

VE460

PIPE ROLL GROOVING TOOL



WARNING



WARNING



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

- Before operating or servicing the VE460 Roll Grooving Tool, read all instructions in this manual and all warning labels on the tool.
- Wear safety glasses, hardhat, foot protection, and hearing protection while working around this tool.
- Save this operating and maintenance manual.

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

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HAZARD IDENTIFICATION

Definitions for identifying the various hazard levels are provided below.



This safety alert symbol indicates important safety messages. When you see this symbol, be alert to the possibility of personal injury.

Carefully read and fully understand the message that follows.



DANGER

- The use of the word “DANGER” identifies an immediate hazard with a likelihood of death or serious personal injury if instructions, including recommended precautions, are not followed.



WARNING

- The use of the word “WARNING” identifies the presence of hazards or unsafe practices that could result in death or serious personal injury if instructions, including recommended precautions, are not followed.



CAUTION

- The use of the word “CAUTION” identifies possible hazards or unsafe practices that could result in personal injury and product or property damage if instructions, including recommended precautions, are not followed.

NOTICE

- The use of the word “NOTICE” identifies special instructions that are important but not related to hazards.

OPERATOR SAFETY INSTRUCTIONS

The VE460 is designed only for roll grooving pipe. Use of these tools requires dexterity and mechanical skills, as well as sound safety habits. Although these tools are manufactured for safe, dependable operation, it is impossible to anticipate all combinations of circumstances that could result in an accident. The following instructions are recommended for safe operation of these tools. The operator is cautioned to always practice “safety first” during each phase of use, including setup and maintenance. It is the responsibility of the owner, lessee, or user of these tools to ensure that all operators read this manual and fully understand the operation of these tools.

Read this manual before operating or servicing these tools. Become familiar with the tool’s operations, applications, and limitations. Be particularly aware of its specific hazards. Store this manual in a clean area where it is always readily available. Additional copies of this manual are available upon request through Victaulic.

1. The VE460 tool is designed ONLY for roll grooving pipe sizes, materials, and wall thicknesses listed in the applicable “Tool Rating and Roll Selection” section.
2. Avoid using the tool in dangerous environments. Do not expose the tool to rain, and do not use the tool in damp or wet locations. Do not use the tool on sloped or uneven surfaces. Keep the work area well lit. Allow sufficient space to operate the tool properly.
3. Ground the tool to protect the operator from electric shock. Tool components are grounded to the frame of the tool. Make sure the frame is grounded properly.
4. Prevent back injury. During tool setup, one person cannot safely handle the pipe stabilizer assembly due to its weight. Two people are needed to safely lift and handle the stabilizer assembly. An alternative is to use a hoist to lift the stabilizer assembly into position.

5. **Inspect the equipment.** Before using the tool, check all moveable parts for any obstructions. Make sure guards and tool components are installed and adjusted properly.
6. **Prevent accidental startups.** Place the switch on the side of the tool to the “OFF” position when the tool is not in use.
7. **Wear proper apparel.** Do not wear loose clothing, jewelry, or anything that can become entangled in moving parts.
8. **Wear protective items when working with tools.** Always wear safety glasses, hardhat, foot protection, and hearing protection.
9. **Stay alert.** Do not operate the tool if you are drowsy from medication or fatigue. Avoid horseplay around the equipment.
10. **Keep visitors away from the immediate work area.** All visitors should be kept a safe distance from the equipment at all times.
11. **Keep work areas clean.** Keep the work area around the tool clear of any obstructions that could limit the movement of the operator. Clean up any oil or other spills.
12. **Secure the work, tool, and accessories.** Make sure the tool is stable. Refer to the applicable “Tool Setup” section.
13. **Support the work.** Support long pipe lengths with a pipe stand that is secured to the floor or the ground.
14. **Operate the tool only with a safety foot switch.** The power drive must be operated with a safety foot switch that is located for easy operator access. Never reach across moving parts. If the tool does not contain a safety foot switch, contact Victaulic.
15. **Keep hands and tools away from grooving rolls and stabilizer roller during the grooving operation.** Grooving rolls can crush or cut fingers and hands.
16. **Do not reach inside the pipe ends during tool operation.** Pipe edges can be sharp and can snag gloves, hands, and shirt sleeves. Fingers and hands can be crushed between the pipe and lower roll.
17. **Do not over-reach.** Maintain proper footing and balance at all times. Make sure the safety foot switch is easily accessible for the operator.
18. **Do not force the tool.** Do not force the tool or accessories to perform any functions beyond their capabilities. Do not overload the tool.
19. **Do not operate the tool at ram speeds exceeding those specified in this manual.**
20. **Do not abuse the foot switch cord.** Keep the cord away from heat, oil, and sharp objects.
21. **Always turn off the main power supply to the tool before servicing the tool.** Only authorized personnel should attempt to perform maintenance on the tool. Always turn off the main power supply to the tool before servicing or adjusting the tool.
22. **Maintain tools with care.** Keep tools clean at all times to ensure proper and safe performance. Follow the instructions for lubricating tool components.
23. **Use only Victaulic replacement parts and accessories.** Use of any other parts may result in a voided warranty, improper operation, and hazardous situations.
24. **Do not remove any labels from the tool.** Replace any damaged or worn labels.

INTRODUCTION

NOTICE

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

The VE460 Roll Grooving Tool is a fully motorized, semi-automatic, hydraulic-feed tool for roll grooving pipe to receive Victaulic grooved pipe products. The standard VE460 tool is supplied with rolls for grooving 4–12-inch/114.3–323.9-mm carbon steel pipe to original groove specifications and 14–24-inch/355.6–610.0-mm carbon steel pipe to Advanced Groove Specifications (AGS). VE460 rolls are marked with the size and part number, and they are color coded to identify the pipe material. For roll grooving to other specifications and materials, refer to the applicable “Tool Rating and Roll Selection” section. Grooving tools for other specifications, sizes, and materials must be purchased separately.



CAUTION

- **These tools must be used ONLY for roll grooving pipe designated in the applicable “Tool Rating and Roll Selection” section of this manual.**

Failure to follow this instruction could overload the tool, resulting in reduced tool life and/or damage to the tool.

RECEIVING THE TOOL

VE460 tools are palletized individually and enclosed in a wooden or cardboard sleeve, which is designed for use in re-shipping the tool back to Victaulic upon completion of the rental contract, when applicable. The stabilizer assembly and additional roll sets are shipped in a separate container.

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

VE460 LARGE CONTAINER CONTENTS

Qty.	Description
1	VE460 Pipe Roll Grooving Tool
1	Roll Set for 8 – 12-inch/219.1 – 323.9-mm Steel Pipe Mounted on the Tool (Unless Ordered Otherwise) - Original Groove System Specifications
2	TM-VE460 Operating and Maintenance Instructions Manual
2	RP-VE460 Repair Parts List
1	Stabilizer Mounting Hardware (Installed Loose in Mounting Holes for Stabilizer)
1	Pipe Diameter Tape
1	Hydraulic System Bleeder Tube
1	Safety Foot Switch with Detachable Line Cord

VE460 SMALL CONTAINER CONTENTS

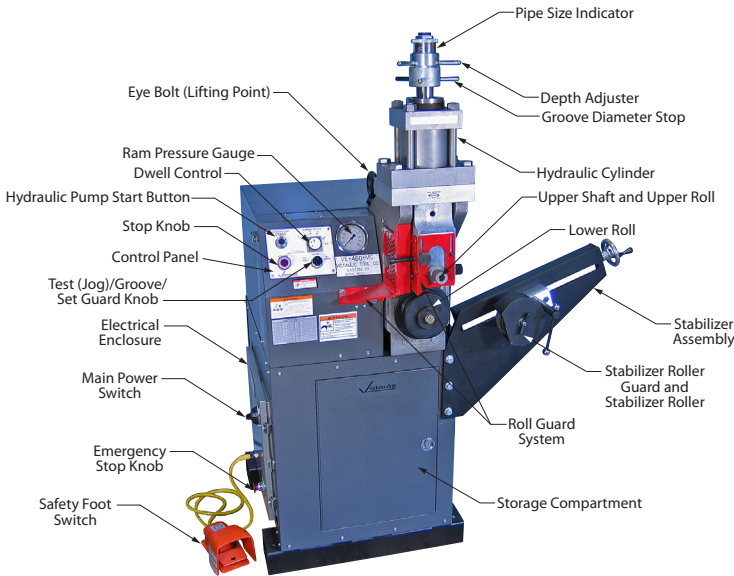
Qty.	Description
1	Stabilizer Assembly
1	Roll Set for 4 – 6-inch/114.3 – 168.3-mm Steel Pipe - Original Groove System Specifications
1	Roll Set for 14 – 24-inch/355.6 – 610.0-mm Steel Pipe - AGS Specifications

NOTE: Support bases for grooving 26-inch/660.0-mm and larger pipe sizes must be ordered separately and will be shipped in separate containers from the tool components listed on this page.

TOOL NOMENCLATURE

NOTICE

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



Located Under Control Panel

⚠ DANGER	
	<p>Contact with hazardous voltage inside this cover plate may result in death or serious personal injury.</p> <ul style="list-style-type: none"> • ALWAYS disconnect the tool from the power source before performing maintenance or adjustments. • Only qualified personnel should open this cover plate.
	<p>3308 Rev. B 8095424L8</p>

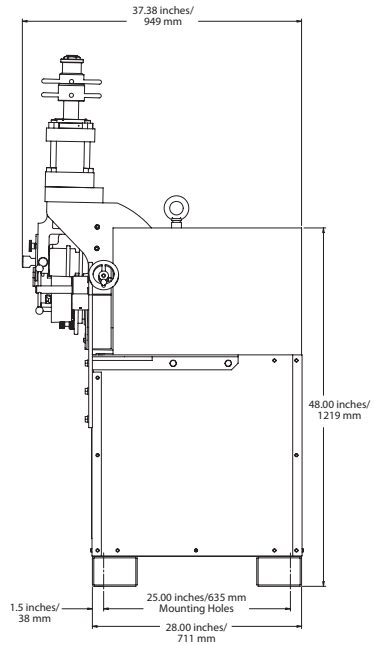
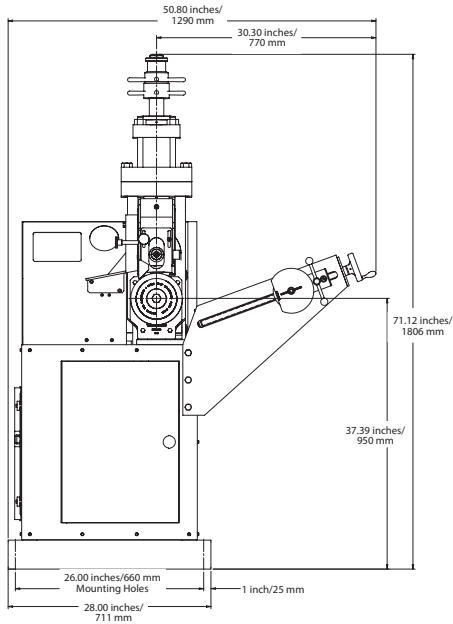
Located on Electrical Enclosure

