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**VE270FSD and VE271FSD Roll Grooving Tools**

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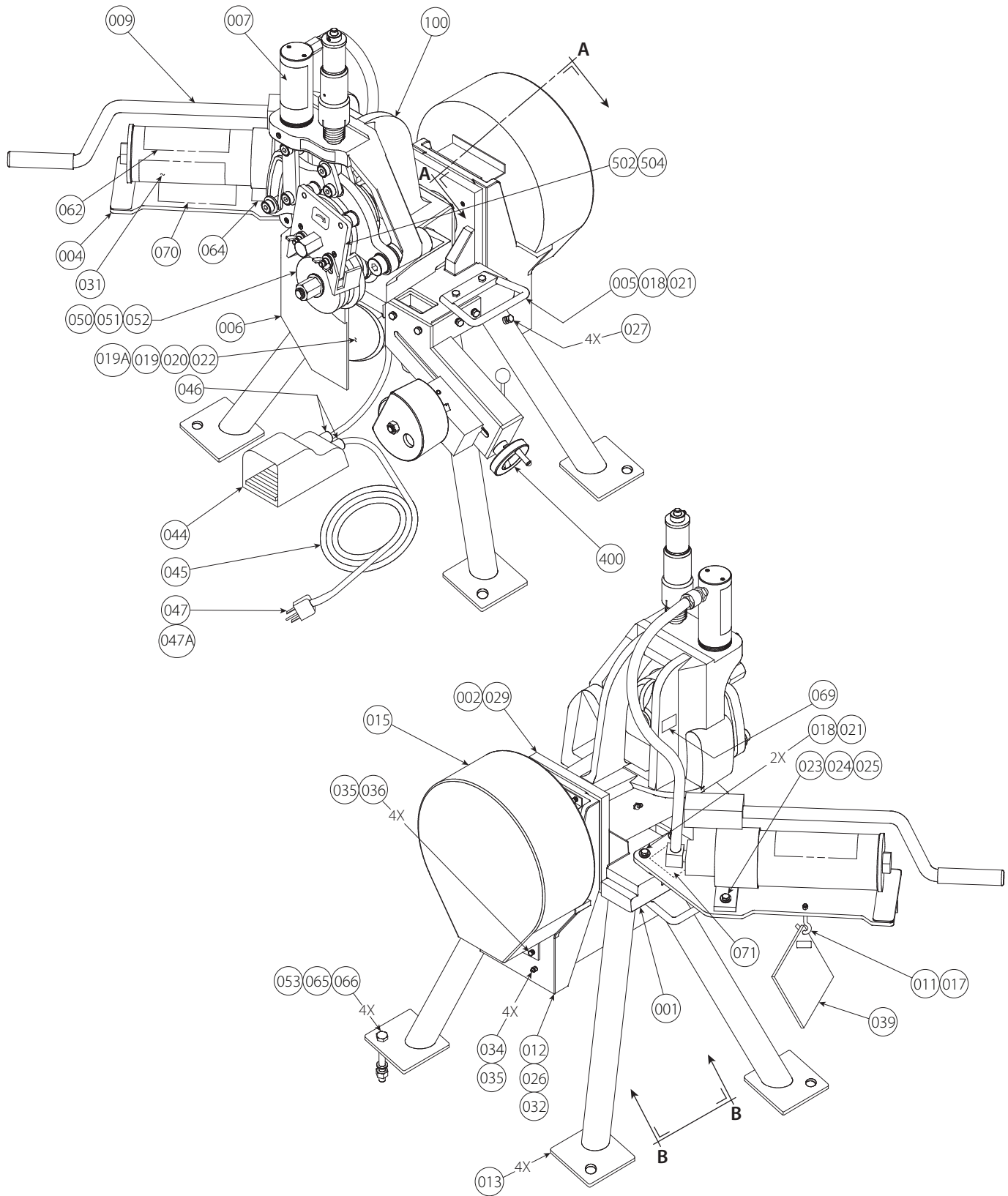
**PARTS ORDERING INFORMATION**

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

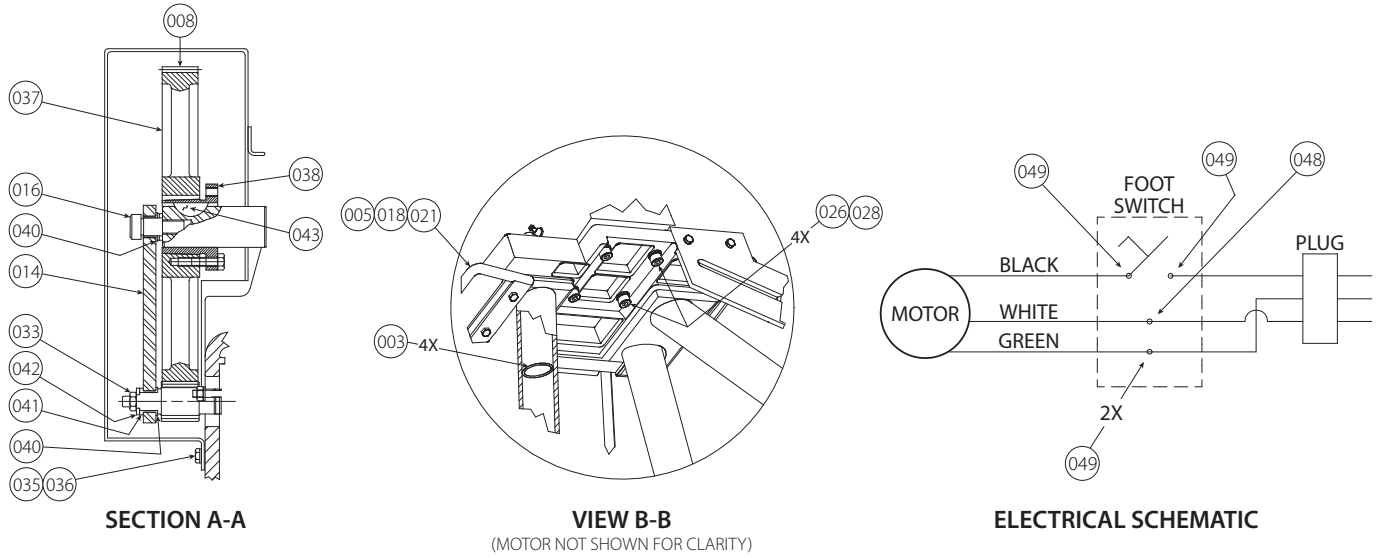
1. Tool Model Number – VE270FSD or VE271FSD
2. Tool Serial Number – The Serial Number can be found on the side of the tool.
3. Quantity, Item Number, Part Number, Description
4. Where to send the part(s) – Company Name and Address
5. To whose attention to send the part(s)
6. Purchase Order Number

Parts may be ordered from your nearest Victaulic Sales Office.

