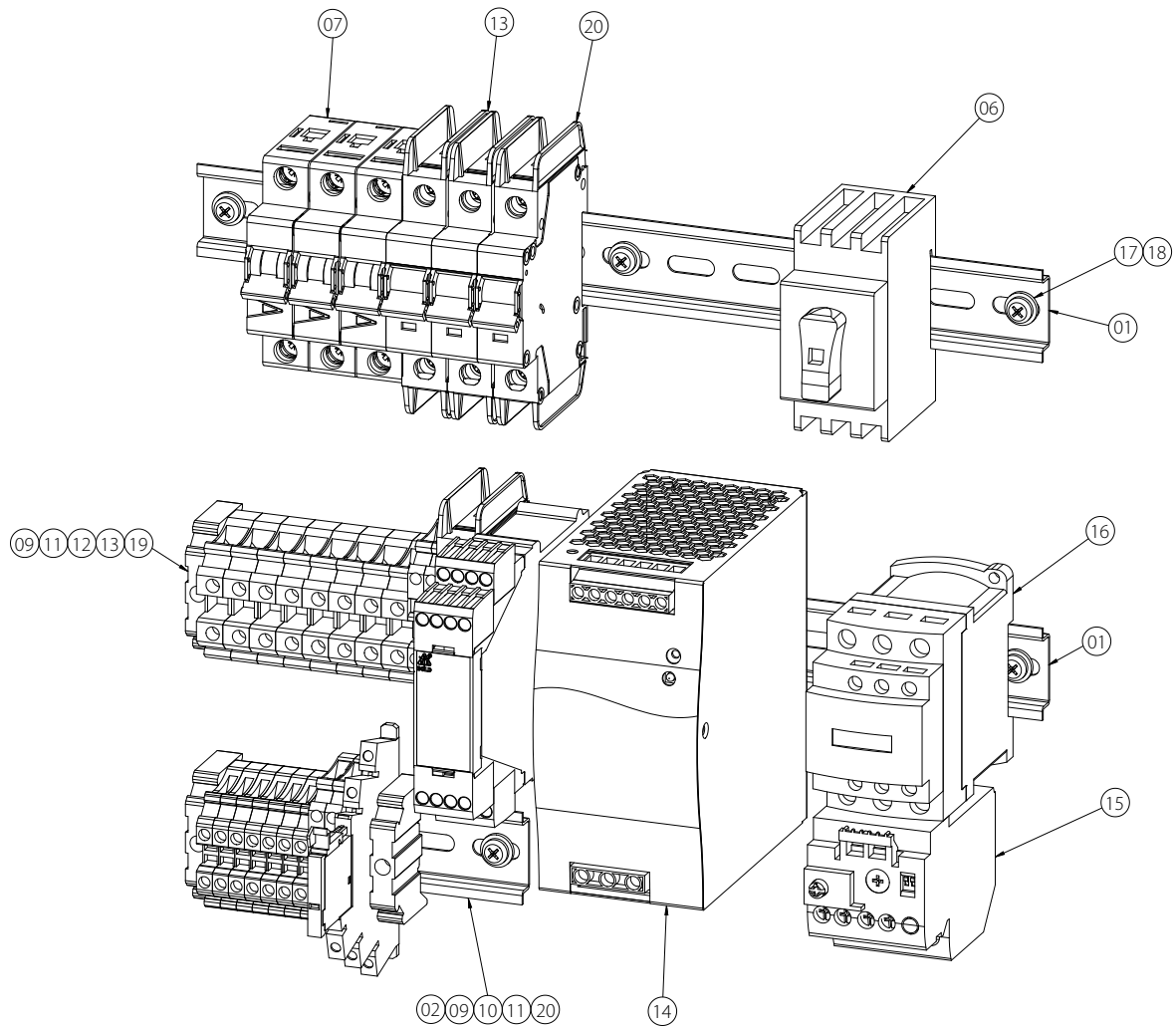
**VE268/VE269 ELECTRICAL ASSEMBLY (UPDATED DESIGN)**



Item #	Part #	Qty.	Description
01	R303268PNT	1	Electrical Enclosure, 3 Phase
02	R074268LBL	1	Label, Electrical Panel
03	R075268PNT	1	Switch Guard
04	R302268ASY	1	Enclosure Panel Assembly
05	R307268PNT	2	Mount Angle Short, Weldment
06	R309268PNT	2	Mount Angle Long, Weldment
07	R310268SCH	1	Cable Assembly, External, Bulkhead Connector to Main Power Outlet
08	R311268SCH	1	Cable Assembly, External, Bulkhead Connector to Motor Terminal Block
09	R312268SCH	1	Cable Subassembly, External, Bulkhead Connector to Foot Switch
10	R313268SCH	1	Cable Assembly, External, Bulkhead Connector to Solenoid Valve
11	R314268SCH	1	Cable Assembly, External, Bulkhead Connector to Emergency Stop Switch

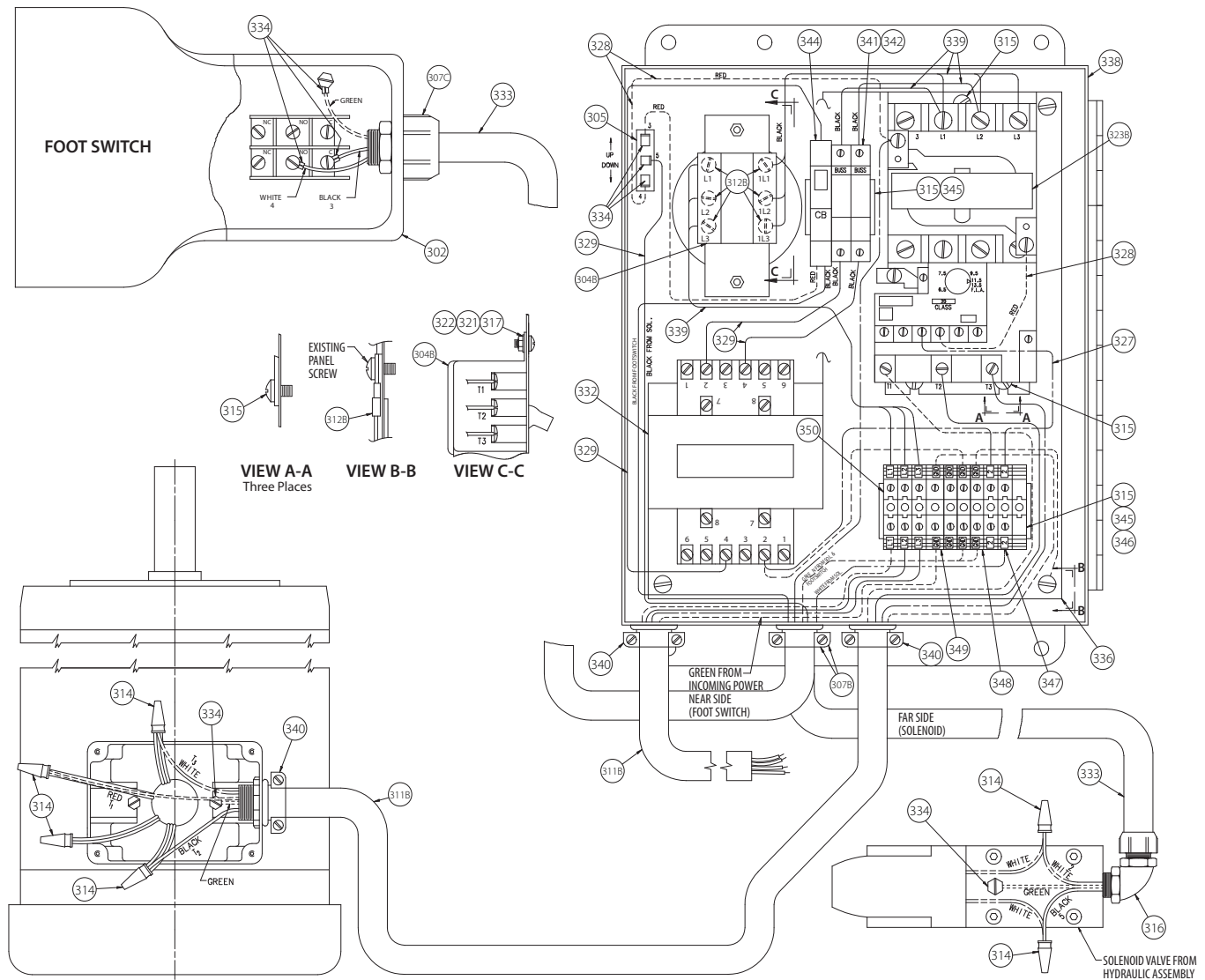
Item #	Part #	Qty.	Description
12	NELC000054	1	Handle, Operator, Mechanical Interlock
13	NELC000055	1	Disconnect Shaft
14	NELC000056	1	Switch, Selector
15	NELC000057	1	Adapter, Body Fixing Collar
16	NE01G51031	2	Connector, Cable Gland, 0.5100.710 Diameter
17	NE01G51032	3	Connector, Cable Gland, 0.3500.630 Diameter
18	NELC000004	1	Foot Switch, Single Stage
19	NELC000058	1	Cable, Female Receptacle
20	NELC000059	10	Sealing Washer
21	NS10040380	8	1/4 - 20 x 3/8" Hex Socket Button Head Cap Screw
22	NN01040000	10	1/4 - 20 Hex Nut
23	NS02040012	2	1/4 - 20 x 3/4" Hex Socket Button Head Cap Screw
24	NELC000061	1	Contact Block, 22mm Push Button, 1NO
26	NELC000060	1	Switch, Complete Control, Push Button, Green
27	NS10040001	2	1/4 - 20 x 1" Button Head Cap Screw