⚠ DANGER	
	<p>Contact with hazardous voltage inside this door may result in death or serious personal injury.</p> <ul style="list-style-type: none"> • ALWAYS disconnect the tool from the power source before performing maintenance or adjustments. • Only qualified personnel should open this door.
	<p>5038 Rev. B 8090404L8</p>

Located on Front of Tool

⚠ WARNING	
	<p>Grooving rolls can crush or cut fingers and hands.</p> <ul style="list-style-type: none"> • Always disconnect the tool from the power source before making any tool adjustments. • Loading/unloading pipe will place your hands close to the rollers. Keep hands away from the grooving rolls and the roller on the pipe stabilizer during operation.
	<ul style="list-style-type: none"> • Never reach inside the pipe ends or across the tool or pipe during operation. • Always groove pipe in a CLOCKWISE direction. • 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. <p>5027 Rev. C 807404L8</p>

⚠ WARNING	
	<p>Failure to follow instructions and warnings could result in serious personal injury, property damage, and/or product damage.</p> <ul style="list-style-type: none"> • 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.
	<p>If you need additional copies of any literature, or if you have questions concerning the safe and proper operation of any pipe preparation tool, contact Victaulic, P.O. Box 31, Easton, PA 18044-0031, Phone 1-800-PICK-VIC, E-Mail: pickvic@victaulic.com.</p> <p>6501 Rev. D 807122L8R</p>



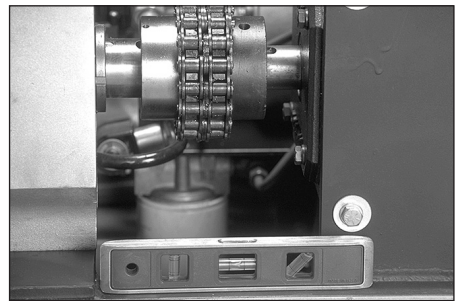
TOOL SETUP FOR GROOVING 24-INCH/610.0-MM AND SMALLER PIPE SIZES

WARNING

- DO NOT turn on the main power supply to the tool until instructed otherwise.
- The tool MUST be leveled and anchored securely on a concrete floor or base.

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

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



2. The VE460 Roll Grooving Tool is designed for use in a permanent location and must be located on a level concrete floor or base. After an appropriate location is chosen, the tool must be level and securely anchored. A non-level tool can severely affect grooving operation. When checking tool level, place the level directly on the frame of the tool, as shown above.
3. Select a location for the tool and pipe stand by taking into consideration the following factors:

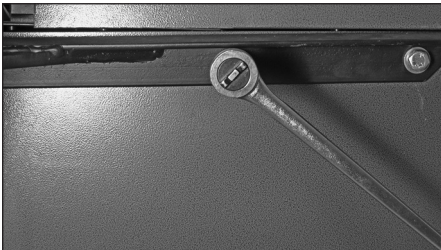
- 3a. The required power supply (refer to the “Power Requirements” section)
- 3b. Ambient temperature requirements of 20° F to 104° F/-21°C to 26° C
- 3c. A level concrete floor or base for the tool and pipe stand
- 3d. Adequate space to handle pipe lengths
- 3e. Adequate clearance around the tool and stabilizer assembly for adjustment and maintenance (refer to drawings on following page)



WARNING

- During tool setup, two people are needed to safely handle the stabilizer assembly due to its weight.
- An alternative is to use a hoist to lift the stabilizer assembly into position.

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



4. Remove the stabilizer bolts and lock washers from the front and right side of the tool. Position the stabilizer assembly onto the front, right corner of the tool so that the

mounting holes in the stabilizer assembly align with the mounting holes in the tool. Using the stabilizer bolts and lock washers, removed previously from the tool, fasten the stabilizer assembly to the tool. **NOTE:** The tool frame is designed so that no nuts are required on the ends of the bolts. Tighten all stabilizer bolts completely until the lock washers are compressed fully.

NOTICE

- VE460 tools are equipped with a detachable safety-foot-switch cord. The safety foot switch can be removed easily for storage in the cabinet when the tool is not in use.



5. Install the safety foot switch by aligning the pins/tab of the male adapter plug with the receptacle.



6. Tighten the locking ring on the plug.
7. Proceed to the “Power Requirements” section.

IMPORTANT INFORMATION FOR TOOL SETUP

Support bases are required when using a VE460 Roll Grooving Tool to groove 26-inch/660.0-mm and larger pipe sizes. Each support base corresponds with a range of pipe sizes; these requirements must be followed to ensure pipe is grooved properly (refer to table below).

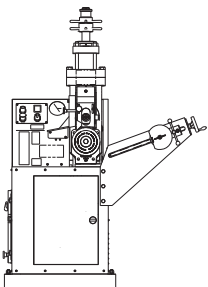
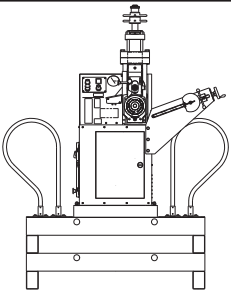
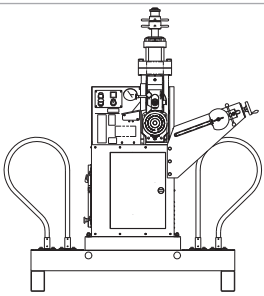
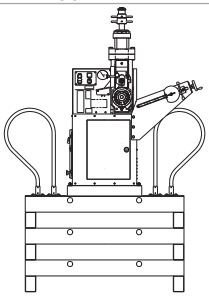
If the tool will be used for roll grooving 24-inch/610.0-mm and smaller pipe sizes, follow the “Tool Setup for Grooving 24-inch/610.0-mm and Smaller Pipe Sizes” section. For the 24-inch/610.0-mm and smaller pipe size range, support bases are not required, but the tool must be anchored to a sturdy, level concrete floor.

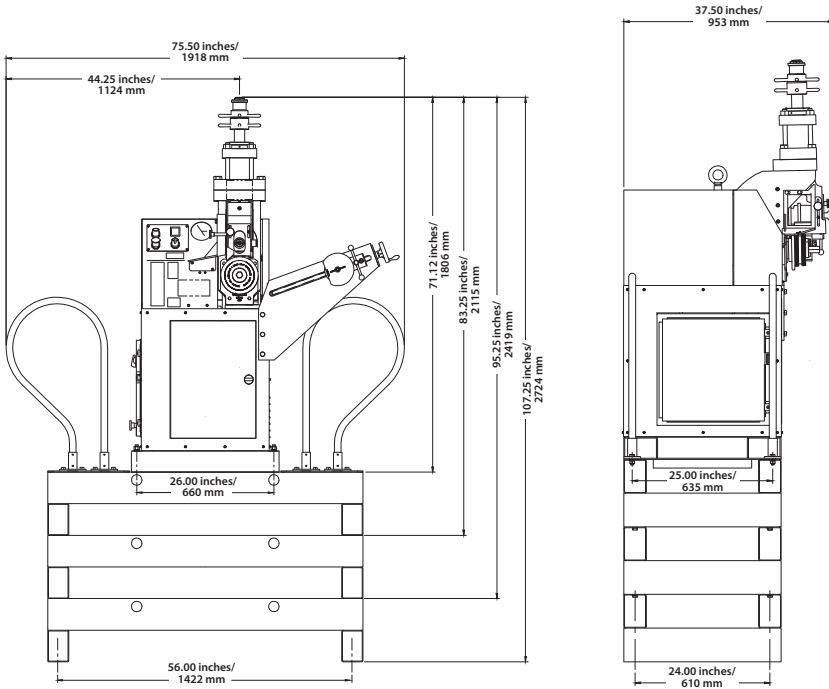
If the tool will be used for roll grooving 26-inch/660.0-mm and larger pipe sizes, follow the “Tool Setup for Grooving 26-inch/660.0-mm and Larger Pipe Sizes” section. **NOTE:** Each support base is 12 inches/305 mm in height and weighs approximately 180 pounds/82 kilograms.

⚠ WARNING

- The tool or bottom support base **MUST** always be anchored to a sturdy, level concrete floor that is capable of handling the weight of the tool and accessories.
- Handrails must be installed and the electrical cord/safety foot switch cord must be routed through the support base(s) to prevent tripping hazards.

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

Configuration	Pipe Size Range	Configuration	Pipe Size Range
 <p>Tool without support base(s)</p>	24-inch/ 610.0-mm and Smaller Pipe Sizes	 <p>Tool installed with two support bases</p>	40 – 48-inch/ 1016.0 – 1219.0-mm Pipe Sizes
 <p>Tool installed with one support base</p>	26 – 38-inch/ 660.0 – 965.0-mm Pipe Sizes	 <p>Tool installed with three support bases</p>	50 – 60-inch/ 1270.0 – 1524.0-mm Pipe Sizes



TOOL SETUP FOR GROOVING 26-INCH/660.0-MM AND LARGER PIPE SIZES

WARNING

- **DO NOT** turn on the main power supply to the tool until instructed otherwise.
- The bottom support base **MUST** always be anchored to a sturdy, level concrete floor that is capable of handling the weight of the tool and accessories.

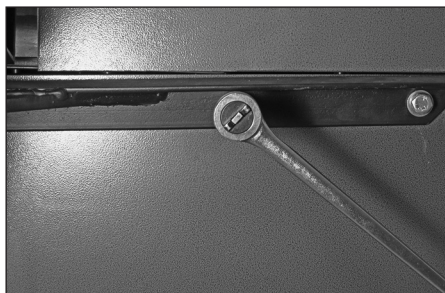
Failure to follow these instructions could result in serious personal injury.

1. Remove all components from the packaging, and make sure all necessary items are included. Refer to the "Receiving the Tool" section.
2. The VE460 Roll Grooving Tool with support base(s) is designed for use in a permanent location and must be located on a level concrete floor. After an appropriate location is chosen, the bottom support base must be level and securely anchored. A non-level tool can severely affect grooving operation.
3. Select a location for the tool/support base(s) and pipe stand by taking into consideration the following factors:
 - 3a. The required power supply (refer to the "Power Requirements" section)
 - 3b. Ambient temperature requirements of 20° F to 104° F/-21°C to 26° C
 - 3c. A level concrete floor for the tool/support base(s) and pipe stand
 - 3d. Adequate space to handle pipe lengths
 - 3e. Adequate clearance around the tool/support base(s) for adjustment and maintenance (refer to drawings above)

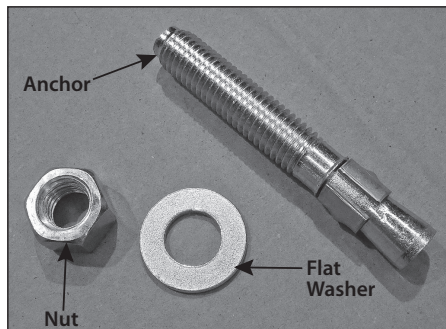
WARNING

- During tool setup, two people are needed to safely handle the stabilizer assembly due to its weight.
- An alternative is to use a hoist to lift the stabilizer assembly into position.

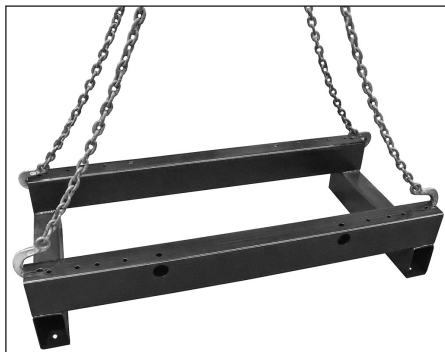
Failure to follow these instructions could result in serious personal injury.