MAIN ASSEMBLY



**MAIN ASSEMBLY (CONTINUED)**

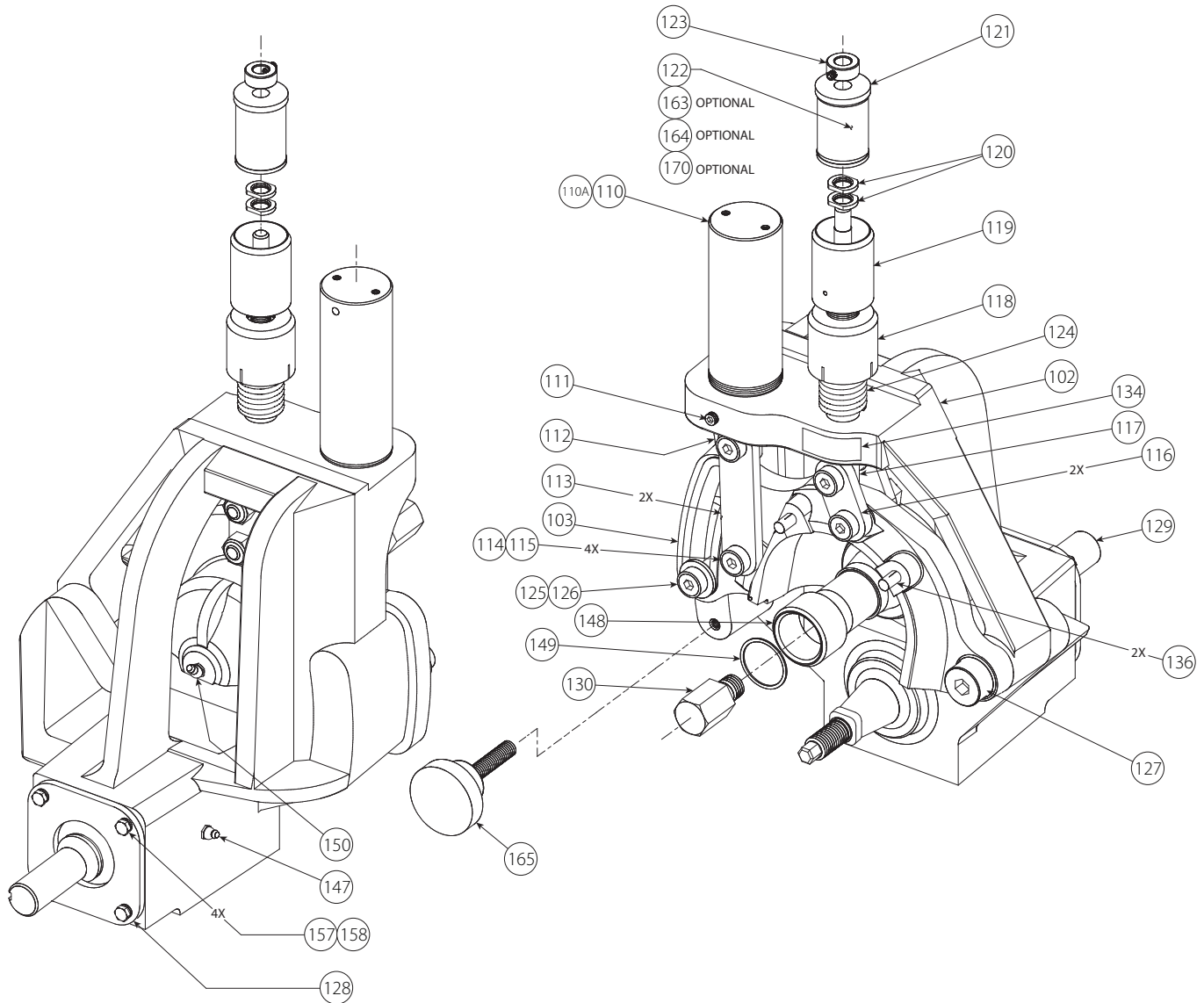


Item#	Part #	Qty.	Description
001	R-001-276-MCH	1	Table
002	R-004-276-MCH	1	Vertical Plate
003	R-003-416-PLT	4	Upper Leg
004	R-004-272-PLT	1	Pump Bracket **
005	R-005-272-PLT	2	Base Handle
006	R-006-276-PNT	1	Guard
007	R-033-274-LBL	1	Roll Warning Label#
008	-	As Req.	Lubriplate Gear Shield Heavy (Spray)
009	R-201-261-OFS	1	Hydraulic Hand Pump Assembly **
011	N-540-040-000	1	¼" Hook Bolt with Nut, ¼ - 20 UNC x 2.625 Lg., Pltd.
012	R-012-417-MAC	1	Motor Mounting Bracket
013	R-013-417-PLT	4	Lower Leg
014	R-014-417-PLT	1	Tie Bar **
015	R-015-417-PNT	1	Gear Guard
016	N-S05-100-012	1	.625 x .75 Lg. Shoulder Bolt, Blk. Ox.
017	N-N01-040-000	1	¼ - 20 UNC Hex Nut, Pltd.
018	N-S01-060-100	6	¾ - 16 UNC x 1.00 Lg. Hex Hd. Screw, Pltd.
019	R-019-416-FSD	1	Gearmotor , 110 Volt**
019A	R-19A-416-FSD	1	220 Volt, Single Phase
020	R-020-417-FSD	1	Gearmotor Filter
021	N-W01-060-000	6	¾" Flat Washer, Pltd.
022	R-022-417-LAB	1	Gear Motor Label - 120 Volt#
022A	R-22E-416-FSD	1	Gear Motor Label - 220 Volt#
023	N-S01-050-108	2	⅝ - 18 UNC x 1.50 Lg. Hex Hd. Screw, Pltd.
024	N-W01-050-000	4	⅝" Flat Washer, Pltd.
025	N-N01-050-000	2	⅝ - 18 UNC Hex Nut, Pltd.
026	N-W03-060-000	8	¾" Lock Washer, Pltd.
027	N-S01-050-012	4	⅝ - 18 UNC x .75 Lg. Grd. 5 Hex Hd. Cap Screw, Pltd.
028	N-S03-060-200	4	¾ - 16 UNC x 2.00 Lg. Socket Hd. Cap Screw, Blk. Ox.
029	N-S03-060-100	6	¾ - 16 UNC x 1.00 Lg. Socket Hd. Cap Screw, Blk. Ox.
031	R-031-272-LAB	1	Instructions Warning Label#
032	N-S01-060-104	4	¾ - 16 UNC x 1.25 Lg. Hex Hd. Cap Screw, Pltd.
033	N-N05-060-000	1	¾ - 16 UNC Thin Elastic Locknut
034	N-N02-040-000	4	¼ - 28 UNF Hex Nut, Pltd.
035	N-W03-040-000	8	¼" Lock Washer, Pltd.
036	N-S01-040-010	4	¼ - 20 UNC x .63 Lg. Hex Hd. Cap Screw, Pltd.
037	R-037-417-MAC	1	Spur Gear **
038	N-M38-000-001	1	P1 Bushing with .375 Wide Keyway

Item#	Part #	Qty.	Description
039	R-039-272-OFS	1	Guard Setting Pad Assembly
040	N-B21-062-001	2	Flange Bushing
041	N-B22-062-001	1	Thrust Bushing
042	N-B40-048-001	1	Tongued Washer
043	N-K01-121-000	1	#1210 Woodruff Key
044	N-E03-000-002	1	Footswitch
045	N-E04-000-011	1	15' Ext. Cord
046	N-E06-000-001	2	Cord Grip Connector
047	N-E08-000-003	1	Plug, 120 Volt
047A	-	1	Plug, 220 Volt
048	-	1	Wire Nut
049	-	4	#RB 14-18 Fork Wire Terminal
050	R-902-272-L03	1	Lower Roll for 2 - 3½" Steel Pipe
051	R-904-272-L06	1	Lower Roll for 4 - 6" Steel Pipe
052	R-908-272-L12	1	Lower Roll for 8 - 12" Steel Pipe
053	N-W03-080-000	4	½" Lock Washer, Pltd.
062	R-062-260-LBL	1	Hydraulic Hand Pump Label#
064	R-064-268-LBL	1	Tightening Direction Label#
065	N-N01-080-000	4	½ - 13 UNC Std. Hex Nut, Pltd.
066	N-S01-080-204	4	½ - 13 UNC -2A x 2.25 Lg. Hex Hd. Cap Screw, Pltd.
069	R-069-272-LAB	1	Name Plate#
070	R-009-424-LBL	1	"C" Diameter Label for Standard Pipe#
071	R-207-264-LBL	1	Groove Profile Information Label#
100	-	1	Tool Head Assembly
190	R-190-272-ASY	1	Arbor Assembly for 2 - 12" Pipe ***
400	R-400-276-FSD	1	Stabilizer Assembly
502	R-9A2-272-U06	1	Upper Roll Assembly for 2 - 6" Steel Pipe *
504	R-9A8-272-U12	1	Upper Roll Assembly for 8 - 12" Steel Pipe *
505	R-512-260-VE0	1	Lower Roll Removal Tool (Not Shown)

\* Standard. Refer to pages 5 - 7 for optional upper roll cover/guard assemblies for grooving ¾ - 1½" pipe sizes and other pipe materials.  
 \*\* Indicates additional items required or recommended when ordering.  
 \*\*\* Standard, not shown. Refer to page 9 for optional arbor assemblies for grooving ¾" and 1 - 1½" pipe sizes.  
 # Refer to pages 13 - 15 for images of product labels