**VE268/VE269 ELECTRICAL ASSEMBLY (UPDATED DESIGN) (CONTINUED)**



Item #	Part #	Qty.	Description
06	NELC000062	1	Disconnect, 3Pole, 1000VAC, 32 AMP
07	NELC000063	1	Circuit Breaker, 3Pole, 277/480 VAC, 20 AMP
13	NELC000064	2	Circuit Breaker, Single Pole, 277/480 VAC, 10 AMP
14	NELC000065	1	Power Supply
15	NELC000066	1	Overload Relay
16	NELC000067	1	Contactor, 3Pole, 3 No, 440VAC, 18 AMP, 24V DC Coil
19	NELC000068	1	Module, Emergency Stop, 3 No Contacts, 24V DC
20	NELC000069	1	Relay, Power, SPDT, 24 VDC
21	NELC000070	1	Circuit Breaker, 2Pole, 277/480 VAC, 15 AMP

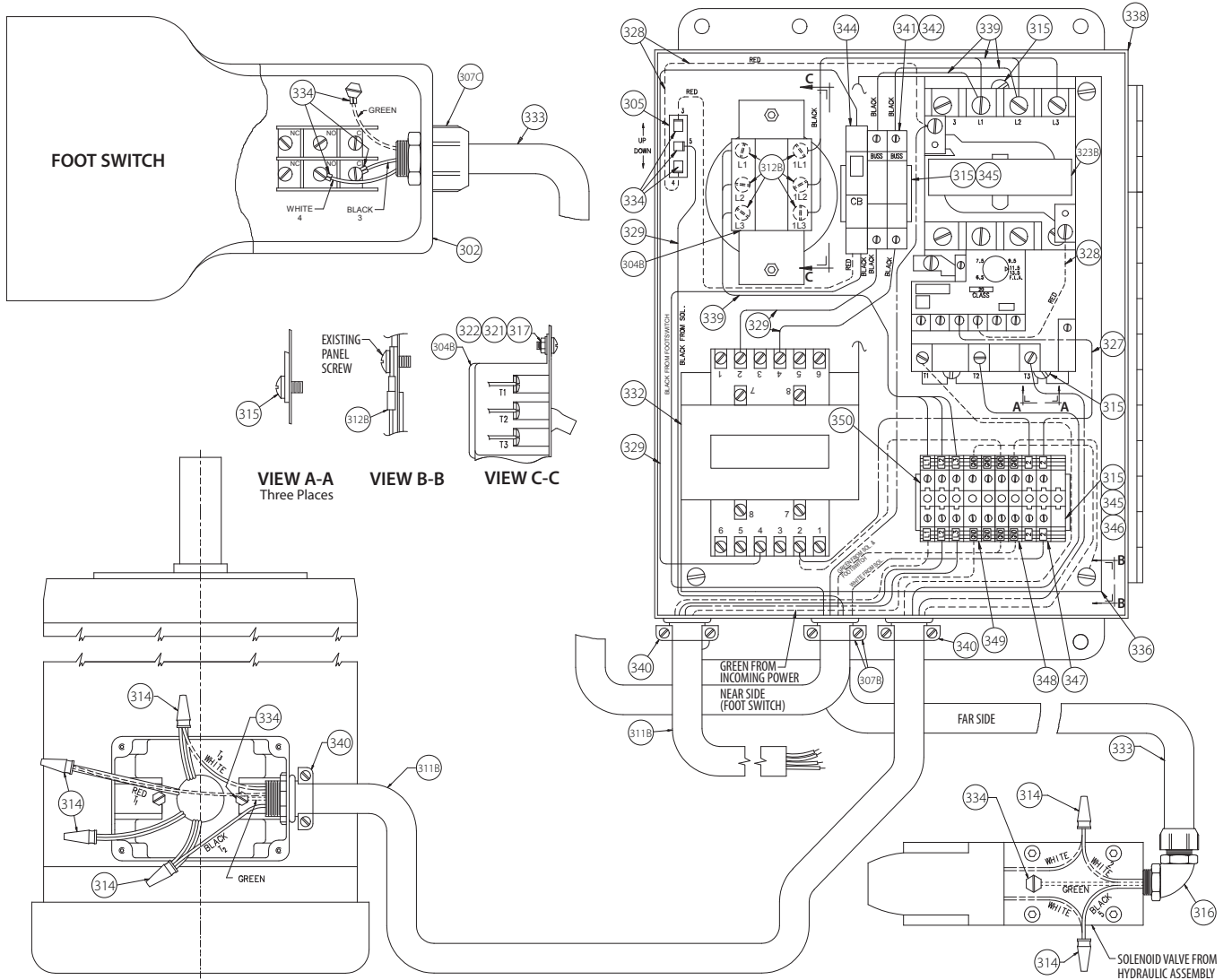
**VE268 ELECTRICAL ASSEMBLY (ORIGINAL DESIGN)**



Item #	Part #	Qty.	Description
302	NE03000003	1	Footswitch
304B	-	1	Switch
305	-	1	Switch
307B	-	2	Connector
307C	NE06000002	1	Connector
311B	-	11 1/2 ft.	Line Cord
312B	-	13	Ring Terminal
314	-	6	Wire Nut
315	-	11	#8 - 32 UNC x .50 Lg. Binding Hd. Slot Screw
316	-	1	Connector
317	-	2	#6 - 32 UNC x .38 Lg. Pan Hd. Slot Screw
321	-	2	#6 Standard Flat Washer, Pltd.
322	-	2	#6 - 32 UNC Hex Nut, Pltd.
323B	-	1	Magnetic Starter
327	-	As Req.	MTW 16 Gauge White
328	-	As Req.	MTW 16 Gauge Red
329	-	As Req.	MTW 16 Gauge Black

Item #	Part #	Qty.	Description
330	-	As Req.	MTW 16 Gauge Green
332	-	1	Transformer
333	NE04000011	12 1/2 ft.	Line Cord
334	-	15	Ring Terminal
336	R336274MCH	Ref.	Main Enclosure Panel
338	R338274VE0	Ref.	Electrical Box (Reference VE268 Main Assembly)
339	-	As Req.	MTW 12 Gauge Black
340	-	3	Connector
341	-	2	Fuse, Primary
342	-	1	Fuse Holder, Primary
344	-	1	Circuit Breaker
345	-	As Req.	DIN Rail
346	-	2	Terminal Block
347	-	2	Terminal Block
348	-	3	Terminal Block
349	-	1	Terminal Block
350	-	3	Terminal Block

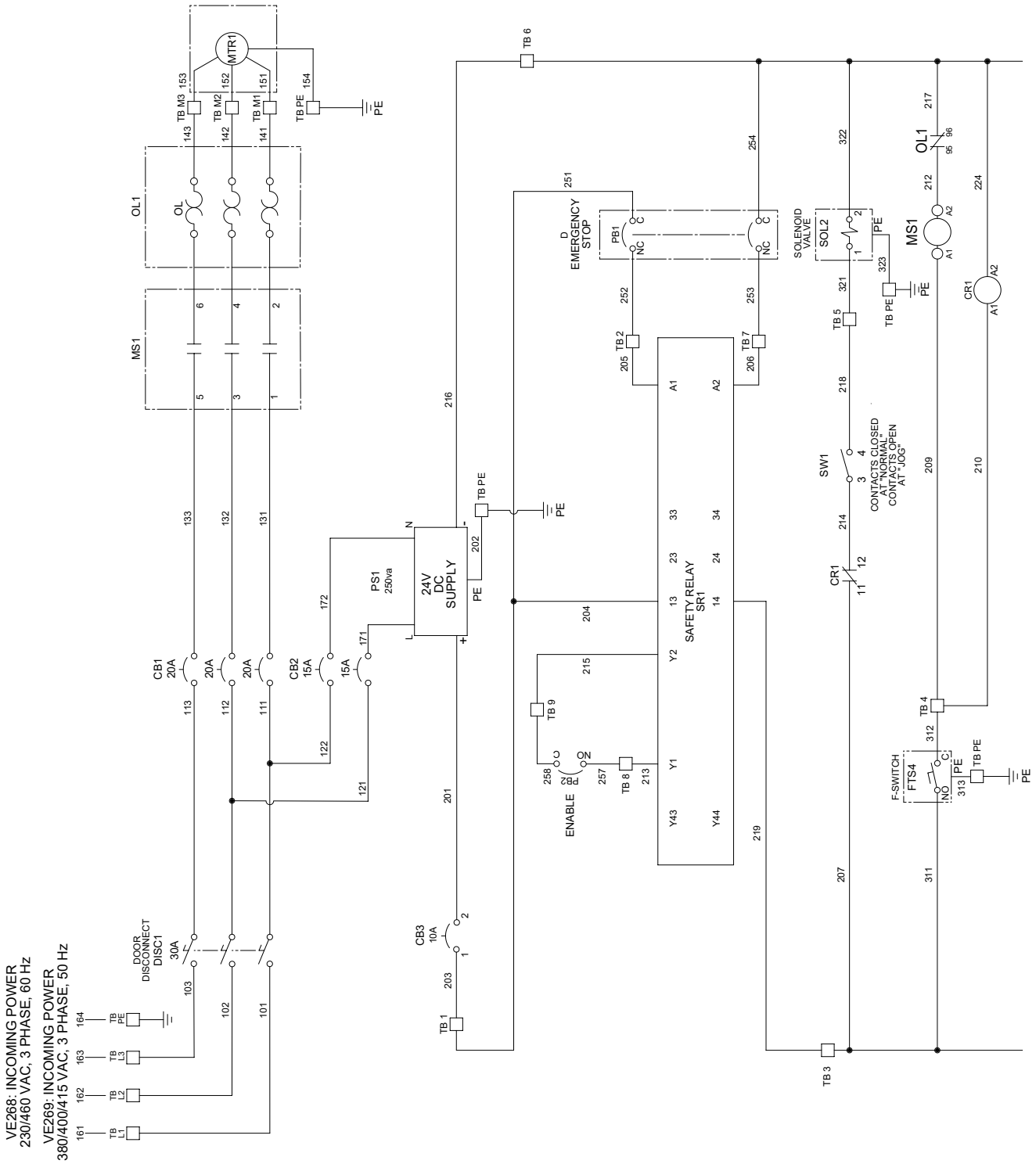
**VE269 ELECTRICAL ASSEMBLY (ORIGINAL DESIGN)**