4. Remove the stabilizer bolts and lock washers from the front and right side of the tool. Position the stabilizer assembly onto the front, right corner of the tool so that the mounting holes in the stabilizer assembly align with the mounting holes in the tool. Using the stabilizer bolts and lock washers, removed previously from the tool, fasten the stabilizer assembly to the tool. **NOTE:** The tool frame is designed so that no nuts are required on the ends of the bolts. Tighten all stabilizer bolts completely until the lock washers are compressed fully.



5. Wedge-type concrete floor anchors ($\frac{3}{8}$ x $4\frac{1}{4}$ -inch size) must be used to secure the bottom platform to the floor. Make sure the floor anchors are installed into the concrete floor in accordance with the manufacturer's instructions.



6. Using a four-point lifting method, as shown above, raise the bottom support base over the area where the floor anchors are installed. Align the four holes in the support base with the four floor anchors. Slowly lower the support base over the floor anchors. **NOTE:** DO NOT attempt to move the support base with a forklift.

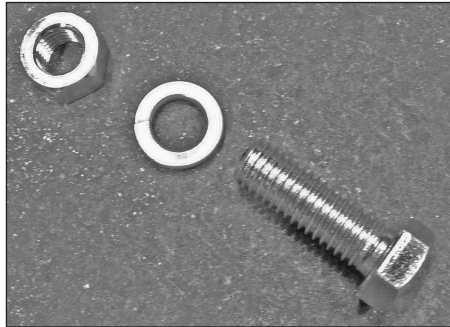


7. Install a flat washer and nut onto each of the floor anchors, as shown above. Tighten the nut completely.

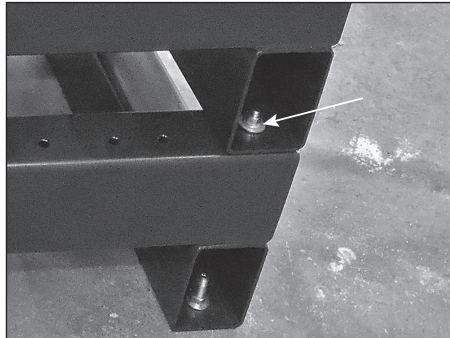


8. At this time, an additional support base can be installed. Following the same four-point lifting method as in step 2, raise the second support base over the bottom

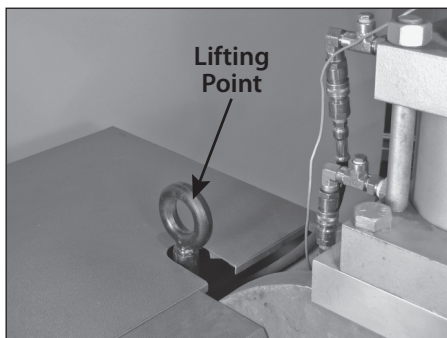
support base. Align the four holes in the second support base with the four holes in the bottom support base. Slowly lower the second support base onto the bottom support base.



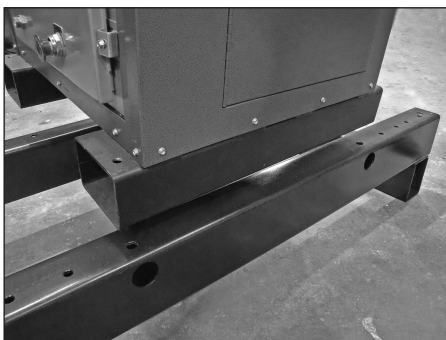
9. Locate the bolt, lock washer, and nut (supplied with the support base kit). This hardware is required to anchor the support bases to each other.



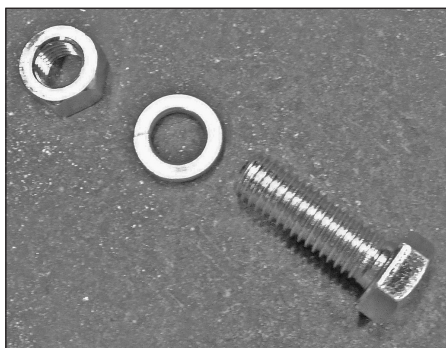
10. Insert a bolt up through the hole in the bottom support base and into the hole in the second support base. Apply a lock washer and nut to the end of the bolt. Tighten the nut completely until the lock washer is compressed fully. Repeat this step for the other three hole locations.
11. If the third support base is required, follow steps 8 - 10.



12. When the correct amount of support bases are installed and secured to each other, the tool must be lifted into position and placed onto the support base(s). An eye bolt is provided in the top-middle section of the tool. Make sure the minimum capacity rating of the overhead crane is 2000 pounds/910 kilograms.



13. As the tool is being lowered onto the support base(s), make sure the power cord is guided out of the way to prevent damage to the cord. The holes in the base of the tool must align with the innermost holes in the support base, as shown above.



14. Locate the bolt, lock washer, and nut (supplied with the support base kit). This hardware is required to anchor the tool and support base to each other.



15. Insert a bolt with a flat washer up through the hole in the support base and into the hole in the base of the tool. Apply a lock washer and nut to the end of the bolt. Tighten the nut completely until the lock washer is compressed fully. Repeat this step for the other three hole locations in the support base and tool base.

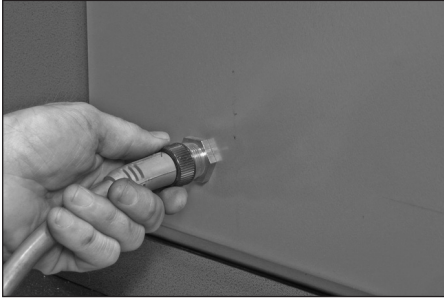
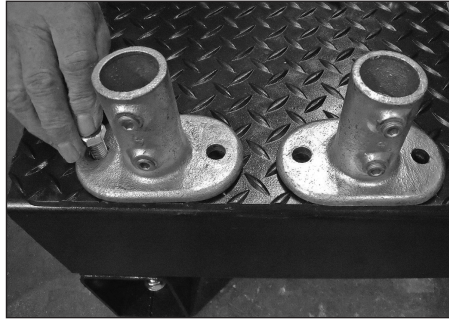
NOTICE

- **VE460 tools are equipped with a detachable safety-foot-switch cord. The safety foot switch can be removed easily for storage in the cabinet when the tool is not in use.**

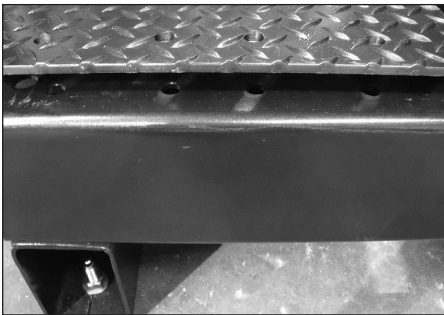
 **WARNING**

- Handrails must be installed and the electrical cord/safety foot switch cord must be routed through the support base(s) to prevent tripping hazards.

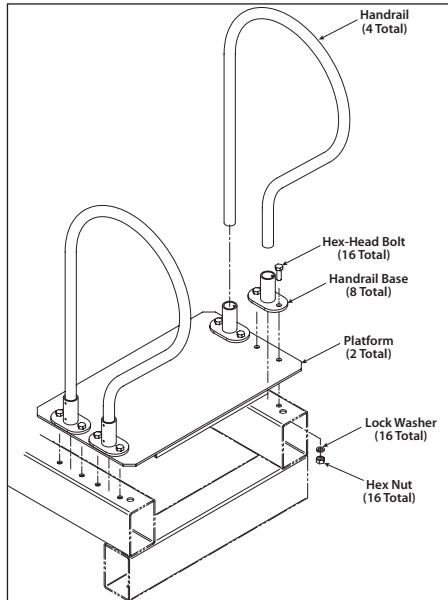
Failure to follow this instruction could result in serious personal injury.



16. Insert the power cord for the safety foot switch up through the support base(s). Plug the safety foot switch cord into the receptacle on the side of the tool by aligning the pins/tab of the male adapter plug with the receptacle. Tighten the locking ring on the plug.



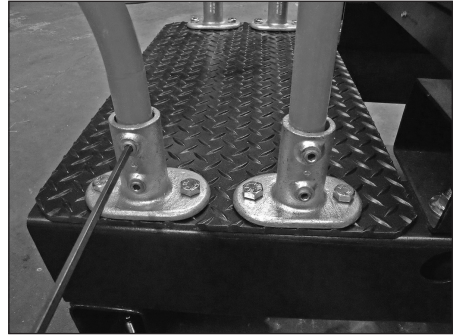
17. Install the platform onto the support base. Align the holes in the platform with the holes in the support base, as shown above. Repeat this step for the other side of the tool.



18. Install a handrail base onto the platform at the eight locations on the platform/tool support. Make sure the holes in the handrail bases align with the holes in the platforms/support base and that the set screws on the handrail bases face away from the platform, as shown above.
- 18a. Install a hex-head bolt through the handrail base and into the platform/tool support. Apply a lock washer and hex nut onto the end of each hex-head bolt.



18b. Tighten the hex nut completely until the lock washer is compressed fully.



18d. Tighten the two set screws on each handrail base to retain the handrails.



18c. Insert a handrail into each handrail base, as shown above.

19. Installation of the support base(s) is now complete. Proceed to the "Power Requirements" section.

POWER REQUIREMENTS

DANGER

- ONLY QUALIFIED ELECTRICIANS SHOULD CONNECT INCOMING POWER TO THE TOOL.**

- To reduce the risk of electric shock, check the electrical source for proper grounding.
- Always turn off the main power supply to the tool before making any tool adjustments or before performing any maintenance.
- DO NOT alter the plug in any way.

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

The VE460 is designed to operate on a 220/440-volt, 3-phase, 60-Hz power supply. The tools are shipped with the wiring set for 220-volt operation, unless specified otherwise on the order. To re-wire the VE460 for 440-volt, 60-Hz service, the following conversions must be made. Refer to the electrical schematic in the RP-VE460 Repair Parts List and the information contained on the nameplate on the tool's drive motor and hydraulic pump motor.

Conversions to 440-volt, 60-Hz Service Include:

1. Motor Connections
2. Fuse Changes
3. Thermal Overload Unit Changes
4. Transformer Connections

The circuit protection required for 220-volt operation is 20 amps. For 440-volt operation, 15-amp circuit protection is required. All VE460 components are grounded to the frame of the tool. Make sure the frame is properly grounded.

For other voltages and frequencies, contact Victaulic. **NOTE:** Operation with certain voltages (i.e. 380/400 volt, 3-phase, 50/60 Hz service) requires different motors and other electrical parts. Contact Victaulic for information regarding operation of a tool with an alternate voltage.

POWER HOOKUP AND VERIFICATION OF PIPE ROTATION DIRECTION

Each VE460 Roll Grooving Tool is provided with a label inside the main electrical enclosure, which identifies voltage ratings, etc. for the tool (refer to example below). Reference must be made to this label to ensure proper tool setup.