**TOOL HEAD ASSEMBLY**

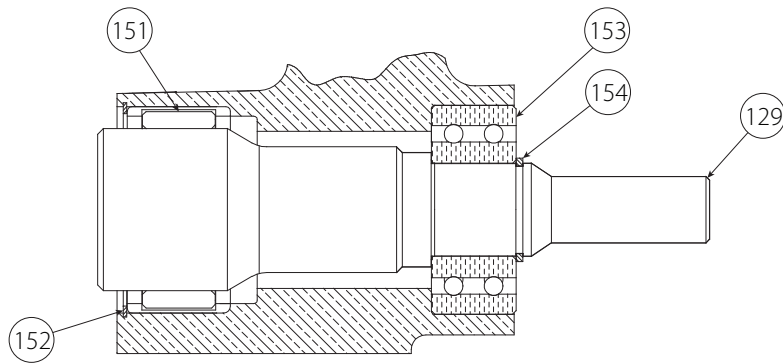


Item#	Part #	Qty.	Description
102	R-002-272-0FS	1	Body **
103	R-003-268-MCH	1	Arm **
110	N-H01-000-008	1	Cylinder **
110A	N-H50-000-001	1	Cylinder Repair Kit
111	N-S80-060-008	1	3/8 - 16 UNC x 1/2" Lg. Brass Tip Set Screw
112	R-012-272-0FS	1	Cylinder Adapter
113	R-013-272-0FS	2	Link, Cylinder to Arm
114	N-S05-100-110	4	.625 x 1.63 Lg. Socket Hd. Shoulder Screw, Blk. Ox.
115	N-N08-080-000	4	1/2 - 13 UNC Heavy Hex Nylon Insert Locking Nut, Pltd.
116	R-116-268-PLT	2	Link, Depth Adjuster to Arm
117	R-017-272-0FS	1	Shaft, Depth Adjuster
118	R-018-272-0FS	1	Depth Adjuster Lock
119	R-019-272-0FS	1	Depth Adjuster
120	R-020-272-0FS	2	Pipe Size Indicator Calibrator
121	R-021-272-0FS	1	Pipe Size Indicator Barrel **
122	R-122-268-LBL	1	Pipe Size Groove Depth Label#
123	N-S95-040-000	1	Collar with Set Screw
124	N-M03-000-015	1	Spring

Item#	Part #	Qty.	Description
125	R-025-272-0FS	1	Guide Washer
126	R-019-226-MCH	1	3/8 x 1.00 Shoulder Screw
127	N-S05-160-014	1	1.00 x .875 Lg. Socket Hd. Shoulder Screw, Blk. Ox.
128	R-028-272-0FS	1	Back Cover Plate
129	R-129-270-MCH	1	Main Shaft
130	R-030-272-0FS	1	Upper Roll Guard Cover Screw
134	R-034-272-LAB	1	Depth Stop Adjustment Direction Label#
136	N-P11-006-100	2	.375 x 1.00 Lg. Type "H" Alloy Steel Groove Pin
147	N-M01-000-002	1	1/8" NPT Straight Grease Fitting
148	N-B04-156-002	1	Inner Race
149	N-T03-000-017	1	Snap Ring
150	N-M01-000-001	1	1/8" NPT 65° Grease Fitting
157	N-S01-040-010	4	1/4 - 20 UNC x .63 Lg. Hex Hd. Cap Screw, Pltd.
158	N-W03-040-000	4	1/4" ID Helical Split Lock Washer, Pltd.
163	R-163-274-LBL	1	Groove Depth Label for ISO-65 and JIS Pipe#
164	R-164-274-LBL	1	Groove Depth Label for DIN Pipe#
165	N-M04-000-004	1	Steel Hand Knob

\*\* Indicates additional items required or recommended when ordering.  
# Refer to pages 13 - 15 for images of product labels

**MAIN SHAFT**



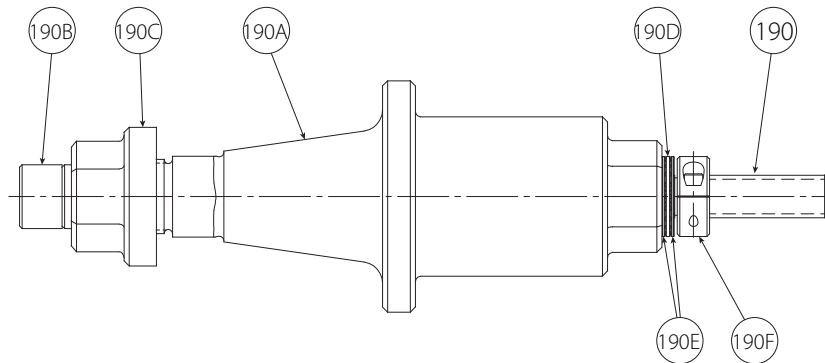
Item#	Part #	Qty.	Description
129	R-129-270-MCH	1	Main Shaft
151	N-B02-275-002	1	Needle Bearing
152	N-T03-000-015	1	Snap Ring

Item#	Part #	Qty.	Description
153	N-B01-157-002	1	40-mm ID x 90-mm OD x 36.5-mm Wide Double Row Ang. Contact Ball Bearing
154	N-T03-000-017	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**

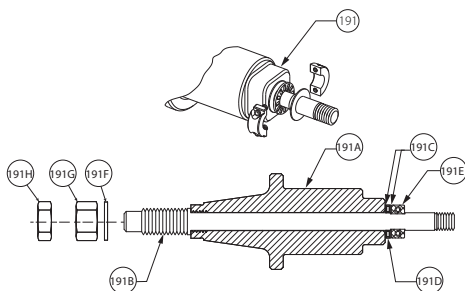


Item#	Part #	Qty.	Description
190	R-190-272-ASY	1	Arbor Assembly for 2 - 12" Pipe (Updated) **
190A	R-195-272-MCH	1	Square Drive Tapered Roll Shaft for 2 - 12" Pipe
190B	R-192-272-MCH	1	Retaining Stud, Tapered Roll Shaft
190C	R-191-272-FNH	1	Lower Roll Nut

Item#	Part #	Qty.	Description
190D	N-B03-050-001	1	.500 Bore Needle Thrust Bearing
190E	N-B05-050-001	2	.500 Bore x 0.32 Thk. Thrust Washer
190F	N-M13-000-002	1	Split Shaft Collar