Item #	Part #	Qty.	Description
302	NE03000002	1	Footswitch
304B	-	1	Switch
305	NE02000008	1	Switch
307B	-	2	Connector
307C	-	1	Connector
311B	-	11 1/2 ft.	Line Cord
312B	-	13	Ring Terminal
314	-	6	Wire Nut
315	-	11	#8 - 32 UNC x .50 Lg. Binding Hd. Slot Screw
316	-	1	Connector
317	-	2	#6 - 32 UNC x .38 Lg. Pan Hd. Slot Screw
321	-	2	#6 Standard Flat Washer, Pltd.
322	-	2	#6 - 32 UNC Hex Nut, Pltd.
323B	-	1	Magnetic Starter
327	-	As Req.	MTW 16 Gauge White
328	-	As Req.	MTW 16 Gauge Red
329	-	As Req.	MTW 16 Gauge Black

Item #	Part #	Qty.	Description
330	-	As Req.	MTW 16 Gauge Green
332	-	1	Shielded Transformer with Special 200VA Base
333	-	12 1/2 ft.	Line Cord
334	-	15	Ring Terminal
336	R336274MCH	Ref.	Main Enclosure Panel
338	R338274VE0	Ref.	Electrical Box (Reference VE268 Main Assembly)
339	-	As Req.	MTW 12 Gauge Black
340	-	3	Connector
341	-	2	Fuse, Primary
342	-	1	Fuse Holder, Primary
344	-	1	Circuit Breaker
345	-	As Req.	DIN Rail
346	-	2	Terminal Block
347	-	2	Terminal Block
348	-	3	Terminal Block
349	-	1	Terminal Block
350	-	3	Terminal Block

VE268/VE269 ELECTRICAL DIAGRAM (UPDATED DESIGN)





**VE268 ELECTRICAL DIAGRAM (ORIGINAL DESIGN)**

	F.L.A. OVERLOAD	CLASS	PHASE IMBALANCE
230V	11.5 AMPS	20	*
460V	6.5 AMPS	20	*

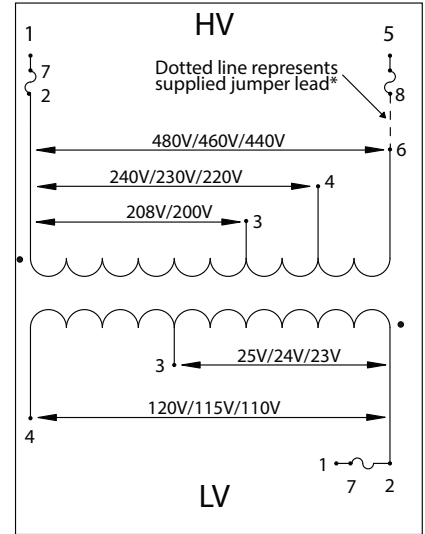
**INCOMING POWER REQUIREMENTS**

230 OR 460 VOLT 3 PHASE 60 HZ  
 8.8 AMP FULL LOAD AT 230V  
 4.4 AMP FULL LOAD AT 460V

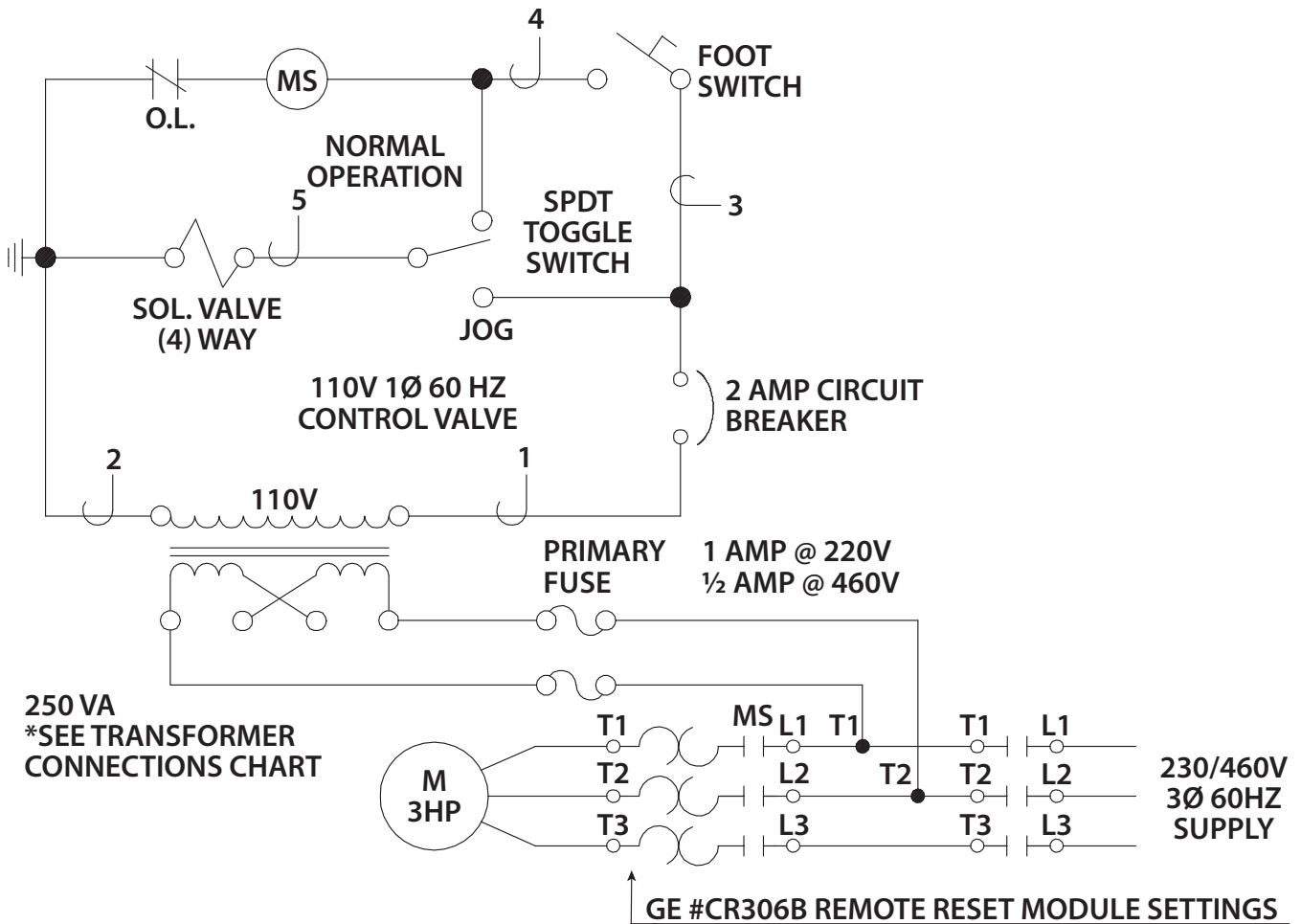
INCOMING POWER MUST BE SHORT  
 CIRCUIT PROTECTED BY BREAKER OR  
 FUSE.

\* #CR306B MOTOR STARTER FEATURES  
 FIXED PHASE IMBALANCE PROTECTION

**TRANSFORMER CONNECTIONS**



\* This primary fuse jumper is supplied with the primary fuse kit only.  
 \*\* Change primary HV Taps only as required.



**VE269 ELECTRICAL DIAGRAM (ORIGINAL DESIGN)**

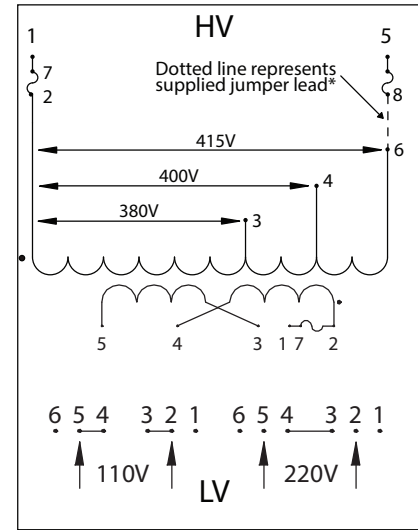
	<u>F.L.A. OVERLOAD</u>	<u>CLASS</u>	<u>PHASE IMBALANCE</u>
380V	6.5 AMPS	20	20

**INCOMING POWER REQUIREMENTS**

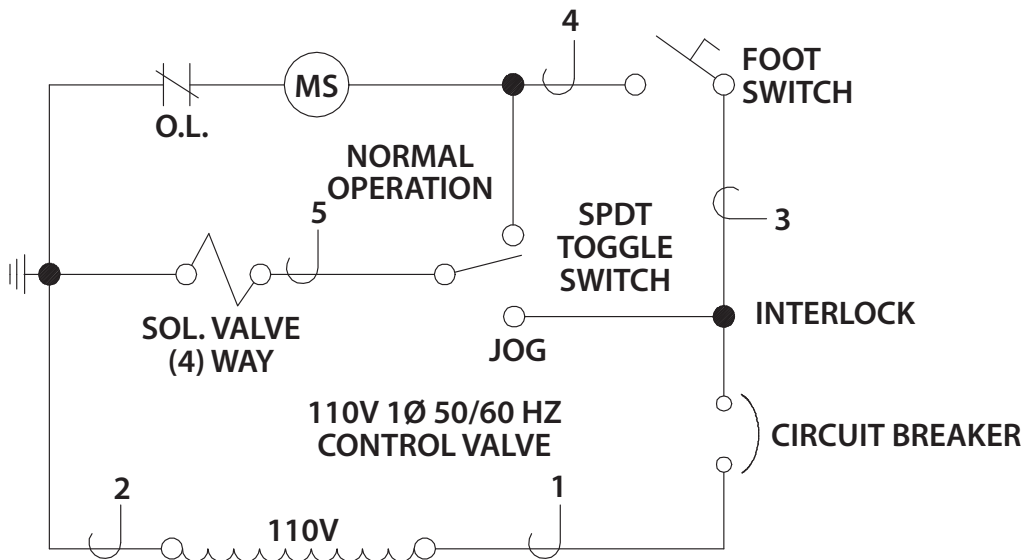
380 VOLT 3 PHASE 50 HZ  
 6.5 AMP FULL LOAD AT 380V  
 5.7 AMP (1.15 S.F.) 380V AT 50HZ

INCOMING POWER MUST BE SHORT  
 CIRCUIT PROTECTED BY BREAKER  
 OR FUSE.