MODEL <input style="width: 100%;" type="text"/>			
SERIAL NUMBER <input style="width: 100%;" type="text"/>			
DRIVE MOTOR VOLTS		PHASE	HERTZ
208/230	<input type="checkbox"/>	1	50
440/460	<input type="checkbox"/>	3	60
380/400	<input type="checkbox"/>		50/60
		FULL-LOAD CURRENT	
		AMPS AT 220 VOLTS	
		AMPS AT 440 VOLTS	
		AMPS AT 380 VOLTS	
HYDRAULIC MOTOR VOLTS		PHASE	HERTZ
208/230	<input type="checkbox"/>	1	50
440/460	<input type="checkbox"/>	3	60
380/400	<input type="checkbox"/>		50/60
		FULL-LOAD CURRENT	
		AMPS AT 220 VOLTS	
		AMPS AT 440 VOLTS	
		AMPS AT 380 VOLTS	
<small> * GEAR OIL – AGMA 7 * HYDRAULIC OIL – HIGH-PRESSURE, ANTI-WEAR ISO GRADE 32 * BEARING LUBE – ANTI-WEAR, EXTREME-PRESSURE NLGI GRADE 2 </small>			
			<small>Electrical Assembly Drawing Revision Level</small> <input style="width: 50px;" type="text"/>

DANGER

- ONLY QUALIFIED ELECTRICIANS SHOULD CONNECT INCOMING POWER TO THE TOOL.**
- The tool must be grounded properly.

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

The VE460 Roll Grooving Tool is supplied with a ¾-inch nominal conduit opening for wiring incoming power. The conduit opening is located at the back of the tool near the main electrical enclosure.

Incoming electrical connections must be made inside the main electrical enclosure. The incoming, three-phase power must be connected at the top of the main breaker at the upper-right side within the main electrical enclosure.

1. Make the ground connection inside the main electrical enclosure.
2. Make 3-phase electrical connections to the circuit breaker of the tool.
3. After the power is connected properly, the tool must be checked for proper rotational direction.

The VE460 Roll Grooving Tool is equipped with a “**TEST (JOG)**” setting. Operating the tool in the “**TEST (JOG)**” setting allows for:

- Determining rotation of the tool’s lower roll
- Confirming that the pipe to be grooved is tracking properly on the lower roll



4. Turn the power switch on the side of the tool to the “**ON**” position.



5. Pull the “**STOP**” knob on the control panel and the electrical enclosure to the out position.



6. Place the switch on the control panel to the “**TEST (JOG)**” mode and momentarily depress the “**HYDRAULIC PUMP START**” button to energize the lower roll. Observe lower roll rotational direction. Release the “**HYDRAULIC PUMP START**” button to de-energize the lower roll. **NOTE:** The safety foot switch does not need to be depressed while the tool is in the “**TEST (JOG)**” mode.
7. Proper rotation of the lower roll is **CLOCKWISE** when viewed from the front of the tool. If rotation is clockwise, power hookup is complete.

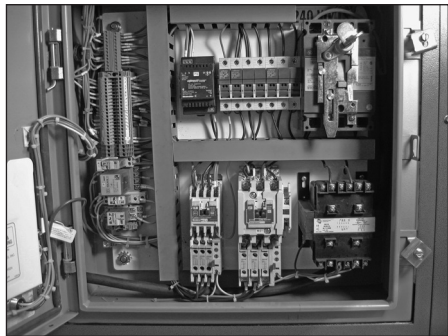
WARNING

- Always turn off the main power supply to the tool before making any tool adjustments.

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



8. If rotation of the lower roll is counter-clockwise, turn the power switch on the side of the tool to the **“OFF”** position and proceed with the following steps.



9. Turn off the main power supply to the tool (main breaker panel, knife switch, etc.). Lock the switch in the **“OFF”** position to prevent accidental engagement. **NOTE:** Victaulic does not supply this lockout mechanism.

10. Open the main enclosure by loosening the screw on the two brackets of the main enclosure. Push in the lever at the bottom of the handle while turning clockwise to open the main enclosure. Reverse any of the two incoming lines at the top of the main breaker (located at the upper-right side within the enclosure).
11. Close the main enclosure and re-tighten the screw on the two brackets.
12. Turn on the main power supply to the tool (main breaker panel, knife switch, etc.).

13. Follow steps 4 - 7 to check the rotational direction of the lower roll. If rotational direction is not clockwise, contact Victaulic. If rotational direction is clockwise, the power hookup procedure is complete.

PREPARING PIPE FOR GROOVING

For proper tool operation and production of grooves that are within Victaulic specifications, the following pipe preparation steps must be followed.

Victaulic recommends square-cut pipe for use with grooved-end pipe products. Square-cut pipe **MUST** be used with Victaulic FlushSeal® and EndSeal® gaskets. For 12-inch/323.9-mm and smaller pipe sizes, beveled-end pipe may be used with Victaulic standard and Vic-Flange gaskets, provided that the wall thickness is standard wall (ANSI B36.10) or less and that the bevel meets ANSI B16.25 (37½°) or ASTM A-53 (30°). **NOTE:** Roll grooving beveled-end pipe may result in unacceptable pipe flare. Beveled steel pipe in 14 - 60-inch/355.6 - 1524-mm sizes is acceptable with Victaulic Advanced Grooving System (AGS) standard or FlushSeal gaskets, including AGS Vic-Flanges.

1. For 12-inch/323.9-mm and smaller pipe sizes, raised internal and external weld beads and seams must be ground flush with the pipe surface 2 inches/50 mm back from the pipe ends.
 - 1a. For 14 - 38-inch/355.6 - 965-mm pipe sizes, raised internal and external weld beads and seams must be ground flush with the pipe surface 4 inches/100 mm back from the pipe ends.
 - 1b. For 40 - 60-inch/1016 - 1524-mm pipe sizes, raised internal and external weld beads and seams must be ground flush with the pipe surface 4½ inches/115 mm back from the pipe ends.
2. All coarse scale, dirt, and other foreign material must be removed from the interior and exterior surfaces of the pipe ends.

CAUTION

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

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

PIPE LENGTH REQUIREMENTS

VE460 tools are capable of grooving short pipe lengths without the use of a pipe stand. Table 1 identifies the minimum pipe lengths that can be grooved safely by using Victaulic Grooving Tools. In addition, this table identifies the maximum pipe lengths that can be grooved without the use of a pipe stand. Refer to the “Grooving Short Pipe Lengths” section for instructions on how to groove short pipe lengths. **NOTE:** Grooved pipe nipples, shorter than those listed in Table 1, are available from Victaulic.

Pipe lengths, longer than those listed in Table 1 (and up to 20 feet/6 meters), must be supported with a pipe stand. Pipe lengths, from 20 feet/6 meters up to double-random lengths (approximately 40 feet/12 meters), must be supported with two pipe stands. Refer to the “Long Pipe Lengths” section for instructions on how to groove long pipe lengths.

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

EXAMPLE: A 20-foot, 4-inch/6.2-m length of 10-inch diameter steel pipe is required to finish a section, and only 20-foot/6.1-m lengths are available. Instead of roll grooving a 20-foot/6.1-m length of steel pipe and a 4-inch/102-mm length of steel pipe, follow these steps:

1. Refer to Table 1, and note that for 10-inch diameter steel pipe, the minimum length that should be roll grooved is 10 inches/255 mm.
2. Roll groove a 19-foot, 6-inch/5.9-m length of pipe and a 10-inch/255-mm length of pipe. Refer to the “Long Pipe Lengths” section.

TABLE 1- PIPE LENGTHS SUITABLE FOR GROOVING

Steel, Stainless Steel, Aluminum, and PVC Pipe Size		Length – inches/mm	
Nominal Pipe Size inches or mm	Actual Outside Diameter inches/mm	Minimum	Maximum
108.0 mm	4.250 108.0	8 205	36 915
4	4.500 114.3	8 205	36 915
4½	5.000 127.0	8 205	32 815
133.0 mm	5.250 133.0	8 205	32 815
139.7 mm	5.500 139.7	8 205	32 815
5	5.563 141.3	8 205	32 815
152.4 mm	6.000 152.4	10 255	30 765
159.0 mm	6.250 159.0	10 255	30 765
165.1 mm	6.500 165.1	10 255	30 765
6	6.625 168.3	10 255	28 715
203.2 mm	8.000 203.2	10 255	24 610
216.3 mm	8.516 216.3	10 255	24 610
8	8.625 219.1	10 255	24 610
254.0 mm	10.000 254.0	10 255	20 510
267.4 mm	10.528 267.4	10 255	20 510
10	10.750 273.0	10 255	20 510
304.8 mm	12.000 304.8	12 305	18 460
318.5 mm	12.539 318.5	12 305	18 460
12	12.750 323.9	12 305	18 460
14 OD	14.000 355.6	12 305	16 410
377.0 mm	14.843 377.0	12 305	16 410
15 OD	15.000 381.0	12 305	16 410
16 OD	16.000 406.4	12 305	16 410

Steel, Stainless Steel, Aluminum, and PVC Pipe Size		Length – inches/mm	
Nominal Pipe Size inches or mm	Actual Outside Diameter inches/mm	Minimum	Maximum
426.0 mm	16.772 426.0	12 305	16 410
18 OD	18.000 457		
480.0 mm	18.898 480		
20 OD	20.000 508		
530.0 mm	20.866 530		
22 OD	22.000 559		
24 OD	24.000 610		
650.0 mm	25.591 650		
26 OD	26.000 660		
28 OD	28.000 711		
30 OD	30.000 762		
32 OD	32.000 813		
36 OD	36.000 914		
38 OD	38.000 965		
40 OD	40.000 1016		
42 OD	42.000 1067		
44 OD	44.000 1118		
46 OD	46.000 1168		
48 OD	48.000 1219		
52 OD	52.000 1321		
54 OD	54.000 1372		
56 OD	56.000 1422		
60 OD	60.000 1524		

NOTE: Always use a pipe stand when roll grooving pipe in these sizes. DO NOT roll groove pipe lengths shorter than 18 inches/ 460 mm in these sizes.

CHECKING AND ADJUSTING THE TOOL PRIOR TO GROOVING

Every Victaulic roll grooving tool is checked, adjusted, and tested at the factory prior to shipment. However, before attempting to operate the tool, the following checks and adjustments should be made to ensure proper tool operation.

WARNING

- Always turn off the main power supply to the tool before making any tool adjustments.

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

GROOVING ROLLS

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

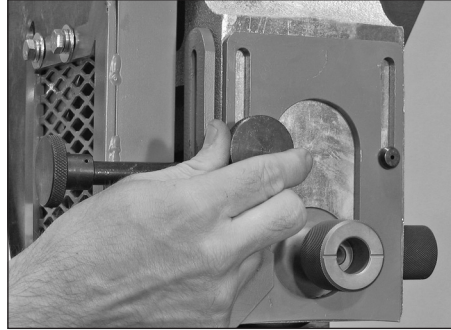
CAUTION

- Make sure the lower-roll retaining bolt is tight.

A loose lower-roll retaining bolt could cause damage to the tool and rolls.

ADJUSTING THE ROLL GUARDS

The VE460 tool features a “SET GUARD” control switch setting. With the correct pipe size and schedule inserted in the tool, the “SET GUARD” setting allows the operator to complete the necessary guard adjustments.