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

**DESIGN "B" - SQUARE DRIVE ARBOR ASSEMBLY FOR 2 - 12" PIPE (DISCONTINUED)**

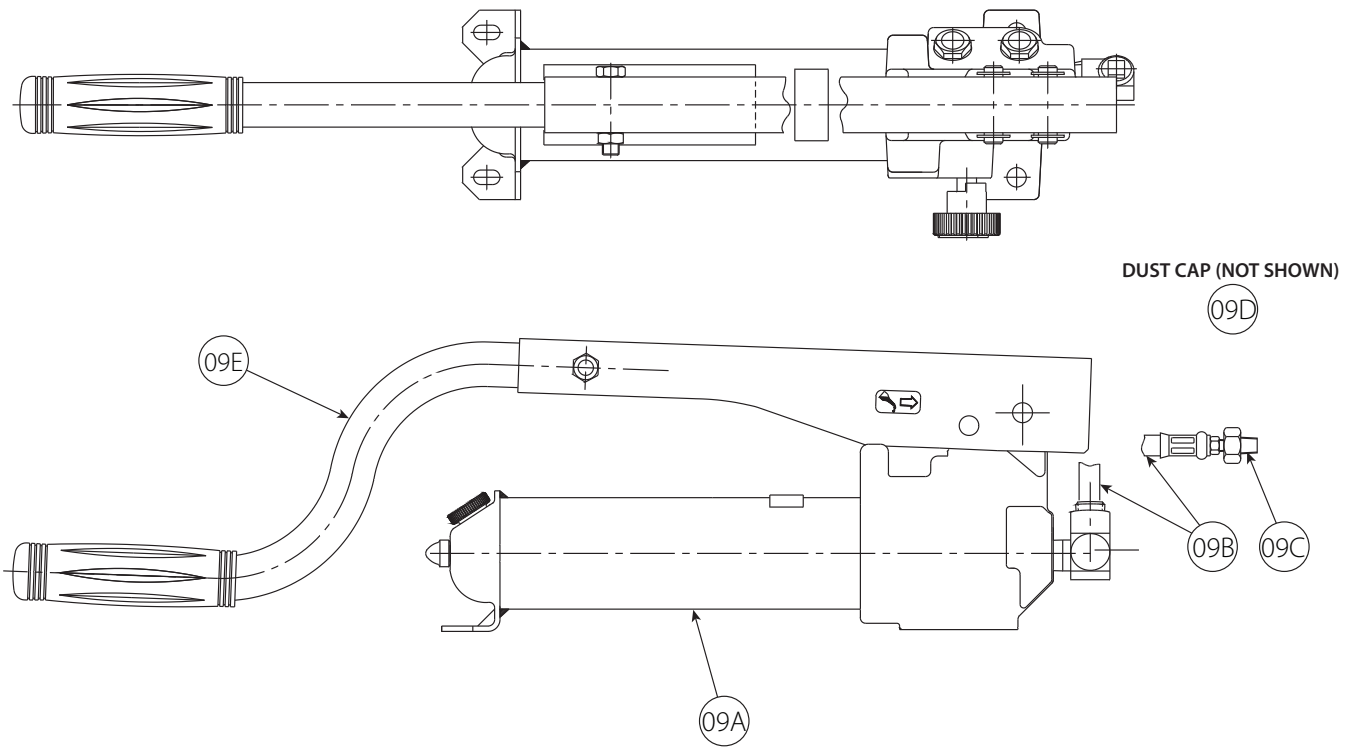


Item#	Part #	Qty.	Description
191	R-190-268-VE0	1	Arbor Assembly for 2 - 12" Pipe (Original) ** ***
191A	R-195-268-MCH	1	Square Drive Tapered Roll Shaft for 2 - 12" Pipe
191B	R-192-268-MCH	1	Tapered Roll Retaining Stud
191C	N-B05-050-001	2	.031 Thk. x .500 Bore Special Flat Washer
191D	N-B03-050-001	1	.500 Bore Needle Thrust Bearing
191E	N-M13-000-002	1	Split Shaft Collar
191F	N-W06-120-000	1	.75 ID SAE High Strength Washer, Pltd.
191G	N-N01-120-000	1	3/4 - 10 UNC Grd. 5 Nut, Pltd.
191H	N-N03-120-000	1	3/4 - 10 UNC Jam Nut, Pltd.

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

\*\*\* Indicates optional part number. Part Number R-195-268-KIT includes Item 191, plus 2 - 3", 4 - 6", and 8 - 12" lower rolls.

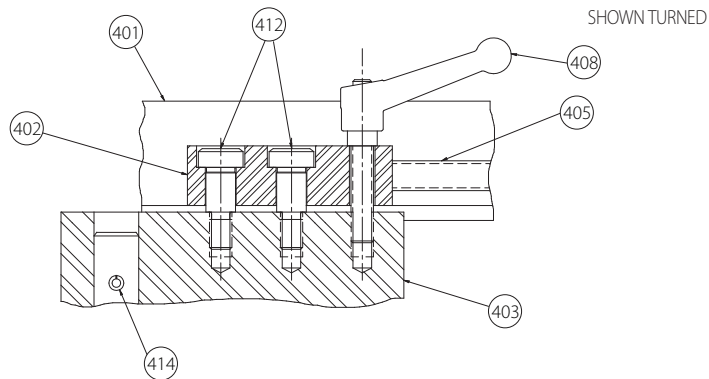
**HYDRAULIC HAND PUMP ASSEMBLY**



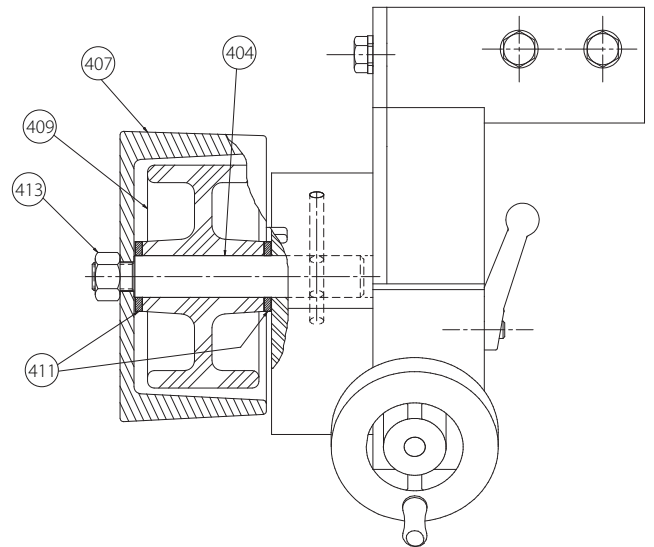
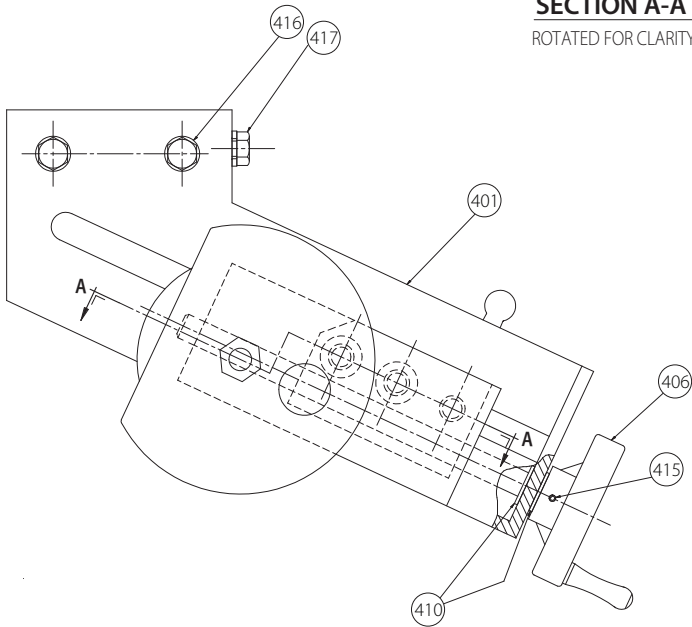
Item#	Part #	Qty.	Description
09A	R-201-261-0FS	1	Hand Pump
09B	N-H02-006-002	1	Hydraulic Hose (25-inch Length with 3/8 NPT Ends)
09C	N-H50-000-017	1	Male Hose Half Coupler

Item#	Part #	Qty.	Description
09D	N-H50-000-015	1	Dust Cap
09E	N-H50-000-076	1	Curved Handle

**STABILIZER ASSEMBLY**



**SECTION A-A**  
ROTATED FOR CLARITY



Item#	Part #	Qty.	Description
400	R-400-276-FSD	1	Stabilizer Body
401	R-401-276-PNT	1	Stabilizer Body
402	R-402-416-PLT	1	Stabilizer Guide Nut
403	R-403-276-PLT	1	Stabilizer Guide
404	R-404-416-MAC	1	Stabilizer Roller Shaft
405	R-405-276-MCH	1	Stabilizer Adjusting Screw
406	R-406-416-MAC	1	Stabilizer Handwheel
407	R-407-416-PNT	1	Stabilizer Wheel Guard
408	N-M04-000-004	1	Hand Knob

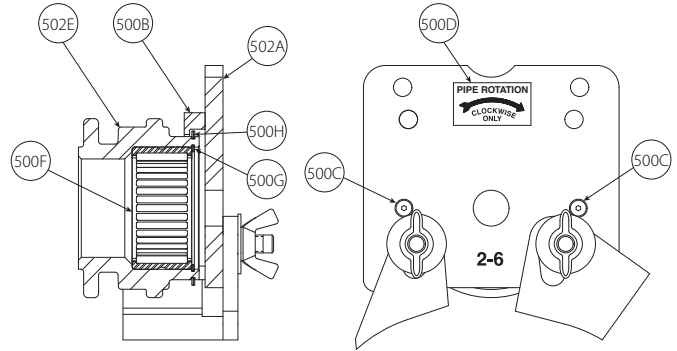
Item#	Part #	Qty.	Description
409	N-M05-000-004	1	4" x 2" Polyurethane Wheel
410	N-B05-037-002	2	Thrust Washer
411	N-B05-075-004	2	Thrust Washer
412	N-S05-080-012	2	.50 x .75" Lg. Socket Hd. Shoulder Bolt, Blk. Ox.
413	N-N02-080-000	1	½ - 20 UNF Hex Nut, Pltd.
414	N-P01-004-208	1	.25 x 2.50" Lg. Roll Pin
415	N-P01-002-102	1	.125 x 1.125" Lg. Roll Pin
416	N-S02-060-100	4	¾ - 16 UNC x 1.0" Lg. Grd. 8 Hex Hd. Cap Screw, Pltd.
417	N-W03-060-000	4	¾" Lockwasher, Pltd.