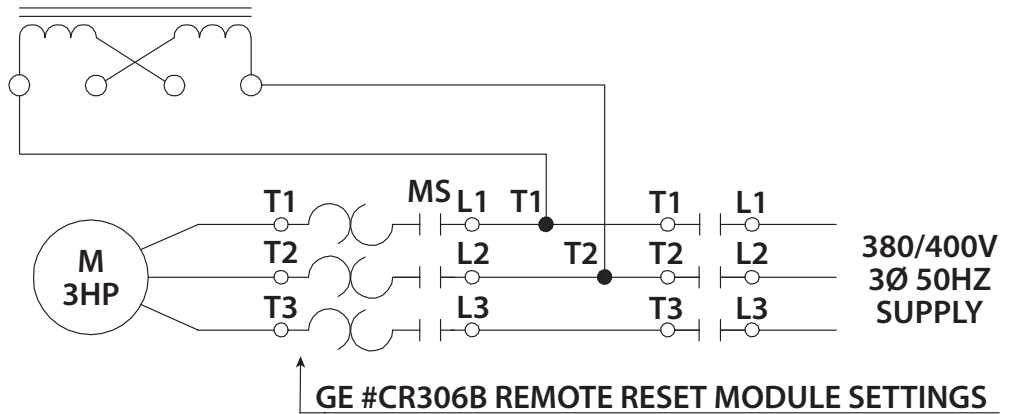
**TRANSFORMER CONNECTIONS**



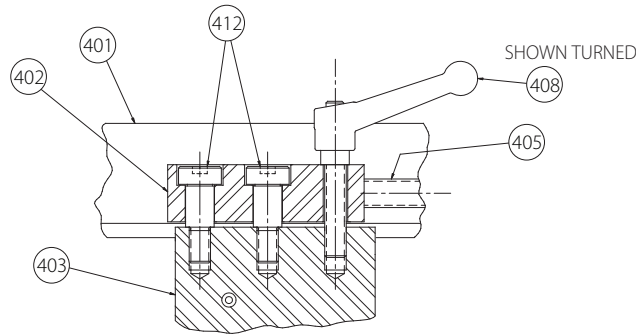
\* This primary fuse jumper is supplied with the primary fuse kit only.  
 \*\* Change primary HV Taps only as required.



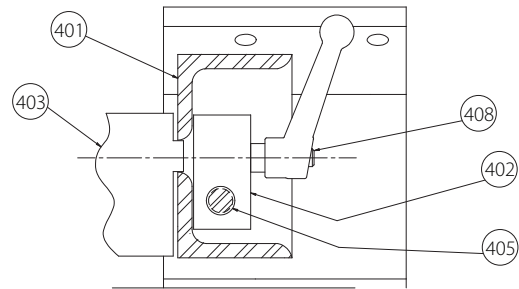
250 VA  
 \*SEE TRANSFORMER  
 CONNECTIONS CHART



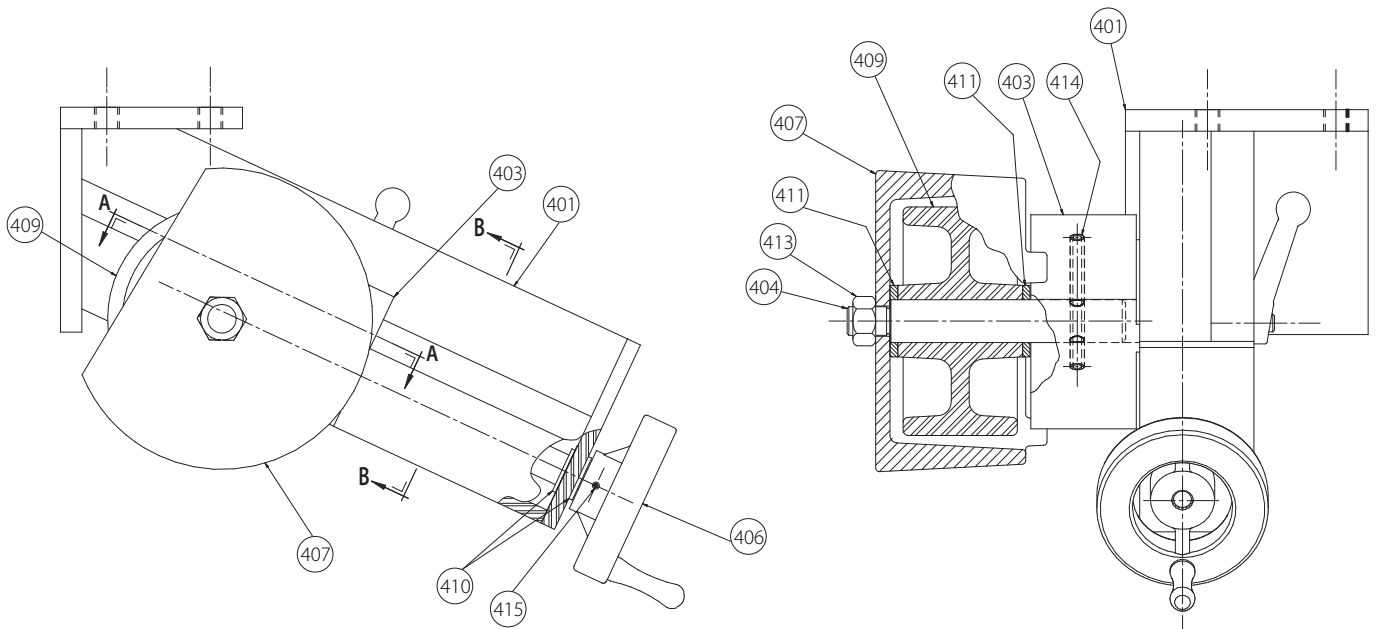
**VE268/VE269 STABILIZER ASSEMBLY**



**SECTION A-A**



**SECTION B-B**



Item #	Part #	Qty.	Description
400	R400274VEO	1	Stabilizer Assembly
401	R4012720FS	1	Stabilizer Body
402	R402416PLT	1	Stabilizer Guide Nut
403	R403416PLT	1	Stabilizer Guide
404	R404416MAC	1	Stabilizer Wheel Shaft
405	R4052720FS	1	Stabilizer Adjustment Screw
406	R406416MAC	1	Stabilizer Handwheel
407	R407416PNT	1	Stabilizer Wheel Guard

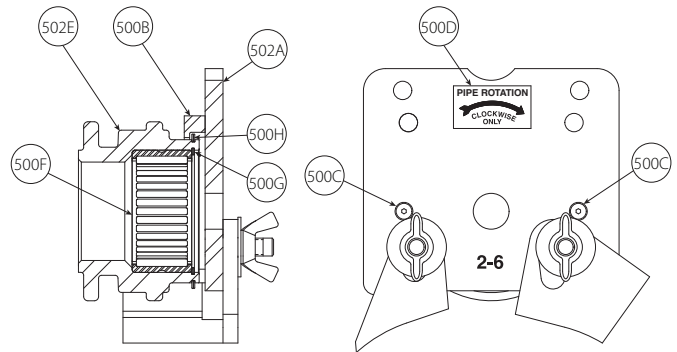
Item #	Part #	Qty.	Description
408	NM04000004	1	Stabilizer Locking Handle Assembly
409	NM05000004	1	4" x 2" Polyurethane Wheel
410	NB05037002	2	Thrust Washer
411	NB05075004	2	Thrust Washer
412	NS05080012	2	½" Dia. x .75" Lg. Socket Hd. Shoulder Bolt, Blk. Ox.
413	NN02080000	1	½ - 20 UNF Hex Nut, Pltd.
414	NP01004208	1	¼" x 2.5" Lg. Roll Pin
415	NP01002102	1	⅛" x 1.125" Lg. Roll Pin

**STANDARD VE268/VE269 UPPER ROLL COVER/GUARD ASSEMBLIES**

**VE268/VE269 UPPER ROLL ASSEMBLY FOR 2 - 6" STEEL PIPE (ITEM 502)**

Item #	Part #	Qty.	Description
502	R9A2272U06	1	Upper Roll Assembly
502A	R510268WLD	1	Upper Roll Guard
500B	R1022720FS	1	Upper Roll Guard Cover Ring
500C	NS09008010	2	#8-32 UNC x 3/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
500D	R040416LAB	1	Pipe Rotation Label #
500F	NB02200001	1	Needle Bearing
500G	NT03000014	1	Snap Ring
500H	NT03000022	1	Snap Ring