1. Loosen the knob on the front of the roll guards to raise the plate to its highest position. Tighten the knob.



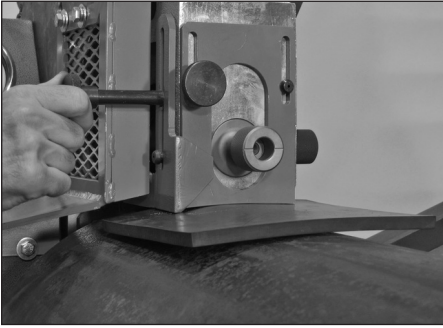
2. Insert a length of pipe that is the correct size and schedule over the lower roll. Make sure the pipe end contacts the lower-roll backstop flange. The pipe must rest directly on top of the roll and must not be skewed to one side or the other.



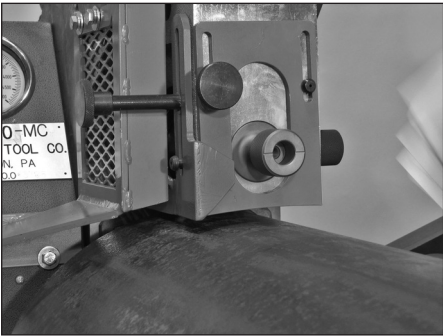
- Place the switch on the control panel to the **"SET GUARD"** mode. Depress the safety foot switch to place the tool's hydraulic system under pressure. Movement of the tool's ram/slide/upper roll will occur. When the upper roll contacts the pipe, an increase in hydraulic system pressure will show on the gauge. When as little as 75 - 100-psi pressure is showing on the gauge, release the safety foot switch. The ram assembly will remain down. If hydraulic pressure is not established, the ram will return to the neutral position as the safety foot switch is released.



- Prior to making tool guard adjustments, push down (in) on the red **"STOP"** knob on the control panel. The upper roll will continue to remain seated against the pipe.
- Use the appropriate guard setting pad. **NOTE:** Two guard setting pads are included. One is specifically for 12-inch/323.9-mm and smaller pipe sizes ($\frac{1}{4}$ -inch/6.4-mm thick guard pad), and the other is specifically for 14-inch/355.6-mm and larger pipe being grooved with AGS roll sets ($\frac{3}{8}$ -inch/9.5-mm thick guard pad with **"FOR AGS ONLY"** label).
- Hold the correct guard setting pad firmly against the pipe and push it under the roll guards. Loosen the knob on the front of the roll guards to drop the plate onto the guard setting pad. Tighten the knob.



7. Loosen the knob on the side of the roll guards to drop the sliding guard onto the guard setting pad. Tighten the knob.



8. Remove the guard setting pad from the pipe.



9. When tool guard adjustments are complete, pull the **"STOP"** knob on the control panel to the out position.



10. Depress and release the **"HYDRAULIC PUMP START"** button. The tool's hydraulic pump motor will energize and the tool's ram shaft will retract to the neutral position.
11. The guard setting procedure is complete.

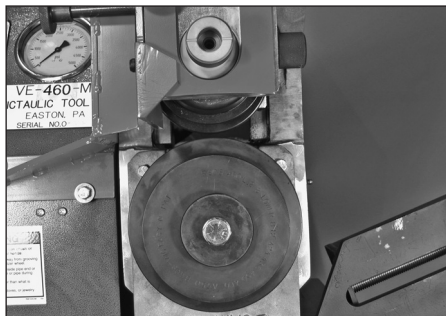
PIPE STABILIZER ADJUSTMENT

⚠ WARNING

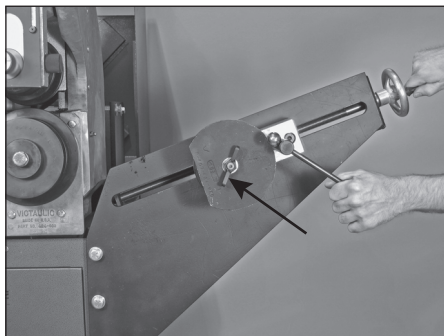
- Always turn off the main power supply to the tool before making any tool adjustments.
- DO NOT reach over pipe while making adjustments.
- DO NOT make adjustments while the tool/pipe is in operation/motion.

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

The pipe stabilizer for the VE460 is designed to prevent pipe sway of short and long pipe lengths. When the stabilizer is adjusted for a selected pipe size and wall thickness, it does not require further adjustment unless pipe of a different size and wall thickness will be grooved. Pipe of the same size and wall thickness can be moved in and out of the tool without retracting the stabilizer.



1. Make sure the proper roll set is installed on the tool for the pipe size and material to be grooved. Rolls are marked with the pipe size, part number, and they are color-coded according to the pipe material. Refer to the applicable "Tool Rating and Roll Selection" section.



2. Loosen the stabilizer locking handle and the stabilizer-roller-guard wing nut.
 - 2a. Using the stabilizer handwheel, retract the stabilizer roller to clear the pipe when it is inserted onto the lower roll.

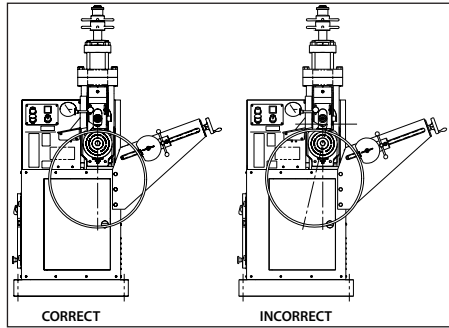


3. Insert a length of pipe that is the correct size and schedule over the lower roll. Make sure the pipe end contacts the lower-roll backstop flange. The pipe must rest directly on top of the roll and must not be skewed to one side or the other.

⚠ CAUTION

- **DO NOT** adjust the stabilizer roller to push the pipe to the left and off center from the rolls. Increased pipe-end flare and shortened roll life will result if the pipe is pushed to the left and off center.
- **DO NOT** reach across the pipe to make pipe stabilizer adjustments.
- **DO NOT** adjust the pipe stabilizer while the pipe is in motion.
- Assembly of couplings on pipe that exceeds the maximum allowable flare dimension may prevent proper pad-to-pad assembly of coupling housings and gasket distortion/damage.

Failure to prepare pipe in accordance with all instructions may cause joint failure, resulting in personal injury and/or property damage.



4. Using the stabilizer handwheel, adjust the stabilizer roller. Position the roller guard so that the roller opening faces the pipe directly. Tighten the stabilizer-roller-guard wing nut. Make sure the guard does not rub the pipe. Refer to the drawing above for proper positioning.
5. Complete all adjustments and groove the pipe. Refer to the “Grooving Operation” section. Observe the stabilizer roller while grooving. It should remain in contact with the pipe, and the pipe should rotate smoothly without swaying from side to side. If the pipe is not rotating smoothly or is swaying from side to side, discontinue grooving and adjust the stabilizer roller further inward. Continue the grooving operation and make further adjustments, as necessary. **DO NOT** adjust the stabilizer roller too far inward, since it will skew the pipe to the left and off center, resulting in excessive pipe-end flare.

RAM SPEED ADJUSTMENT

The ram speed adjustment is factory set for roll grooving steel pipe. When grooving a pipe material other than steel pipe, the ram speed may need to be re-adjusted.

1. Locate the key, which is inserted into the ram speed control valve at the factory.



2. Turn the key to unlock the ram speed control valve.
3. With the key inserted into the ram speed control valve, rotate the knob until it “locks in.” Adjust the ram speed control valve to the proper setting, as indicated in the table below.

Pipe Material	Ram Speed Control Valve Setting
Steel	2.5
Steel (Grooved to AGS Specifications)	2.5
Stainless Steel (Type 304/304L and Type 316/316L)	1.5
Stainless Steel (Type 304/304L and Type 316/316L Grooved to AGS Specifications)	2.5
Aluminum (Types 6061-T4 and 6063-T4)	3.0
PVC	10.0

4. After the ram speed is set, re-lock the ram speed control valve into position and remove the key. Store the key in a safe location on the tool.

NOTICE

- The ram speed affects only the rate at which the upper roll forms the groove. It does not affect the rate at which the upper roll advances to contact the pipe, nor does it affect the rate at which the roll retracts from the pipe at the completion of a groove.
- Ram speed during the formation of a groove can have a significant effect on pipe flare. The settings listed in the table on this page will produce excellent grooves in most situations. However, if excessive flare results at these settings, reduce the setting to correct the condition. For example, adjust the ram-speed control valve to 1.5 or 2.0 for steel pipe when flare is excessive at the 2.5 setting.

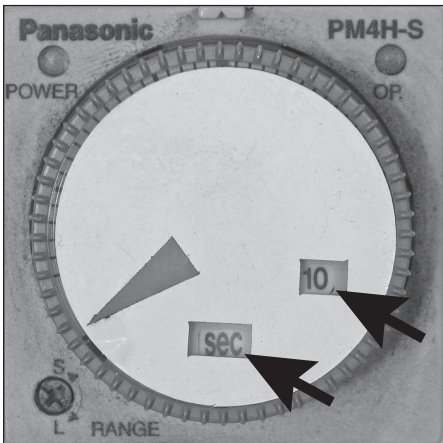
DWELL CONTROL ADJUSTMENT

The dwell control adjustment controls the length of time the tool continues to rotate the pipe after the groove diameter stop contacts the top of the hydraulic cylinder. The dwell control timer is adjustable for time range and pipe size settings.

When adjusted to the proper pipe size, the pipe will rotate a minimum of one revolution after the groove diameter stop contacts the hydraulic cylinder. This ensures that the groove in the pipe will be of uniform depth around the entire pipe circumference.

TIME RANGE ADJUSTMENT

The time range setting will set the operating parameters of the timer.

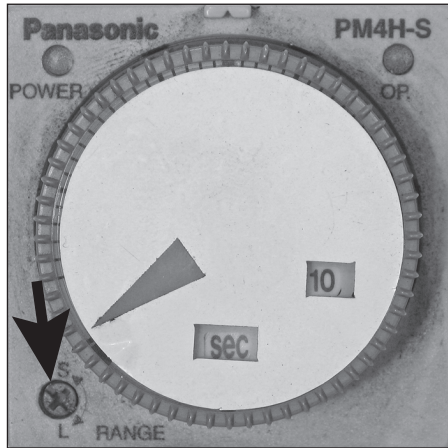


1. To adjust the time range setting, rotate the timer dial counterclockwise completely until the range settings are visible on the dial.

CAUTION

- Use only a #0 Phillips-head screwdriver to adjust the range screw.

Failure to follow this instruction may damage the screw head.



2. If necessary, rotate the time range screw, located in the lower left-hand corner of the timer, to the desired range shown on the dial face. **NOTE:** VE460 tools are factory set in the “SEC-10” position. Use only a #0 Phillips head screwdriver to adjust the range screw. Use of any tools other than a #0 Phillips-head screwdriver may damage the screw head.
 - For 4 – 38-inch/114.3 – 965.0-mm pipe sizes, set the timer range to “SEC-10”
 - For 40 – 60-inch/1016.0 – 1524.0-mm pipe sizes, set the timer range to “SEC-50”

CAUTION

- The timing range must be set properly for the pipe size being grooved.

Failure to follow this instruction could cause excessive or insufficient dwell, resulting in improper groove diameters and grooves that are not uniform in depth.