**STANDARD UPPER ROLL COVER/GUARD ASSEMBLIES**

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

Item#	Part #	Qty.	Description
502	R-9A2-272-U06	1	Upper Roll Assembly
502A	R-510-268-WLD	1	Upper Roll Guard
500B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
500C	N-509-008-010	2	#8-32 UNC x 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
500D	R-040-416-LAB	1	Pipe Rotation Label#
502E	R-902-272-U06	1	2" - 6" Upper Roll for Steel Pipe *
500F	N-B02-200-001	1	Needle Bearing
500G	N-T03-000-014	1	Snap Ring
500H	N-T03-000-022	1	Snap Ring

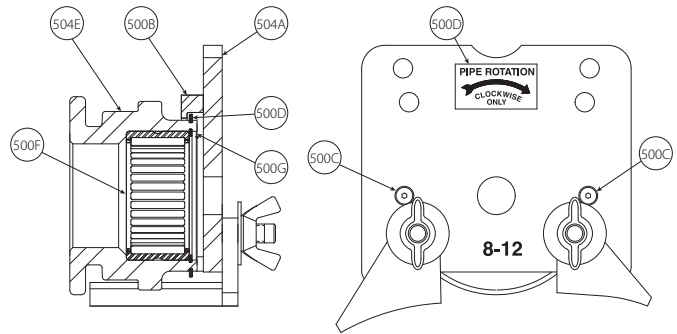
\* Not a saleable item. Assembly must be ordered.  
 # Refer to pages 13 - 15 for images of product labels



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

Item#	Part #	Qty.	Description
504	R-9A8-272-U12	1	Upper Roll Assembly
504A	R-520-268-WLD	1	Upper Roll Guard
500B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
500C	N-509-008-010	2	#8-32 UNC x 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
500D	R-040-416-LAB	1	Pipe Rotation Label#
504E	R-908-272-U12	1	8" - 12" Upper Roll for Steel Pipe *
500F	N-B02-200-001	1	Needle Bearing
500G	N-T03-000-014	1	Snap Ring
500H	N-T03-000-022	1	Snap Ring

\* Not a saleable item. Assembly must be ordered.  
 # Refer to pages 13 - 15 for images of product labels



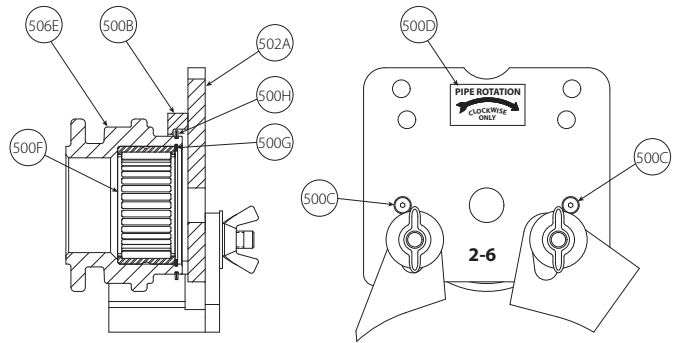


**OPTIONAL UPPER ROLL COVER/GUARD ASSEMBLIES**

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

Item#	Part #	Qty.	Description
506	R-XA2-272-U06	1	Upper Roll Assembly
502A	R-510-268-WLD	1	Upper Roll Guard
500B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
500C	N-S09-008-010	2	#8-32 UNC x 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
500D	R-040-416-LAB	1	Pipe Rotation Label#
506E	R-X02-272-U06	1	2" - 6" Upper Roll for Stainless Steel Pipe *
500F	N-B02-200-001	1	Needle Bearing
500G	N-T03-000-014	1	Snap Ring
500H	N-T03-000-022	1	Snap Ring
506J	R-X02-272-L03	1	2 - 3 1/2" Lower Roll for Stainless Steel Pipe **
506K	R-X04-272-L06	1	4 - 6" Lower Roll for Stainless Steel Pipe **

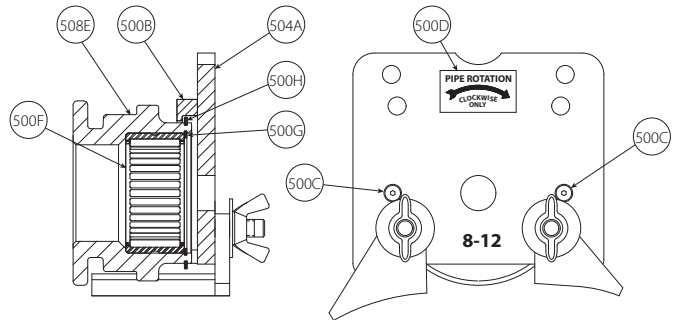
\* Not a saleable item. Assembly must be ordered.  
 \*\* Not shown  
 # Refer to pages 13 - 15 for images of product labels



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

Item#	Part #	Qty.	Description
508	R-XA8-272-U12	1	Upper Roll Assembly
504A	R-520-268-WLD	1	Upper Roll Guard
500B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
500C	N-S09-008-010	2	#8-32 UNC x 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
500D	R-040-416-LAB	1	Pipe Rotation Label#
508E	R-X08-272-U12	1	8" - 12" Upper Roll for Stainless Steel Pipe *
500F	N-B02-200-001	1	Needle Bearing
500G	N-T03-000-014	1	Snap Ring
500H	N-T03-000-022	1	Snap Ring
508J	R-X08-272-L12	1	8 - 12" Lower Roll for Stainless Steel Pipe **

\* Not a saleable item. Assembly must be ordered.  
 \*\* Not shown  
 # Refer to pages 13 - 15 for images of product labels

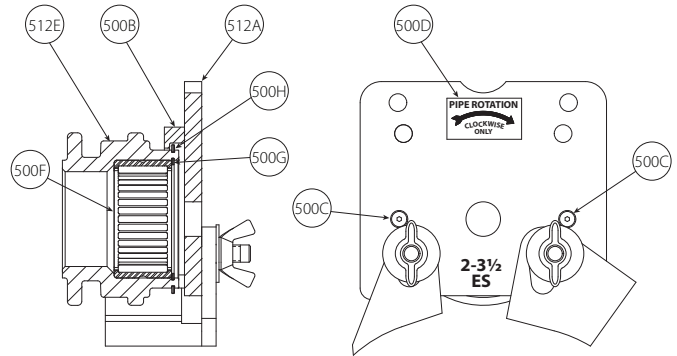


**OPTIONAL UPPER ROLL COVER/GUARD ASSEMBLIES**

**UPPER ROLL ASSEMBLY FOR  
2 - 3½" PIPE FOR ENDSEAL® PRODUCTS  
(ITEM 512)**

Item#	Part #	Qty.	Description
512	R-ZA2-272-U03	1	Upper Roll Assembly
512A	R-Z00-268-WLD	1	Upper Roll Guard
500B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
500C	N-S09-008-010	2	#8-32 UNC x ¾" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
500D	R-040-416-LAB	1	Pipe Rotation Label#
512E	R-Z02-272-U03	1	2" - 3½" Upper Roll for EndSeal® Pipe *
500F	N-B02-200-001	1	Needle Bearing
500G	N-T03-000-014	1	Snap Ring
500H	N-T03-000-022	1	Snap Ring
512J	R-Z02-272-L03	1	2" - 3½" Lower Roll for EndSeal® Pipe **