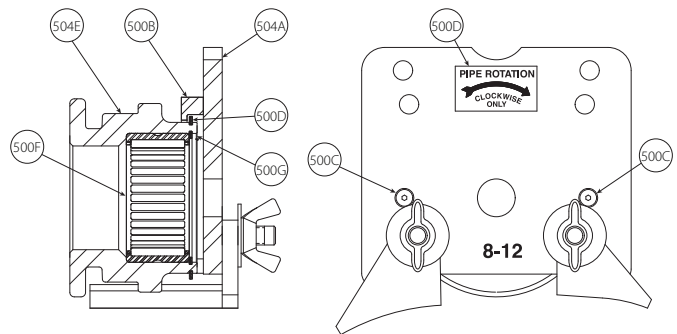
# Refer to pages 20 - 23 for images of product labels



**VE268/VE269 UPPER ROLL ASSEMBLY FOR 8 - 12" STEEL PIPE (ITEM 504)**

Item #	Part #	Qty.	Description
504	R9A8272U12	1	Upper Roll Assembly
504A	R520268WLD	1	Upper Roll Guard
500B	R1022720FS	1	Upper Roll Guard Cover Ring
500C	NS09008010	2	#8-32 UNC x 3/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
500D	R040416LAB	1	Pipe Rotation Label #
500F	NB02200001	1	Needle Bearing
500G	NT03000014	1	Snap Ring
500H	NT03000022	1	Snap Ring

# Refer to pages 20 - 23 for images of product labels

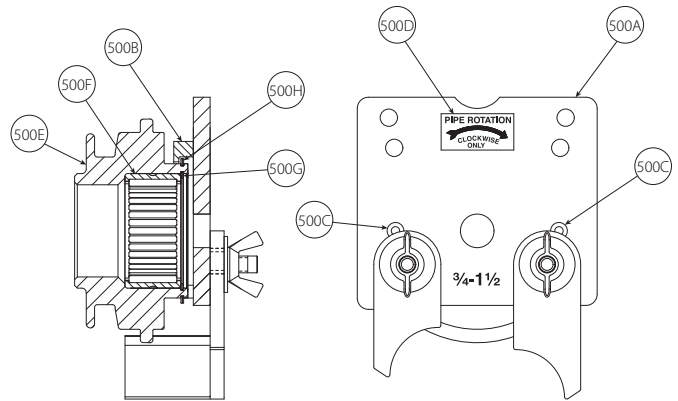


**OPTIONAL VE268/VE269 UPPER ROLL COVER/GUARD ASSEMBLIES**

**VE268/VE269 UPPER ROLL ASSEMBLY FOR 3/4 - 1 1/2" STEEL PIPE (ITEM 500)**

Item #	Part #	Qty.	Description
500	R9A0268U02	1	Upper Roll Assembly
500A	R500268WLD	1	Upper Roll Guard
500B	R1022720FS	1	Upper Roll Guard Cover Ring
500C	NS09008010	2	#8-32 UNC x 3/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
500D	R040416LAB	1	Pipe Rotation Label #
500F	NB02200001	1	Needle Bearing
500G	NT03000014	1	Snap Ring
500H	NT03000022	1	Snap Ring

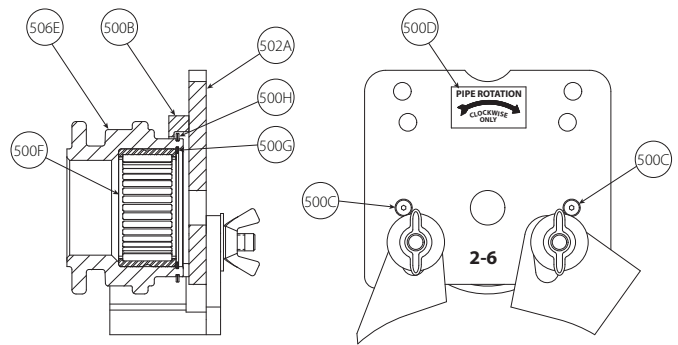
# Refer to pages 20 - 23 for images of product labels



**VE268/VE269 UPPER ROLL ASSEMBLY FOR 2 - 6" SCHEDULES 5S AND 10S STAINLESS STEEL PIPE (ITEM 506)**

Item #	Part #	Qty.	Description
506	RXA2272U06	1	Upper Roll Assembly
502A	R510268WLD	1	Upper Roll Guard
500B	R1022720FS	1	Upper Roll Guard Cover Ring
500C	NS09008010	2	#8-32 UNC x 3/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
500D	R040416LAB	1	Pipe Rotation Label #
500F	NB02200001	1	Needle Bearing
500G	NT03000014	1	Snap Ring
500H	NT03000022	1	Snap Ring
506J	RX02272L03	1	2 - 3 1/2" Lower Roll for Stainless Steel Pipe **
506K	RX04272L06	1	4 - 6" Lower Roll for Stainless Steel Pipe **

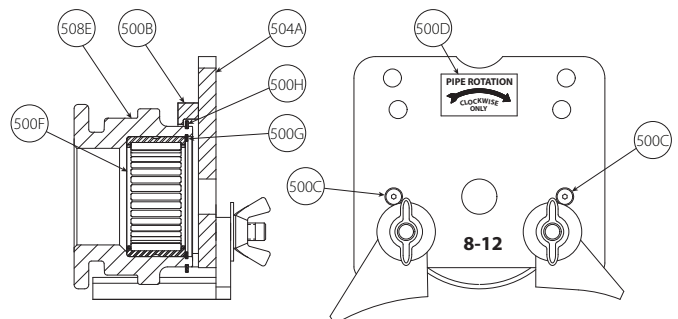
\*\* Not shown  
# Refer to pages 20 - 23 for images of product labels



**VE268/VE269 UPPER ROLL ASSEMBLY FOR 8 - 12" SCHEDULES 5S AND 10S STAINLESS STEEL PIPE (ITEM 508)**

Item #	Part #	Qty.	Description
508	RXA8272U12	1	Upper Roll Assembly
504A	R520268WLD	1	Upper Roll Guard
500B	R1022720FS	1	Upper Roll Guard Cover Ring
500C	NS09008010	2	#8-32 UNC x 3/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
500D	R040416LAB	1	Pipe Rotation Label #
500F	NB02200001	1	Needle Bearing
500G	NT03000014	1	Snap Ring
500H	NT03000022	1	Snap Ring
508J	RX08272L12	1	8 - 12" Lower Roll for Stainless Steel Pipe **

\*\* Not shown

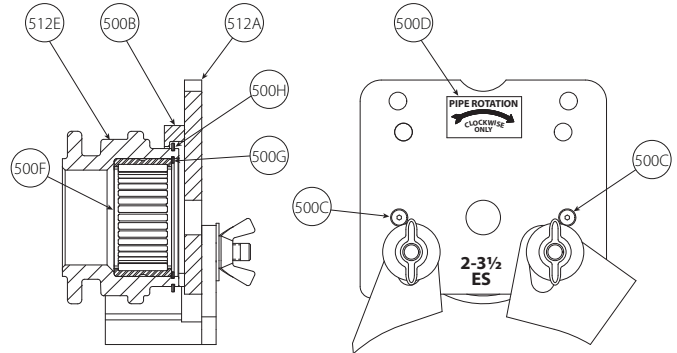


**OPTIONAL VE268/VE269 UPPER ROLL COVER/GUARD ASSEMBLIES**

**VE268/VE269 UPPER ROLL ASSEMBLY FOR 2 - 3 1/2" PIPE FOR ENDSEAL® PRODUCTS (ITEM 512)**

Item #	Part #	Qty.	Description
512	RZA2272U03	1	Upper Roll Assembly
512A	RZ00268WLD	1	Upper Roll Guard
500B	R1022720FS	1	Upper Roll Guard Cover Ring
500C	NS09008010	2	#8-32 UNC x 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
500D	R040416LAB	1	Pipe Rotation Label #
500F	NB02200001	1	Needle Bearing
500G	NT03000014	1	Snap Ring
500H	NT03000022	1	Snap Ring
512J	RZ02272L03	1	2" - 3 1/2" Lower Roll for EndSeal® Pipe **

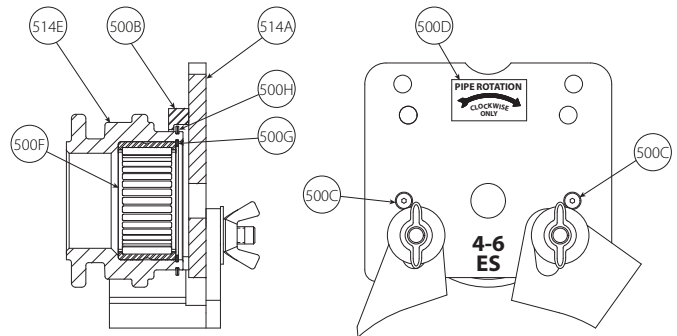
\*\* Not shown  
# Refer to pages 20 - 23 for images of product labels



**VE268/VE269 UPPER ROLL ASSEMBLY FOR 4 - 6" PIPE FOR ENDSEAL® PRODUCTS (ITEM 514)**

Item #	Part #	Qty.	Description
514	RZA4272U06	1	Upper Roll Assembly
514A	RZ10268WLD	1	Upper Roll Guard
500B	R1022720FS	1	Upper Roll Guard Cover Ring
500C	NS09008010	2	#8-32 UNC x 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
500D	R040416LAB	1	Pipe Rotation Label #
500F	NB02200001	1	Needle Bearing
500G	NT03000014	1	Snap Ring
500H	NT03000022	1	Snap Ring
514J	RZ04272L06	1	4" - 6" Lower Roll for EndSeal® Pipe **