PIPE SIZE ADJUSTMENT



1. Rotate the timer dial to the appropriate pipe size.
- 4 – 38-inch/114.3 – 965.0-mm pipe sizes are detailed in black. Make sure the timer range is set to “SEC-10.”
- 40 – 60-inch/1016.0 – 1524.0-mm pipe sizes are detailed in red. Make sure the timer range is set to “SEC-50.”

GROOVE DIAMETER STOP ADJUSTMENTS

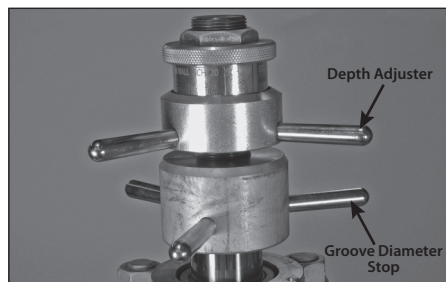
The groove diameter stop must be adjusted for each pipe size or change in wall thickness. The groove diameter, which is identified as the “C” dimension, is listed under the “Roll Groove Specifications” section. In addition, a label is affixed to the tool, which lists the “C” dimensions.

NOTICE

- To perform the following adjustments, Victaulic recommends the use of several short, scrap sections of pipe that are the proper material, diameter, and thickness to be grooved. Make sure the scrap sections meet the length requirements listed in Table 1.

To achieve the proper diameter:

1. Determine the diameter and thickness of the pipe to be grooved.
2. Locate the proper diameter and thickness on the pipe size indicator label of the depth stop. The pipe size indicator barrel can be rotated for easy viewing.



3. Unlock the depth adjuster from the groove diameter stop.
- 3a. Align the top edge of the depth adjuster with the lowest line position of the proper size and schedule markings.
- 3b. Hold the depth adjuster to prevent it from turning.



4. Turn the groove diameter stop counter-clockwise to lock the depth adjuster in this position.

NOTICE

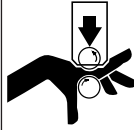
- Rotating the depth adjusters while locked will cause premature thread wear of the depth adjusters and cylinder ram.
- The markings provide an approximate groove diameter adjustment and are not exact groove diameter settings. Variations in pipe OD and wall thickness make it impossible to calibrate the groove diameter stop exactly.
- Set the initial adjustment shallow (at bottom edge of mark), groove a sample piece of pipe, then make the final adjustment.



5. Insert a length of pipe over the lower roll with the pipe end against the lower-roll backstop flange.



WARNING



Grooving rolls can crush or cut fingers and hands.

- Always turn off the main power supply to the tool before making any tool adjustments.
- Loading/unloading pipe will place your hands close to the rollers. 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.
- Always groove pipe in a **CLOCKWISE** direction.
- Never groove pipe that is shorter than the recommended lengths listed in this manual.
- Never wear loose clothing, loose gloves, or anything that can become entangled in moving parts.

6. Prepare a trial groove. Refer to the "Grooving Operation" section.

NOTICE

- Occasionally during grooving, the groove diameter stop may move up and down slightly, making contact and then breaking contact with the hydraulic cylinder. This is normal for pipe that has a noticeable weld seam or hard spot.



7. After a trial groove is prepared and the pipe is removed from the tool, check the groove diameter (“C” dimension) carefully. Refer to the “Roll Groove Specifications” section. A standard pipe tape, supplied with the tool, is the best method for checking the “C” dimension. In addition, a vernier caliper or narrow-land micrometer can be used to check this dimension at two locations (90° apart) within the groove. The average reading must be within the required groove diameter specification.
8. If the groove diameter (“C” dimension) is not within Victaulic specifications, the diameter stop must be adjusted.
 - 8a. Unlock the depth adjusters.
 - 8b. To adjust for a smaller groove diameter, loosen the groove diameter stop and turn the depth adjuster counter-clockwise (when viewed from above the tool). Turn the groove diameter stop counter-clockwise to lock the depth adjuster in this position.
 - 8c. To adjust for a larger groove diameter, loosen the groove diameter stop and turn the depth adjuster clockwise (when viewed from above the tool). Turn the groove diameter stop counter-clockwise to lock the depth adjuster in this position.

NOTE: A quarter turn either way will change the groove diameter by 0.042 inch/1.1 mm or 0.167 inch/4.2 mm per full turn.

NOTICE

- **Rotating the depth adjusters while locked will cause premature thread wear of the depth adjusters and cylinder ram.**

9. Prepare another trial groove, and check the groove diameter (“C” dimension), as described in previous steps. Repeat these steps, as necessary, until the groove diameter is within specification.

CAUTION

- **The “C” dimension (groove diameter) must conform to Victaulic specifications to ensure proper joint performance.**

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

GROOVING SHORT PIPE LENGTHS

DANGER



- To reduce the risk of electric shock, check the tool for proper grounding and follow all instructions.
- Before operating the tool, review the “Operator Safety Instructions” section of this manual.

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

CAUTION

- This tool must be used **ONLY** for roll grooving pipe designated in the applicable “Tool Rating and Roll Selection” section of this manual.

Failure to follow this instruction could overload the tool, resulting in reduced tool life and/or damage to the tool.

1. Before grooving, make sure all instructions in the previous sections of this manual have been followed.
2. Turn on the main power supply to the tool (main breaker panel, knife switch, etc.).



3. Turn the power switch on the side of the tool to the “ON” position.



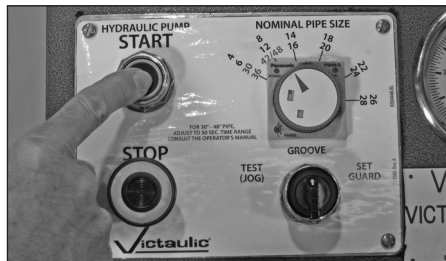
4. Make sure the switch on the control panel is set to the “GROOVE” position.

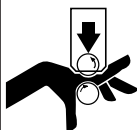


- 4a. Pull the “STOP” knob on the control panel to the out position, and make sure the “STOP” knob on the electrical enclosure is pulled to the out position.



5. Push the “HYDRAULIC PUMP START” button.



! WARNING

Grooving rolls can crush or cut fingers and hands.

- Always turn off the main power supply to the tool before making any tool adjustments.

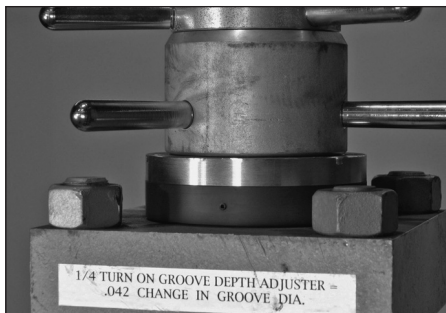
- Loading/unloading pipe will place your hands close to the rollers. Keep hands away from the grooving rolls and the roller on the pipe stabilizer during operation.
- Never reach inside the pipe ends or across the tool or pipe during operation.
- Always groove pipe in a **CLOCKWISE** direction.
- Never groove pipe that is shorter than the recommended lengths listed in this manual.
- Never wear loose clothing, loose gloves, or anything that can become entangled in moving parts.



6. Insert a length of pipe that is the correct size and thickness onto the lower roll. Make sure the pipe end contacts the lower-roll backstop flange completely. While manually supporting the pipe, depress and hold down the safety foot switch. The upper roll will advance and contact the pipe. Remove hands from the pipe.

NOTICE

- Occasionally during grooving, the groove diameter stop may move up and down slightly, making contact and then breaking contact with the hydraulic cylinder. This is normal for pipe that has a noticeable weld seam or hard spot.



7. As grooving continues, the groove diameter stop will move down and contact the hydraulic cylinder. This contact activates the dwell timer, which allows the pipe to rotate one to three more revolutions to ensure groove completion (refer to the "Dwell Control Adjustment" section).
 - 7a. Release the safety foot switch, and withdraw foot from the switch.
 - 7b. Prepare to support the pipe because the tool will release the pipe automatically.
8. If no more roll grooving will be performed for a while, turn off the hydraulic system by pushing down (in) either the red **"STOP"** knob on the control panel or the electrical enclosure.

NOTICE

- **The groove diameter must be within specification for the diameter and wall thickness of pipe. The groove diameter should be checked and adjusted, as necessary, to ensure grooves remain within specification.**

GROOVING LONG PIPE LENGTHS

⚠ DANGER

- To reduce the risk of electric shock, check the tool for proper grounding and follow all instructions.
- Before operating the tool, review the “Operator Safety Instructions” section of this manual.

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

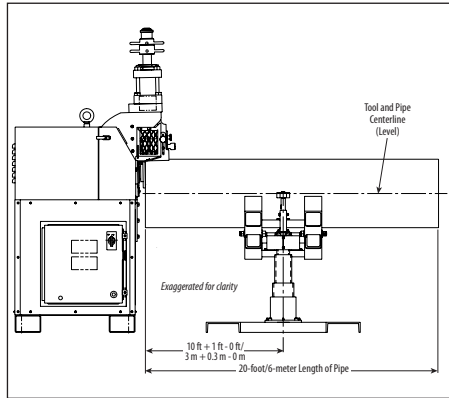
⚠ CAUTION

- For long pipe lengths, make sure the pipe stand is positioned properly to minimize pipe-end flare.
- **DO NOT** install couplings on pipe that exceeds the maximum allowable flare.
- This tool must be used **ONLY** for roll grooving pipe designated in the applicable “Tool Rating and Roll Selection” section of this manual.
- Always refer to the applicable “Roll Groove Specifications” table for details.

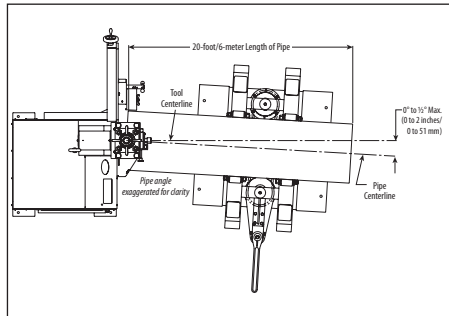
Failure to follow these instructions could cause product failure, resulting in property damage.

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

1. Make sure the tool is level. Refer to the “Tool Setup” section for leveling requirements.



2. Place the pipe stand at a distance slightly beyond half the pipe length from the tool. Refer to the drawing above.



3. Position the pipe stand approximately 0 - ½ a degree to the left of the tracking angle. Refer to the drawing above. **NOTE:** When pipe flare is excessive, right-to-left tracking must be kept to a minimum. It may be necessary to use less than ½ a degree for the tracking angle.
4. If the tool is properly set up in a level position, but the back end of the pipe is higher than the end being grooved, the pipe may not track. In addition, excessive flare may occur on the pipe end. Refer to the “Tool Setup” section and the drawings above for tool setup and pipe positioning requirements.

5. Before grooving, make sure all instructions in the previous sections of this manual have been followed.
6. Turn on the main power supply to the tool (main breaker panel, knife switch, etc.).