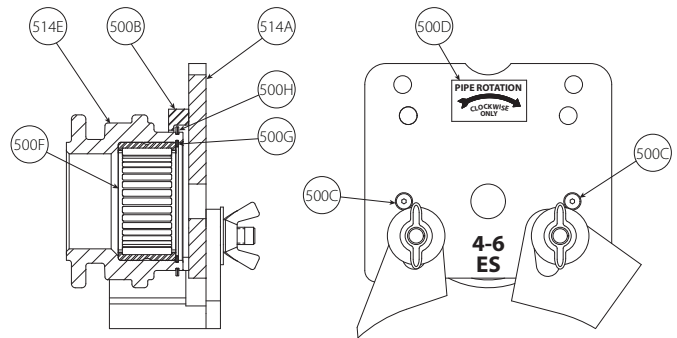
\* Not a saleable item. Assembly must be ordered.  
\*\* Not shown  
# Refer to pages 13 - 15 for images of product labels



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

Item#	Part #	Qty.	Description
514	R-ZA4-272-U06	1	Upper Roll Assembly
514A	R-Z10-268-WLD	1	Upper Roll Guard
500B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
500C	N-S09-008-010	2	#8-32 UNC x ¾" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
500D	R-040-416-LAB	1	Pipe Rotation Label#
514E	R-Z04-272-U06	1	4" - 6" Upper Roll for EndSeal® Pipe *
500F	N-B02-200-001	1	Needle Bearing
500G	N-T03-000-014	1	Snap Ring
500H	N-T03-000-022	1	Snap Ring
514J	R-Z04-272-L06	1	4" - 6" Lower Roll for EndSeal® Pipe **

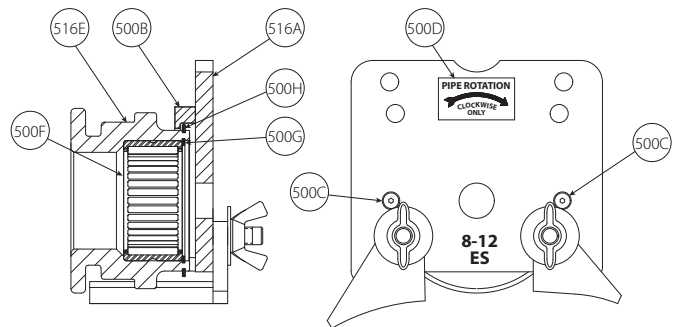
\* Not a saleable item. Assembly must be ordered.  
\*\* Not shown  
# Refer to pages 13 - 15 for images of product labels



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

Item#	Part #	Qty.	Description
516	R-ZA8-272-U12	1	Upper Roll Assembly
516A	R-Z20-268-WLD	1	Upper Roll Guard
500B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
500C	N-S09-008-010	2	#8-32 UNC x ¾" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
500D	R-040-416-LAB	1	Pipe Rotation Label#
516E	R-Z08-272-U12	1	8" - 12" Upper Roll for EndSeal® Pipe *
500F	N-B02-200-001	1	Needle Bearing
500G	N-T03-000-014	1	Snap Ring
500H	N-T03-000-022	1	Snap Ring
516J	R-Z08-272-L12	1	8" - 12" Lower Roll for EndSeal® Pipe **

\* Not a saleable item. Assembly must be ordered.  
\*\* Not shown  
# Refer to pages 13 - 15 for images of product labels



**OPTIONAL UPPER ROLL COVER/GUARD ASSEMBLIES**

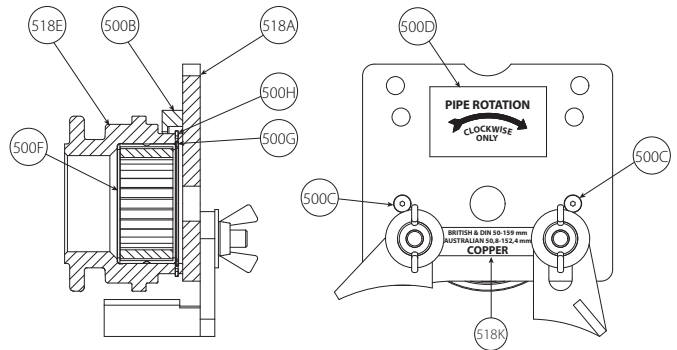
**UPPER ROLL ASSEMBLY FOR 50.8 - 152.4 MM AUSTRALIAN AND 50 - 159 MM BRITISH/DIN COPPER TUBING (ITEM 518)**

Item#	Part #	Qty.	Description
518	R-RE1-272-UA6	1	Upper Roll Assembly
518A	R-R00-268-WLD	1	Upper Roll Guard
500B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
500C	N-S09-008-010	2	#8-32 UNC x 3/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
500D	R-040-416-LAB	1	Pipe Rotation Label#
518E	R-RE1-272-U06	1	Upper Roll for Copper Pipe *
500F	N-B02-200-001	1	Needle Bearing
500G	N-T03-000-014	1	Snap Ring
500H	N-T03-000-022	1	Snap Ring
518J	R-RE1-272-L06	1	Lower Roll for Copper Pipe **
518K	R-157-272-LBL	1	Roll Guard Cover Label (Export)#

\* Not a saleable item. Assembly must be ordered.

\*\* Not shown

# Refer to pages 13 - 15 for images of product labels



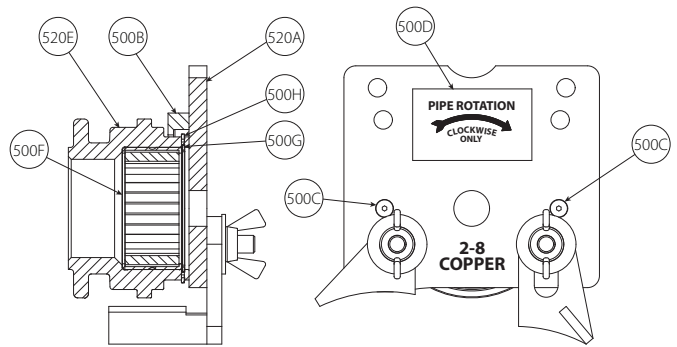
**UPPER ROLL ASSEMBLY FOR 2 - 8" COPPER TUBING (ITEM 520)**

Item#	Part #	Qty.	Description
520	R-RA2-272-U08	1	Upper Roll Assembly
520A	R-R00-268-WLD	1	Upper Roll Guard
500B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
500C	N-S09-008-010	2	#8-32 UNC x 3/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
500D	R-040-416-LAB	1	Pipe Rotation Label#
520E	R-R02-272-U08	1	2" - 8" Upper Roll for Copper Pipe *
500F	N-B02-200-001	1	Needle Bearing
500G	N-T03-000-014	1	Snap Ring
500H	N-T03-000-022	1	Snap Ring
520J	R-R02-272-L06	1	2 - 6" Lower Roll for Copper Pipe **
520K	R-R08-272-L08	1	8" Lower Roll for Copper Pipe **

\* Not a saleable item. Assembly must be ordered.

\*\* Not shown

# Refer to pages 13 - 15 for images of product labels

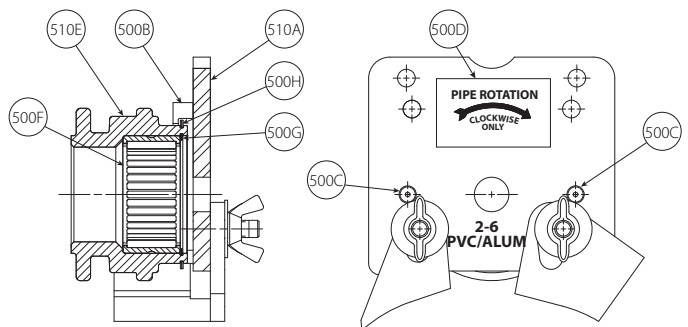


**UPPER ROLL ASSEMBLY FOR 2 - 6" PVC AND ALUMINUM PIPE (ITEM 510)**

Item#	Part #	Qty.	Description
510	R-PA2-272-U06	1	Upper Roll Assembly
510A	R-530-268-WLD	1	Upper Roll Guard
500B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
500C	N-S09-008-010	2	#8-32 UNC x 3/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
500D	R-040-416-LAB	1	Pipe Rotation Label#
510E	R-P02-272-U06	1	2" - 6" Upper Roll for Plastic Pipe *
500F	N-B02-200-001	1	Needle Bearing
500G	N-T03-000-014	1	Snap Ring
500H	N-T03-000-022	1	Snap Ring

\* Not a saleable item. Assembly must be ordered.