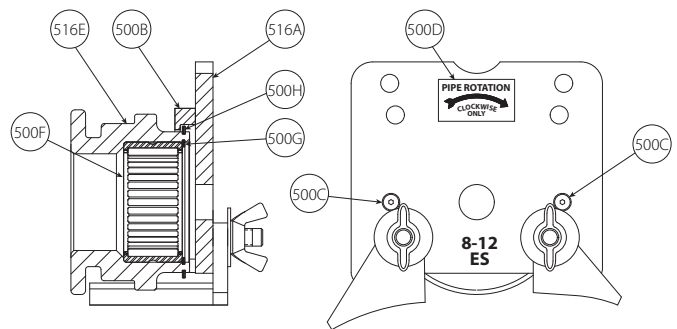
\*\* Not shown  
# Refer to pages 20 - 23 for images of product labels



**VE268/VE269 UPPER ROLL ASSEMBLY FOR 8 - 12" PIPE FOR ENDSEAL® PRODUCTS (ITEM 516)**

Item #	Part #	Qty.	Description
516	RZA8272U12	1	Upper Roll Assembly
516A	RZ20268WLD	1	Upper Roll Guard
500B	R1022720FS	1	Upper Roll Guard Cover Ring
500C	NS09008010	2	#8-32 UNC x 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
500D	R040416LAB	1	Pipe Rotation Label #
500F	NB02200001	1	Needle Bearing
500G	NT03000014	1	Snap Ring
500H	NT03000022	1	Snap Ring
516J	RZ08272L12	1	8" - 12" Lower Roll for EndSeal® Pipe **

\*\* Not shown  
# Refer to pages 20 - 23 for images of product labels

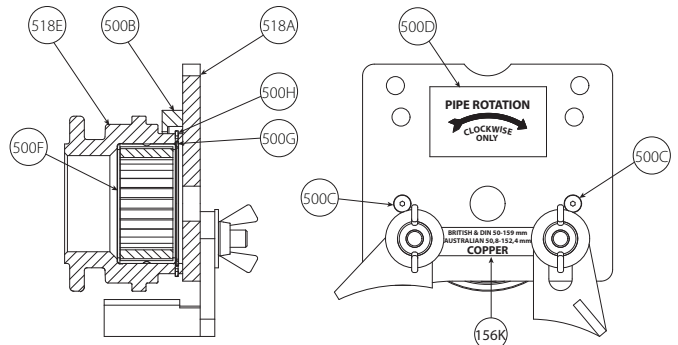


**OPTIONAL VE268/VE269 UPPER ROLL COVER/GUARD ASSEMBLIES**

**VE268/VE269 UPPER ROLL ASSEMBLY FOR 50.8 - 152.4 MM AUSTRALIAN AND 50 - 159 MM BRITISH/DIN COPPER TUBING (ITEM 518)**

Item #	Part #	Qty.	Description
518	RRE1272U06	1	Upper Roll Assembly
518A	RR00268WLD	1	Upper Roll Guard
500B	R1022720FS	1	Upper Roll Guard Cover Ring
500C	NS09008010	2	#8-32 UNC x 3/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
500D	R040416LAB	1	Pipe Rotation Label #
500F	NB02200001	1	Needle Bearing
500G	NT03000014	1	Snap Ring
500H	NT03000022	1	Snap Ring
518J	RRE1272L06	1	Lower Roll for Copper Pipe **
518K	R157272LBL	1	Roll Guard Cover Label (Export) #

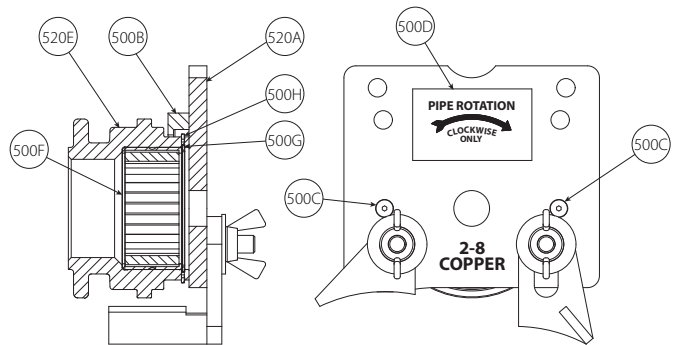
\*\* Not shown  
# Refer to pages 20 - 23 for images of product labels



**VE268/VE269 UPPER ROLL ASSEMBLY FOR 2 - 8" COPPER TUBING (ITEM 520)**

Item #	Part #	Qty.	Description
520	RRA2272U08	1	Upper Roll Assembly
520A	RR00268WLD	1	Upper Roll Guard
500B	R1022720FS	1	Upper Roll Guard Cover Ring
500C	NS09008010	2	#8-32 UNC x 3/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
500D	R040416LAB	1	Pipe Rotation Label #
500F	NB02200001	1	Needle Bearing
500G	NT03000014	1	Snap Ring
500H	NT03000022	1	Snap Ring
520J	RR02272L06	1	2 - 6" Lower Roll for Copper Pipe **
520K	RR08272L08	1	8" Lower Roll for Copper Pipe **

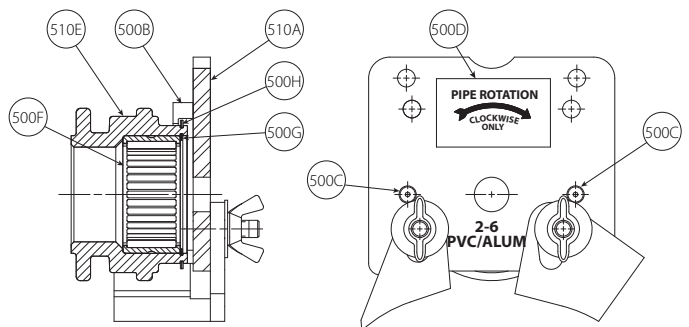
\*\* Not shown  
# Refer to pages 20 - 23 for images of product labels



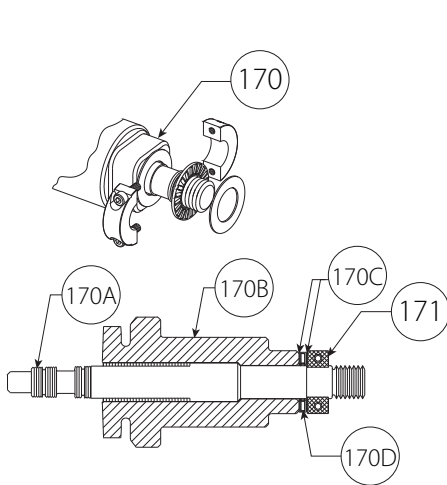
**VE268/VE269 UPPER ROLL ASSEMBLY FOR 2 - 6" PVC AND ALUMINUM PIPE (ITEM 510)**

Item #	Part #	Qty.	Description
510	RPA2272U06	1	Upper Roll Assembly
510A	R530268WLD	1	Upper Roll Guard
500B	R1022720FS	1	Upper Roll Guard Cover Ring
500C	NS09008010	2	#8-32 UNC x 3/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
500D	R040416LAB	1	Pipe Rotation Label #
500F	NB02200001	1	Needle Bearing
500G	NT03000014	1	Snap Ring
500H	NT03000022	1	Snap Ring

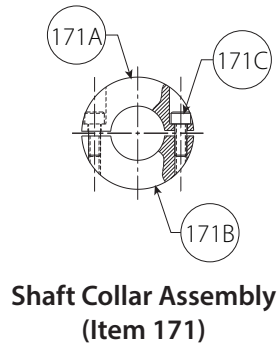
# Refer to pages 20 - 23 for images of product labels



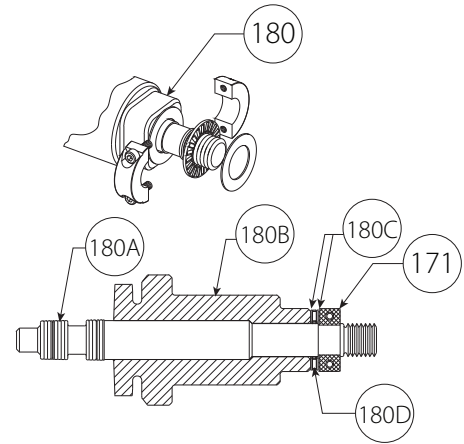
**OPTIONAL VE268/VE269 ARBOR ASSEMBLIES**



**Arbor Assembly for 3/4" Pipe  
(Item 170)**



**Shaft Collar Assembly  
(Item 171)**



**Arbor Assembly for 1 - 1 1/2" Pipe  
(Item 180)**

**SHAFT COLLAR ASSEMBLY**

Item #	Part #	Qty.	Description
171	R173268ASY	1	Shaft Collar Assembly **
171A	R171268MCH	1	Shaft Collar – Top *
171B	R172268MCH	1	Shaft Collar – Bottom *
171C	NS03006006	2	#6–32 UNC x 3/8" Lg. SHCS, Blk. Ox. *

\* Included in assembly. Not available for individual sale.  
\*\* Indicates additional items required or recommended when ordering.