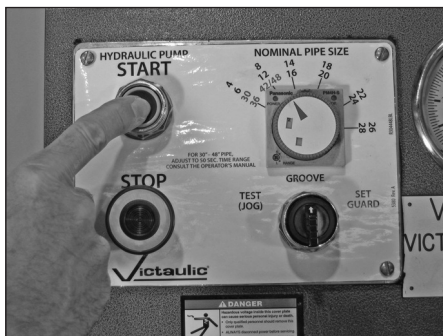
7. Turn the power switch on the side of the tool to the "ON" position.



8. Pull the "STOP" knob on the control panel and the electrical enclosure to the out position.

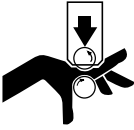


9. Make sure the switch on the control panel is set to the "GROOVE" position.



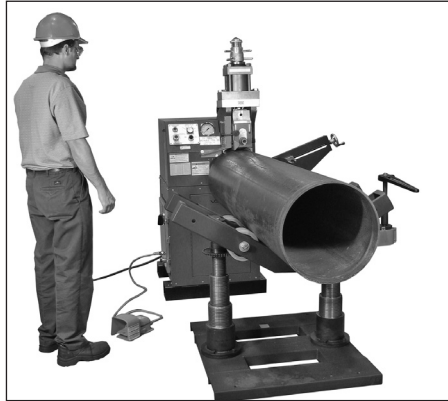
- 9a. Push the "HYDRAULIC PUMP START" button.

WARNING

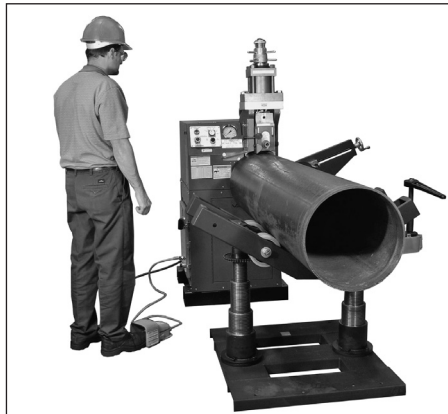


Grooving rolls can crush or cut fingers and hands.

- Always turn off the main power supply to the tool before making any tool adjustments.
- Loading/unloading pipe will place your hands close to the rollers. 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.
- Always groove pipe in a **CLOCKWISE** direction.
- Never groove pipe that is shorter than the recommended lengths listed in this manual.
- Never wear loose clothing, loose gloves, or anything that can become entangled in moving parts.



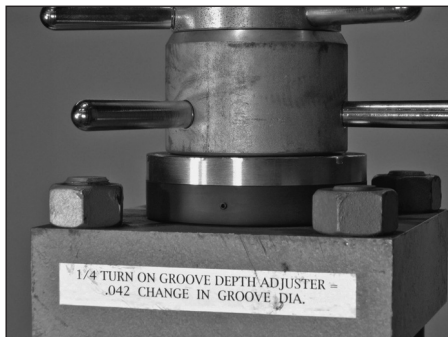
11. The operator should be positioned, as shown above.



12. To start the grooving operation, depress and hold down the safety foot switch. This will advance the upper roll into contact with the pipe. The lower roll will start rotating, and the groove will begin to form.
13. During the grooving operation, visually check the tracking of the pipe as it rotates. Make sure the pipe remains against the lower-roll backstop flange. If the pipe does not stay in contact with the lower-roll backstop flange, stop the tool by releasing the safety foot switch, and withdraw pipe from the switch. Make sure pipe is positioned properly (refer to the "Long Pipe Lengths" section). Repeat steps 10 - 12.



10. Insert a length of pipe that is the correct size and thickness onto the lower roll. Make sure the pipe end contacts the lower-roll backstop flange completely. Remove hands from the pipe.



14. As grooving continues, the groove diameter stop will move down and contact the hydraulic cylinder. This contact activates a timer, which allows the pipe to rotate one to three more revolutions to ensure groove completion (refer to the “Dwell Control Adjustment” section). The tool will automatically release the pipe a few seconds later. Release the safety foot switch, and withdraw foot from switch.

NOTICE

- **Occasionally during grooving, the groove diameter stop may move up and down slightly, making contact and then breaking contact with the hydraulic cylinder. This is normal for pipe that has a noticeable weld seam or hard spot.**
- **Make sure short pipe lengths are properly supported.**

15. If no more roll grooving will be performed for a while, turn off the hydraulic system by pushing down (in) either the red “STOP” knob on the control panel or the electrical enclosure.

NOTICE

- **If the pipe remains lodged on the lower roll:
Jogging the lower roll will free the pipe. DO NOT attempt to pull the pipe out of the rolls while “jogging” the lower roll. Pull the “STOP” knob on the control panel and the electrical enclosure to the out position, depress the “Hydraulic Pump Start” button, then push down (in) on the red “STOP” knob on the control panel and the electrical enclosure to “jog” the lower roll.**
- **The groove diameter must be within specification for the diameter and wall thickness of pipe. The groove diameter should be checked and adjusted, as necessary, to ensure grooves remain within specification.**

ROLL CHANGING

VE460 roll grooving tools are designed with rolls to accommodate several pipe sizes and materials, which eliminates the need for frequent roll changes.

When a different pipe size or material is required for grooving, the upper and lower rolls must be changed. For proper roll selection, refer to the “Tool Rating and Roll Selection” section.

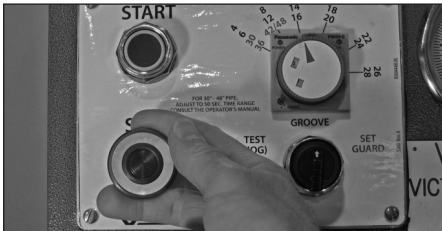
NOTICE

- Upper and lower rolls are matched components and must not be intermixed.

1. Turn on the main power supply to the tool (main breaker panel, knife switch, etc.).



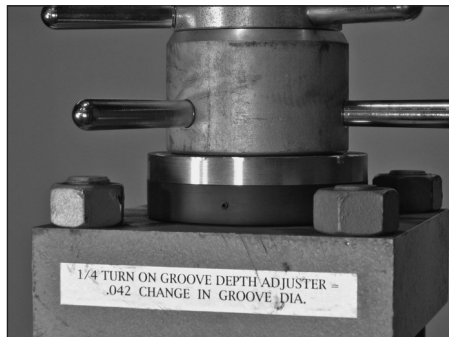
2. Turn the power switch on the side of the tool to the “ON” position.



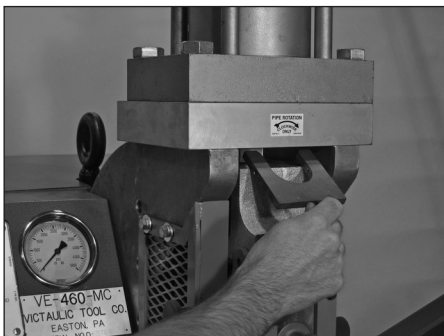
3. Pull the “STOP” knob on the control panel and the electrical enclosure to the out position.



4. Push the “HYDRAULIC PUMP START” button.



5. Depress the safety foot switch. When the groove diameter stop contacts the hydraulic cylinder, push down (in) on the red “STOP” knob on the control panel. Release the safety foot switch, and withdraw foot from switch.



6. Remove the slide spacer by snapping it out of the tool head, as shown above.



7. Pull the **"STOP"** knob on the control panel to the out position.



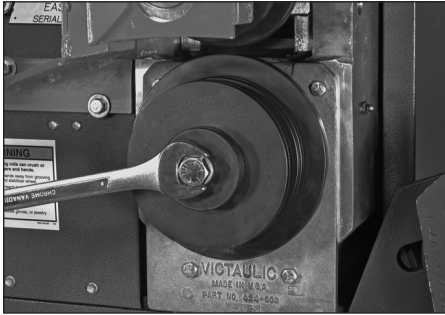
8. Push the **"HYDRAULIC PUMP START"** button to retract (raise) the slide.



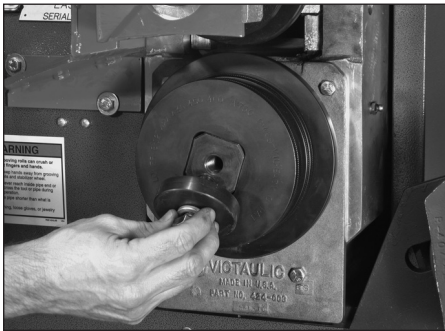
9. After the slide is retracted (raised) completely, push down (in) on the red **"STOP"** knob on the control panel.



10. Turn the power switch on the side of the tool to the **"OFF"** position.

LOWER ROLL REMOVAL

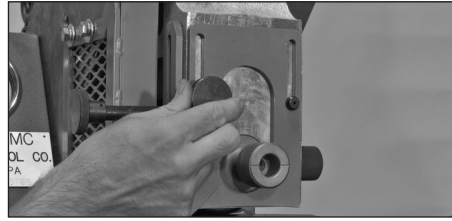
1. Using an appropriate wrench, loosen the lower-roll retaining bolt.



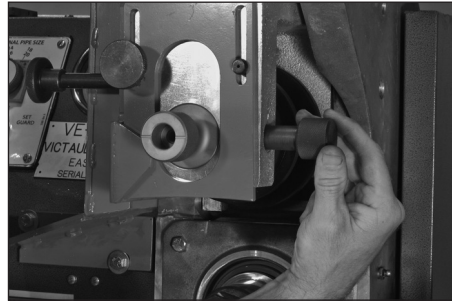
2. Remove the lower-roll retaining bolt and the lower-roll washer.



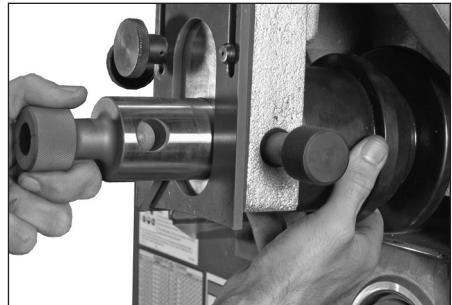
3. Remove the lower roll by pulling it off the main shaft. Store the lower roll inside the tool cabinet. If the lower roll cannot be removed by hand, use a conventional gear puller.

UPPER ROLL REMOVAL

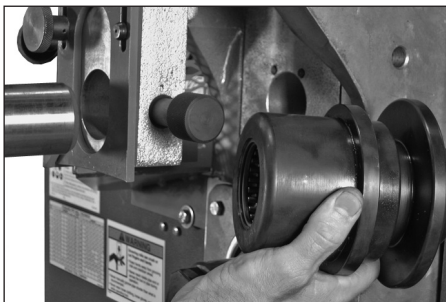
1. Adjust the front roll guard downward, if necessary, to fully uncover the upper shaft.



2. Pull the upper shaft pin out of the slide until it stops.



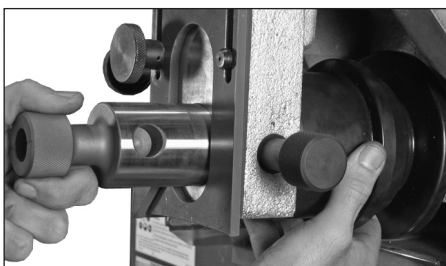
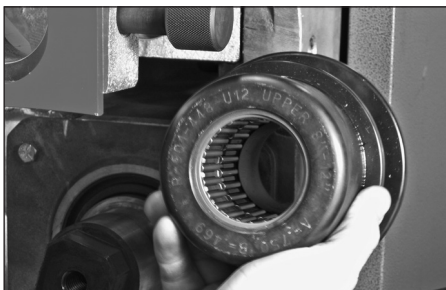
3. While supporting the upper roll, remove the upper shaft from the upper roll/slide by pulling it straight out.