# Refer to pages 13 - 15 for images of product labels

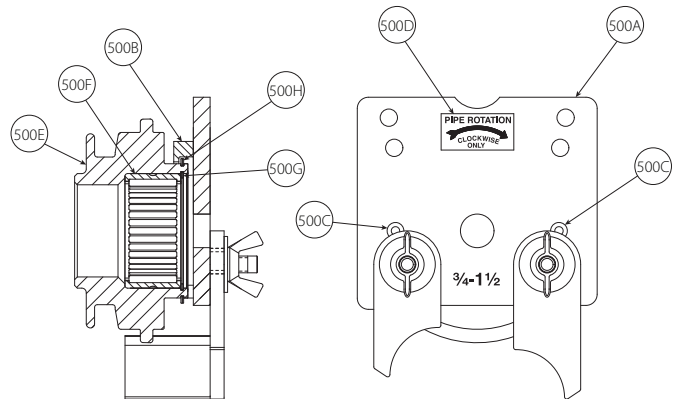


**OPTIONAL UPPER ROLL COVER/GUARD ASSEMBLIES**

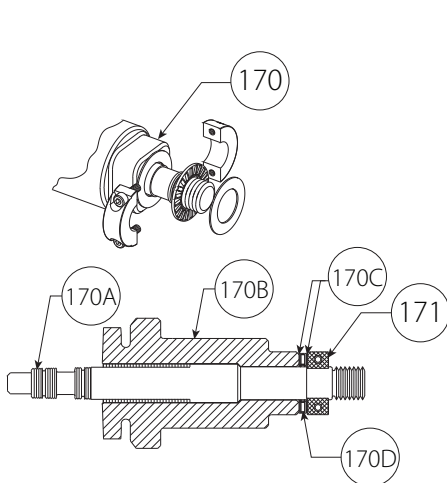
**UPPER ROLL ASSEMBLY FOR 3/4 - 1 1/2" STEEL PIPE (ITEM 500)**

Item#	Part #	Qty.	Description
500	R-9A0-268-U02	1	Upper Roll Guard Assembly
500A	R-500-268-WLD	1	Upper Roll Guard
500B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
500C	N-509-008-010	2	#8-32 UNC x 3/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
500D	R-040-416-LAB	1	Pipe Rotation Label#
500E	R-900-268-U01	1	3/4" - 1 1/2" Upper Roll for Steel Pipe *
500F	N-B02-200-001	1	Needle Bearing
500G	N-T03-000-014	1	Snap Ring
500H	N-T03-000-022	1	Snap Ring

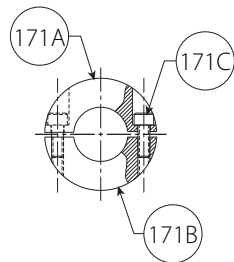
\* Not a saleable item. Assembly must be ordered.  
# Refer to pages 13 - 15 for images of product labels



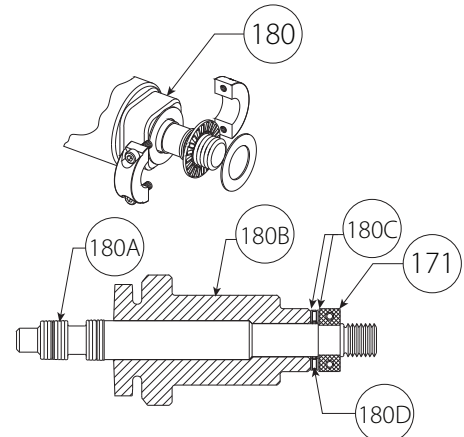
**OPTIONAL ARBOR ASSEMBLIES**



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



**Shaft Collar Assembly (Item 171)**



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

Item#	Part #	Qty.	Description
<b>SHAFT COLLAR ASSEMBLY</b>			
171	R-173-268-ASY	1	Shaft Collar Assembly **
171A	R-171-268-MCH	1	Shaft Collar - Top *
171B	R-172-268-MCH	1	Shaft Collar - Bottom *
171C	N-S03-006-006	2	#6-32 UNC x 3/8" Lg. SHCS, Blk. Ox. *
<b>ARBOR ASSEMBLY FOR 3/4" PIPE</b>			
170	R-900-268-LA1	1	Lower Roll Assembly for 3/4" Pipe **
170A	R-975-268-L75	1	Lower Roll for 3/4" Pipe
170B	R-900-268-A02	1	Lower Roll Adapter
170C	N-M30-000-005	2	0.031 Thk. x 0.750 Bore Special Flat Washer
170D	N-B03-750-001	1	0.750 Bore Needle Thrust Bearing

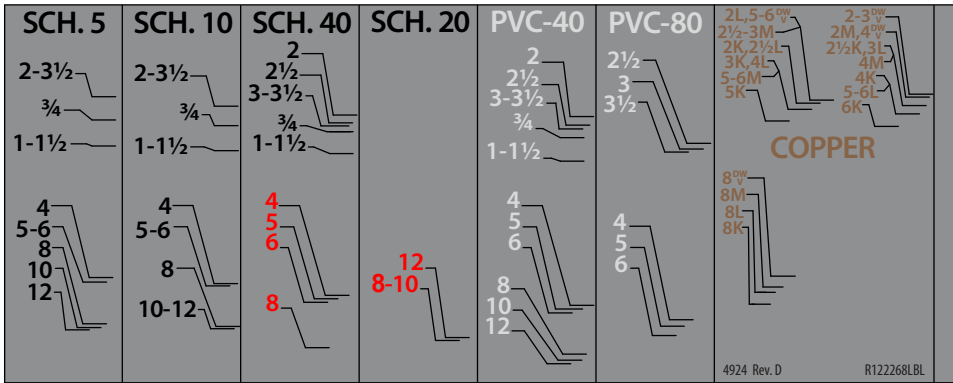
Item#	Part #	Qty.	Description
<b>ARBOR ASSEMBLY FOR 1 - 1 1/2" PIPE</b>			
180	R-901-268-LA2	1	Lower Roll Assembly for 1 - 1 1/2" Pipe **
180A	R-901-268-L02	1	Lower Roll for 1 - 1 1/2" Pipe
180B	R-900-268-A02	1	Lower Roll Adapter
180C	N-M30-000-005	2	0.031 Thk. x 0.750 Bore Special Flat Washer
180D	N-B03-750-001	1	0.750 Bore Needle Thrust Bearing

\* Not a saleable item. Assembly must be ordered.

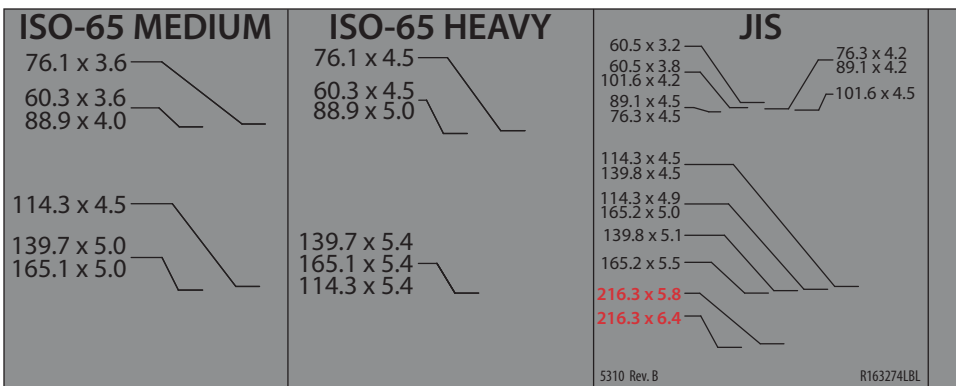
\*\* Indicates additional items required or recommended when ordering.