**ARBOR ASSEMBLY FOR 1 - 1 1/2" PIPE**

Item #	Part #	Qty.	Description
180	R901268LA2	1	Arbor Assembly for 1 - 1 1/2" Pipe **
180A	R901268LA2	1	Lower Roll for 1 - 1 1/2" Pipe
-	RX01268LA2	1	Lower Roll for 1 - 1 1/2" Stainless Steel Pipe
180B	R900268A02	1	Lower Roll Adapter
180C	NM30000005	2	0.031 Thk. x 0.750 Bore Special Flat Washer
180D	NB03750001	1	0.750 Bore Needle Thrust Bearing

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

**ARBOR ASSEMBLY FOR 3/4" PIPE**

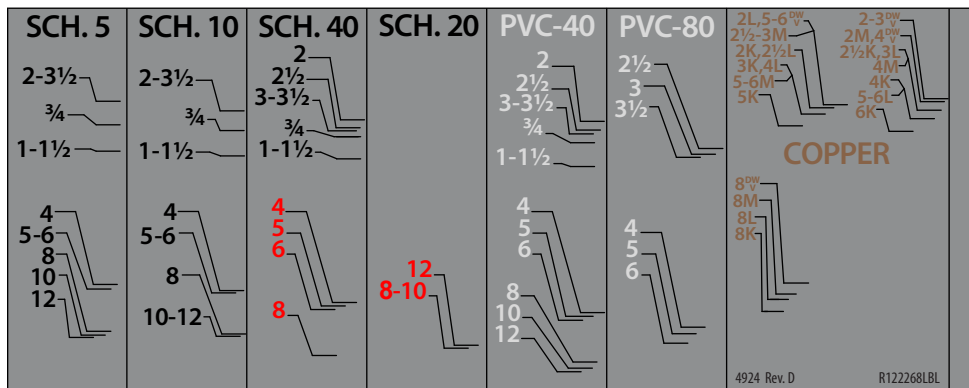
Item #	Part #	Qty.	Description
170	R9A0268L01	1	Arbor Assembly for 3/4" Pipe **
170A	R900268LA1	1	Lower Roll for 3/4" Pipe
-	R900268LA1	1	Lower Roll for 3/4" Stainless Steel Pipe
170B	R900268A02	1	Lower Roll Adapter
170C	NM30000005	2	0.031 Thk. x 0.750 Bore Special Flat Washer
170D	NB03750001	1	0.750 Bore Needle Thrust Bearing

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

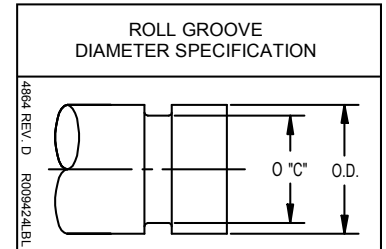


IMAGES OF THE LABELS ON PAGES 25 - 28 ARE NOT TO SCALE.

**R122268LBL**

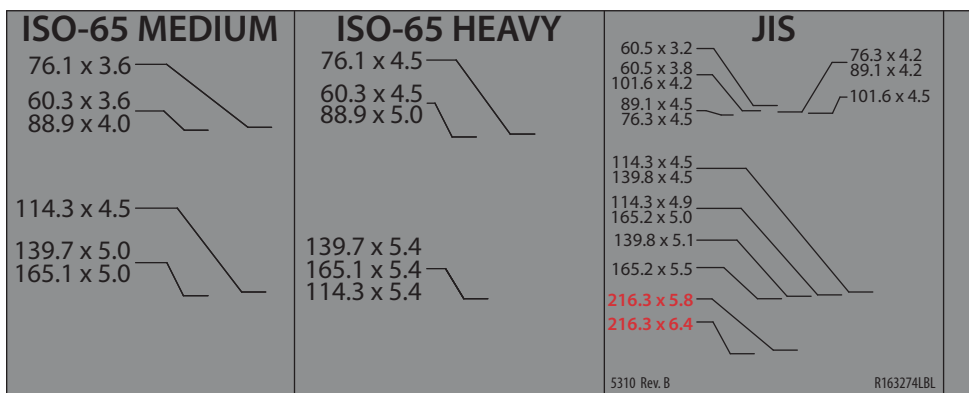


**R009424LBL**

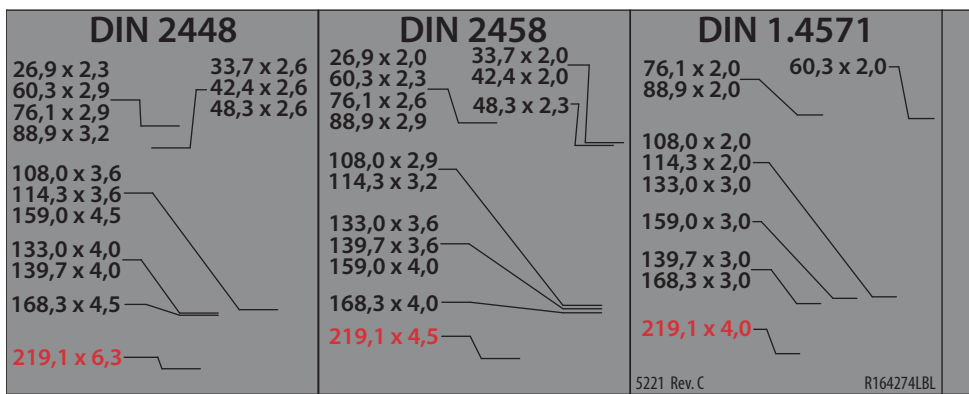


SIZE	O.D.		Ø "C"	
	MAXIMUM	MINIMUM	MAXIMUM	MINIMUM
3/4 [26,9]	1.060 [26,9]	1.040 [26,4]	.938 [23,8]	.923 [23,4]
1 [33,7]	1.328 [33,7]	1.302 [33,1]	1.190 [30,2]	1.175 [29,9]
1 1/4 [42,4]	1.676 [42,6]	1.644 [41,8]	1.535 [39,0]	1.520 [38,6]
1 1/2 [48,3]	1.919 [48,7]	1.881 [47,8]	1.775 [45,1]	1.760 [44,7]
2 [60,3]	2.399 [60,9]	2.351 [59,7]	2.250 [57,2]	2.235 [56,8]
2 1/2 [73]	2.904 [73,8]	2.846 [72,3]	2.720 [69,1]	2.702 [68,6]
3 [88,9]	3.535 [89,8]	3.469 [88,1]	3.344 [84,9]	3.326 [84,5]
3 1/2 [101,6]	4.040 [102,6]	3.969 [100,8]	3.834 [97,4]	3.814 [96,9]
4 [114,3]	4.545 [115,4]	4.469 [113,5]	4.334 [110,1]	4.314 [109,6]
4 1/2 [127]	5.050 [128,3]	4.969 [126,2]	4.834 [122,8]	4.814 [122,3]
5 [141,3]	5.619 [142,7]	5.532 [140,5]	5.395 [137,0]	5.373 [136,5]
6 [168,3]	6.688 [169,9]	6.594 [167,5]	6.455 [164,0]	6.433 [163,4]
8 [203,2]	8.063 [204,8]	7.969 [202,4]	7.816 [198,5]	7.791 [197,9]
10 [254]	10.063 [255,6]	9.969 [253,2]	9.812 [249,2]	9.785 [248,5]
12 [304,8]	12.063 [306,4]	11.969 [304,0]	11.781 [299,2]	11.751 [298,5]
14 O.D. [354,6]	14.063 [357,2]	13.969 [354,8]	13.781 [350,0]	13.751 [349,3]
16 O.D. [406,4]	16.063 [408,0]	15.969 [405,6]	15.781 [400,8]	15.751 [400,1]
18 O.D. [457]	18.063 [458,8]	17.969 [456,4]	17.781 [451,6]	17.751 [450,9]
20 O.D. [508]	20.063 [509,6]	19.969 [507,2]	19.781 [502,4]	19.751 [501,7]
22 O.D. [559]	22.063 [560,4]	21.969 [558,0]	21.656 [550,1]	21.626 [549,3]
24 O.D. [610]	24.063 [611,2]	23.969 [608,8]	23.656 [600,9]	23.626 [600,1]
26 O.D. [660]	26.093 [662,8]	25.969 [659,6]	25.500 [647,7]	25.437 [646,1]
28 O.D. [711]	28.093 [713,6]	27.969 [710,4]	27.500 [698,5]	27.437 [696,9]
30 O.D. [762]	30.093 [764,4]	29.969 [761,2]	29.500 [749,3]	29.437 [747,7]
32 O.D. [813]	32.093 [815,2]	31.969 [812,0]	31.500 [800,1]	31.437 [798,5]
36 O.D. [914]	36.093 [916,8]	35.969 [913,6]	35.500 [901,7]	35.437 [900,1]
42 O.D. [1067]	42.093 [1069,2]	41.969 [1066,0]	41.500 [1054,1]	41.437 [1052,5]
48 O.D. [1219]	48.093 [1221,6]	47.969 [1218,4]	47.500 [1206,5]	47.437 [1204,9]

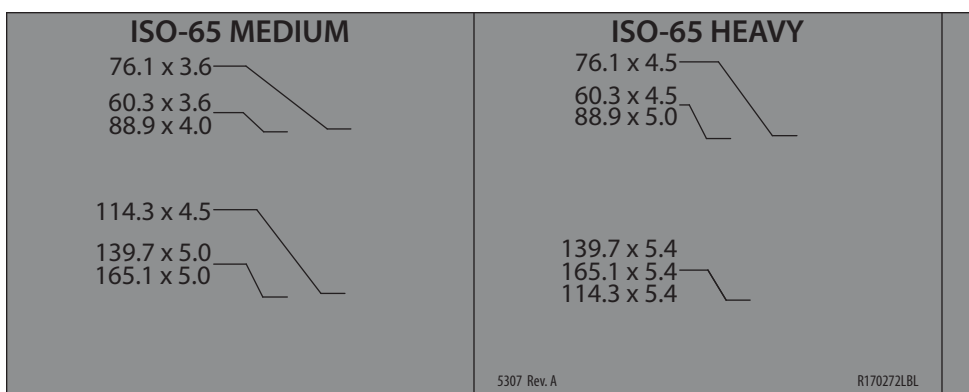
**R163274LBL**



**R164274LBL**



**R170272LBL**



R010416LAB

PIPE SIZE		SCHEDULE											PIPE SIZE		SCHEDULE										
O.D.		5	10	20	30	40	STD	80	XStrg.	O.D.		5	10	20	30	40	STD	80	XStrg.						
3/4	1.050	.065	.083	-	-	.113	.113	.154	.154	26	26.000	-.312	.500	-	-	.375	-	.500							
1	1.315	.065	.109	-	-	.133	.133	.179	.179	28	28.000	-.312	.500	.625	-	.375	-	.500							
1 1/4	1.660	.065	.109	-	-	.140	.140	.191	.191	30	30.000	-.312	.500	.625	-	.375	-	.500							
1 1/2	1.900	.065	.109	-	-	.145	.145	.200	.200	32	32.000	-.312	.500	.625	.688	.375	-	.500							
2	2.375	.065	.109	-	-	.154	.154	.218	.218	36	36.000	-.312	.500	.625	.750	.375	-	.500							
2 1/2	2.875	.083	.120	-	-	.203	.203	.267	.267	38	38.000	-	-	-	-	.375	-	.500							
3	3.500	.083	.120	-	-	.216	.216	.300	.300	40	40.000	-	-	-	-	.375	-	.500							
3 1/2	4.000	.083	.120	-	-	.226	.226	.318	.318	42	42.000	-	-	-	-	.375	-	.500							
4	4.500	.083	.120	-	-	.237	.237	.337	.337	44	44.000	-	-	-	-	.375	-	.500							
5	5.563	.109	.134	-	-	.258	.258	.375	.375	46	46.000	-	-	-	-	.375	-	.500							
6	6.625	.109	.134	-	-	.280	.280	.432	.432	48	48.000	-	-	-	-	.375	-	.500							
8	8.625	.109	.148	.250	.277	.322	.322	.500	.500	52	52.000	-	-	-	-	.375	-	.500							
10	10.750	.134	.165	.250	.307	.365	.365	.593	.500	54	54.000	-	-	-	-	.375	-	.500							
12	12.750	.165	.180	.250	.330	.406	.375	.687	.500	56	56.000	-	-	-	-	.375	-	.500							
14	14.000	-	.250	.312	.375	.437	.375	.750	.500	60	60.000	-	-	-	-	.375	-	.500							
16	16.000	-	.250	.312	.375	.500	.375	.843	.500	64	64.000	-	-	-	-	.375	-	.500							
18	18.000	-	.250	.312	.437	.562	.375	.937	.500	68	68.000	-	-	-	-	.375	-	.500							
20	20.000	-	.250	.375	.500	.593	.375	1.031	.500	72	72.000	-	-	-	-	.375	-	.500							
24	24.000	-	.250	.375	.562	.687	.375	1.281	.500																

R070260VE0

### COPPER ROLL GROOVE DIAMETER SPECIFICATION

SIZE	O.D.		Ø "C"	
	MAXIMUM	MINIMUM	MAXIMUM	MINIMUM
2 [54,0]	2.127 [54,0]	2.123 [53,9]	2.029 [51,5]	2.009 [51,0]
2 1/2 [66,7]	2.627 [66,7]	2.623 [66,6]	2.525 [64,1]	2.505 [63,6]
3 [79,4]	3.127 [79,4]	3.123 [79,3]	3.025 [76,8]	3.005 [76,3]
4 [104,8]	4.127 [104,8]	4.123 [104,7]	4.019 [102,1]	3.999 [101,6]
5 [130,2]	5.127 [130,2]	5.123 [130,1]	4.999 [127,0]	4.979 [126,5]
6 [155,6]	6.127 [155,6]	6.123 [155,5]	5.999 [152,3]	5.979 [151,9]
8 [206,4]	8.127 [206,4]	8.121 [206,3]	7.959 [202,2]	7.939 [201,7]

**-IMPORTANT-**

USE ONLY VICTAULIC GROOVING ROLLS DESIGNED FOR COPPER TUBING (COLOR CODED COPPER)

GROOVE COPPER TUBING AT A MODERATE RATE BY UNIFORMLY FORMING GROOVES IN 5 TO 10 TUBE ROTATIONS. FORMING GROOVES AT FASTER RATES CAN RESULT IN POOR GROOVE SHARPNESS AND JOINT FAILURE.

R064268LBL

3/4 - 1 1/2 SHAFT

TIGHTEN LOOSEN

2 - 12 SHAFT

LOOSEN TIGHTEN

R040416LAB

**PIPE ROTATION**

CLOCKWISE ONLY

3318 Rev. D R040416LAB

R034272LAB

← INCREASE DECREASE →

GROOVE DIAMETER

487 Rev. 5 R034272LAB

R020260LBL

SET TO COLOR ON GROOVE DEPTH SCALE

4913 Rev. B R020260LBL

R031272LAB

**WARNING**

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

- Before operating or servicing any pipe preparation tools, read all instructions in the Operating and Maintenance Instructions Manual and all labels on the tool.
- Wear safety glasses, hardhat, foot protection, and hearing protection when working around tools.

If you need additional copies of any literature, or if you have questions concerning the safe and proper operation of any pipe preparation tools, contact Victaulic, P.O. Box 31, Easton, PA 18044-0031, Phone 1-800-PICK VIC, E-Mail: pickvic@victaulic.com.

0567 Rev. D R031272LAB

R207264LBL


Pipe and groove features, noted below, must be measured to verify they are within current Victaulic specifications. Victaulic submittal publications can be downloaded at [www.victaulic.com](http://www.victaulic.com).

Measure Prior to Grooving Measure After Grooving

OD= Average Pipe Outside Diameter  
T = Pipe Wall Thickness  
A = Distance from Pipe End to Groove  
B = Groove Width  
C = Average Diameter at Base of Groove  
D = Groove Depth  
F = Pipe-End Flare

7264 Rev. A R207264LBL

R511921LBL

**VE268** 

SERIAL NO.  DATE MFD.

VOLTS	PHASE	HERTZ	FULL-LOAD CURRENT
230	3	60	11.5 AMPS
460	3	60	6.5 AMPS

**DRIVE MOTOR:**

VOLTS	PHASE	HERTZ	FULL-LOAD CURRENT
230	3	60	8.8 AMPS
460	3	60	4.4 AMPS

**SHORT CIRCUIT INTERRUPTING CAPACITY 5,000 AMPS**

- GEAR OIL – AGMA 7
- HYDRAULIC OIL – HIGH-PRESSURE, ANTI-WEAR ISO GRADE 32
- BEARING LUBE – ANTI-WEAR, EXTREME PRESSURE NLGI GRADE 2


ELECTRICAL ASSEMBLY DWG. R-301-268-SCH REVISION LEVEL

CE  Victaulic Company World Headquarters  
4901 Kesslersville Road • Easton, PA 18040  
victaulic.com

Manufactured in Canada

1192 Rev. B R511921LBL

R511921LBL

**VE269** 

SERIAL NO.  DATE MFD.

VOLTS	PHASE	HERTZ	FULL-LOAD CURRENT
380	3	50	10.6 AMPS
415	3	50	9.7 AMPS

**DRIVE MOTOR:**

VOLTS	PHASE	HERTZ	FULL-LOAD CURRENT
380	3	50	8.0 AMPS
415	3	50	7.4 AMPS

**SHORT CIRCUIT INTERRUPTING CAPACITY 5,000 AMPS**

- GEAR OIL – AGMA 7
- HYDRAULIC OIL – HIGH-PRESSURE, ANTI-WEAR ISO GRADE 32
- BEARING LUBE – ANTI-WEAR, EXTREME PRESSURE NLGI GRADE 2

ELECTRICAL ASSEMBLY DWG. R-301-269-SCH REVISION LEVEL

CE  Victaulic Company World Headquarters  
4901 Kesslersville Road • Easton, PA 18040  
victaulic.com

Manufactured in Canada


1192 Rev. B R511921LBL

R090424LAB

**⚠ DANGER**

Contact with hazardous voltage inside this door may result in death or serious personal injury.

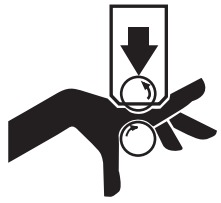
- ALWAYS disconnect the tool from the power source before performing maintenance or adjustments.
- Only qualified personnel should open this door.



5038 Rev. B R090424LAB

R033274LBL

**⚠ WARNING**



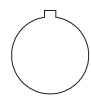
Grooving rolls can crush or cut fingers and hands.

- Be sure guard is properly adjusted before grooving pipe.
- Keep hands away from grooving rolls and stabilizer wheel.
- Never reach inside pipe end or across the tool or pipe during operation.
- Always groove pipe in a clockwise direction only.
- Never groove pipe shorter than what is recommended.
- Never wear loose clothing, loose gloves, or jewelry while operating tool.


2246 Rev. A 2/98 R033274LBL

R011920LBL

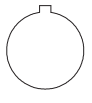
ENABLE





**VE268/VE269**



NORMAL JOG



11920 Rev. E R011920LBL

VE268 and VE269 Roll Grooving Tools

R157272LBL

**BRITISH & DIN 50 – 159 mm**  
**AUSTRALIAN 50,8 – 152,4 MM**

3373 Rev.A 11/01 R157272LBL

R023268LBL

**VE268 SERIES**



5448 Rev. B R023268LBL

R023269LBL

**VE269 SERIES**



2736 Rev. B R023269LBL

R055260LBL



4914 Rev. B R055260LBL