IMAGES OF THE LABELS ON PAGES 13 - 15 ARE NOT TO SCALE.

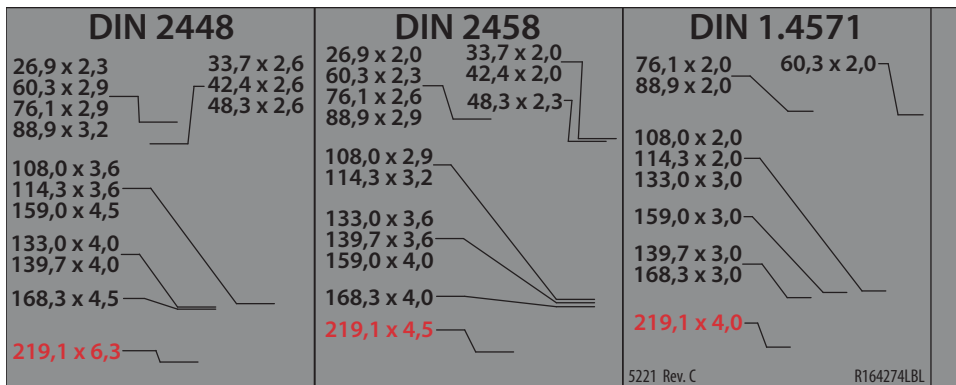
R-122-268-LBL



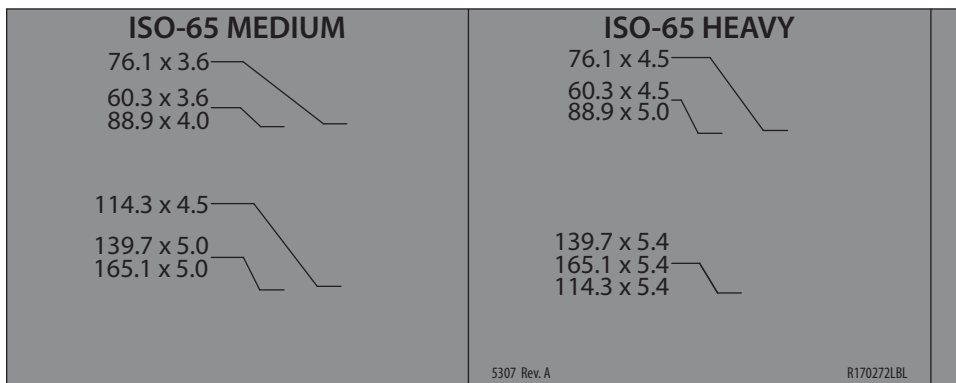
R-163-274-LBL




R-164-274-LBL

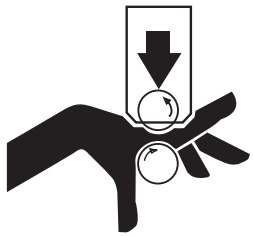


R-170-272-LBL



R-007-276-LBL


WARNING



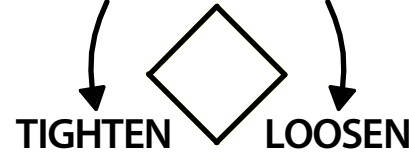
**Grooving rolls can crush or cut fingers and hands.**

- Always disconnect the tool from the power source before making any tool adjustments.
- Make sure the guard is adjusted properly before grooving pipe.
- Loading/unloading pipe will place your hands close to the grooving rolls. Keep hands away from the grooving rolls and the roller on the pipe stabilizer during operation.
- Never reach inside the pipe ends or across the tool or pipe during operation.
- Never groove pipe that is shorter than the recommended lengths listed in the operating and maintenance manual.
- Never wear loose clothing, loose gloves, or anything that can become entangled in moving parts.


2244 Rev. D R007276LBL

R-064-268-LBL

**3/4 - 1 1/2 SHAFT**




**2 - 12 SHAFT**




4865 Rev. C R064268LBL

R-034-272-LAB



INCREASE

DECREASE




GROOVE DIAMETER

4867 Rev. B R034272LAB

R-040-416-LAB


PIPE ROTATION



3318 Rev. D R040416LAB

R-031-272-LAB


WARNING



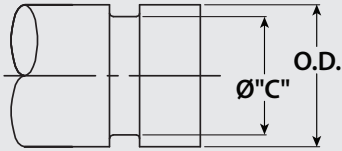
**Failure to follow instructions and warnings could result in serious personal injury, property damage, and/or product damage.**

- 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

R-009-424-LBL



4864 Rev. E R009424LBL

SIZE	O.D.		ø "C"	
	MAXIMUM	MINIMUM	MAXIMUM	MINIMUM
¾ [26.9]	1.060 [26.9]	1.040 [26.4]	0.938 [23.8]	0.923 [23.4]
1 [33.7]	1.328 [33.7]	1.302 [33.1]	1.190 [30.2]	1.175 [29.9]
1¼ [42.4]	1.676 [42.6]	1.644 [41.8]	1.535 [39.0]	1.520 [38.6]
1½ [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]
2½ [73.0]	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]
3½ [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]
4½ [127.0]	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]
203.2 mm	8.063 [204.8]	7.969 [202.4]	7.816 [198.5]	7.791 [197.9]
8 [219.1]	8.688 [220.7]	8.594 [218.3]	8.441 [214.4]	8.416 [213.8]
254.0 mm	10.063 [255.6]	9.969 [253.2]	9.812 [249.2]	9.785 [248.5]
10 [273.0]	10.813 [274.7]	10.719 [272.3]	10.562 [268.3]	10.535 [267.6]
304.8 mm	12.063 [306.4]	11.969 [304.0]	11.781 [299.2]	11.751 [298.5]
12 [323.9]	12.813 [325.5]	12.719 [323.1]	12.531 [318.3]	12.501 [317.5]
14 OD [355.6]	14.063 [357.2]	13.969 [354.8]	13.781 [350.0]	13.751 [349.3]
15 OD [381.0]	15.063 [382.6]	14.969 [380.2]	14.781 [375.4]	14.751 [374.7]
16 OD [406.4]	16.063 [408.0]	15.969 [405.6]	15.781 [400.8]	15.751 [400.1]
18 OD [457]	18.063 [458.8]	17.969 [456.4]	17.781 [451.6]	17.751 [450.9]
20 OD [508]	20.063 [509.6]	19.969 [507.2]	19.781 [502.4]	19.751 [501.7]
22 OD [559]	22.063 [560.4]	21.969 [558.0]	21.656 [550.1]	21.626 [549.3]
24 OD [610]	24.063 [611.2]	23.969 [608.8]	23.656 [600.9]	23.626 [600.1]
26 OD [660]	26.063 [662.0]	25.937 [658.8]	25.500 [647.7]	25.437 [646.1]
28 OD [711]	28.063 [712.8]	27.937 [709.6]	27.500 [698.5]	27.437 [696.9]
30 OD [762]	30.063 [763.6]	29.937 [760.4]	29.500 [749.3]	29.437 [747.7]
32 OD [813]	32.063 [814.4]	31.937 [811.2]	31.500 [800.1]	31.437 [798.5]
36 OD [914]	36.063 [916.0]	35.937 [912.8]	35.500 [901.7]	35.437 [900.1]
42 OD [1067]	42.063 [1068.4]	41.937 [1065.2]	41.500 [1054.1]	41.437 [1052.5]
48 OD [1219]	48.063 [1220.8]	47.937 [1217.6]	47.500 [1206.5]	47.437 [1204.9]

R-062-260-LBL

R-157-272-LBL

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

3373 Rev.A 11/01 R157272LBL

R-207-264-LBL

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).

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

R-022-417-LAB

R-22E-416-FSD

R-069-272-LAB

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**VE270FSD and VE271FSD Roll Grooving Tools**

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