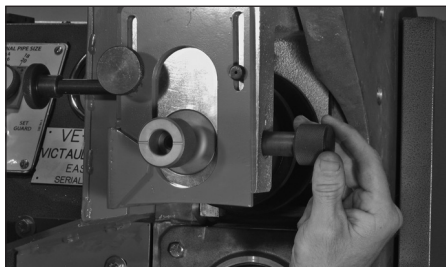
- 3a. Remove the upper roll. Store the upper roll inside the tool cabinet.

UPPER ROLL INSTALLATION

1. Prior to installation, clean the upper shaft and the upper roll to remove any dirt and scale. Inspect the bearing in the upper roll for proper lubrication and condition. If damage is present, replace any affected components.

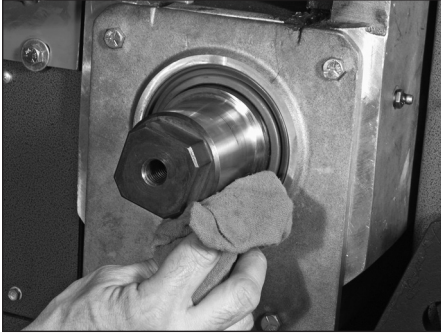


2. Install the proper upper roll behind the slide, as shown above. Make sure the markings on the upper roll are facing forward. While supporting the upper roll, insert the upper shaft into the slide and upper roll.

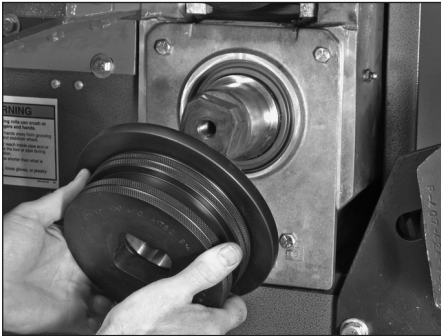


3. Align the hole in the upper shaft with the hole in the side of the slide. Push the upper shaft pin into the slide/upper shaft until it stops. **NOTE:** Hole orientation lines are marked on the front of the upper shaft.

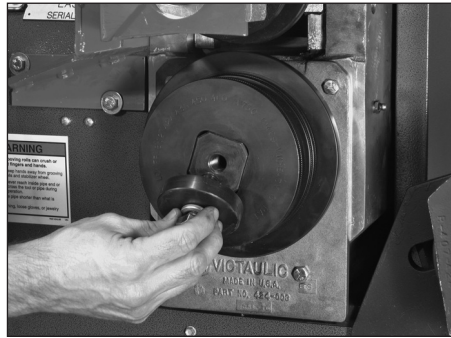
LOWER ROLL INSTALLATION



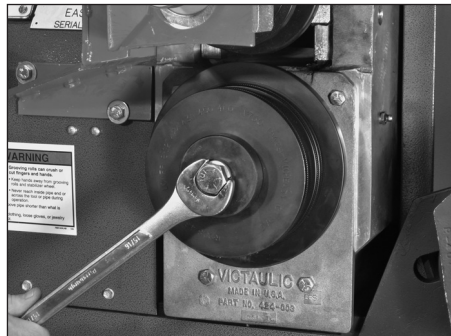
1. Prior to installation, clean the main shaft and the lower roll bore to remove any dirt and scale.
2. To aid in removing the lower roll at a later time, a dry graphite spray or anti-seize lubricant can be applied to the main shaft before the lower roll is installed.



3. Align the square end of the main shaft with the square hole in the lower roll. Push the lower roll completely onto the main shaft. Make sure the markings on the lower roll are facing out.



4. Install the lower-roll washer and lower-roll retaining bolt.



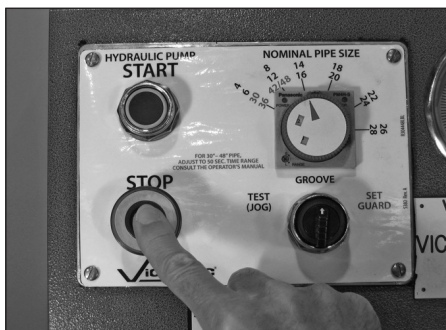
5. Tighten the lower-roll retaining bolt completely to secure the lower roll onto the main shaft.



6. Turn the power switch on the side of the tool to the "ON" position.



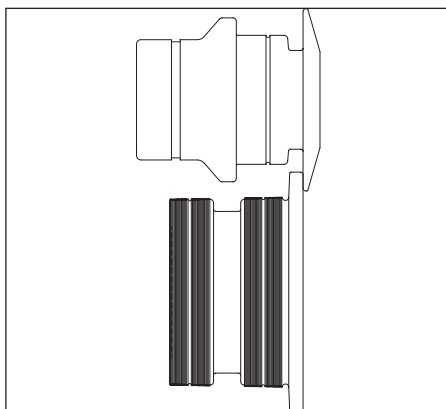
7. Pull the **"STOP"** knob on the control panel to the out position.



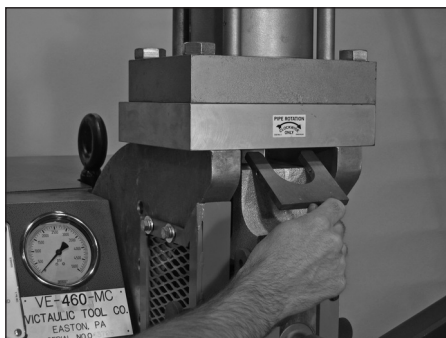
8. Push the **"HYDRAULIC PUMP START"** button.



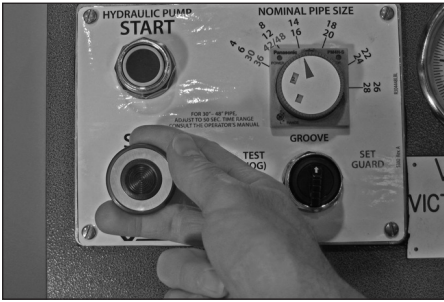
- 8a. Place the switch on the control panel to the **"SET GUARD"** mode. Depress and hold the safety foot switch. The upper roll and slide will start to move downward.



9. After the upper roll/slide has advanced approximately 1 inch/25 mm and the rolls are aligned and engaged, push down (in) on the red **"STOP"** knob on the control panel.



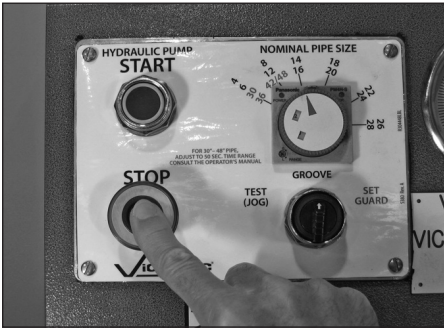
10. Snap the slide spacer into the tool, as shown above.



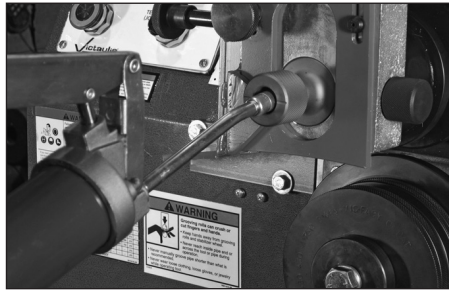
11. Pull the **“STOP”** knob on the control panel to the out position.



12. Push the **“HYDRAULIC PUMP START”** button to fully retract (raise) the slide.




13. After the slide has retracted (raised) completely, push down (in) on the red **“STOP”** knob on the control panel.



14. Grease the upper shaft bearings, as shown, by applying grease through the lubrication fitting on the front of the upper shaft. Refer to the applicable **“Recommended Lubricants”** table for the proper grease.
15. Roll set installation is now complete. Before grooving, make sure all instructions in the previous sections of this manual have been followed (i.e. adjusting the roll guards, adjusting the groove diameter stop, etc.).

MAINTENANCE

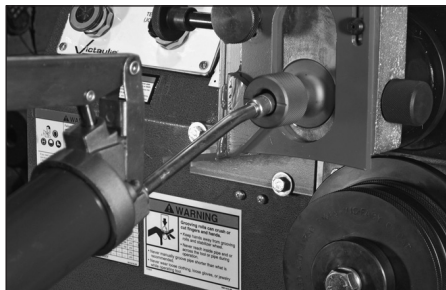
⚠ DANGER	
	<ul style="list-style-type: none"> Always turn off the main power supply to the tool before making any tool adjustments or before performing any maintenance.
<p>Failure to follow this instruction could result in death or serious personal injury.</p>	

This section provides information about keeping tools in proper operating condition and guidance for making repairs when it becomes necessary. Preventive maintenance during operation will pay for itself in repair and operating savings.

Replacement parts must be ordered from Victaulic to ensure proper and safe operation of the tool.

LUBRICATION

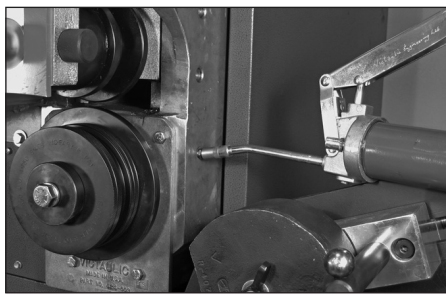
- After every 8 hours of operation, lubricate the tool. Always lubricate the upper roll bearings when rolls are changed.



- Grease the upper shaft bearings every time roll changes are made and after every 8 hours of operation. A grease fitting is provided on the front of the upper shaft. Refer to the applicable "Recommended Lubricants" table for the proper grease.



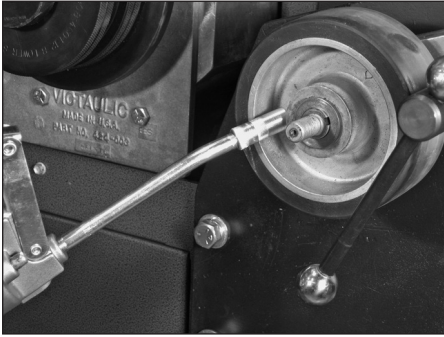
- Grease the slide gibs. The slide gib grease fitting is located on the back of the slide and is accessible when the tool hood is open.



- Grease the main shaft bearings through the fitting located on the side of the tool.



- Remove the stabilizer-roller-guard wing nut and stabilizer roller guard.



5a. Grease the stabilizer roller.

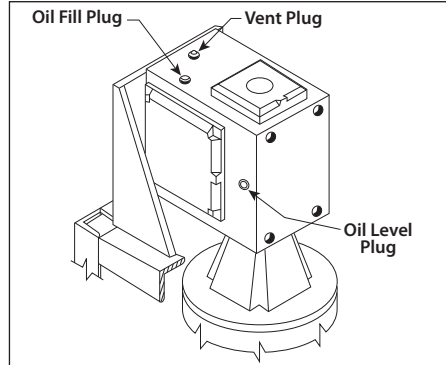


5b. Replace the stabilizer roller guard and stabilizer-roller-guard wing nut.

CHECKING AND FILLING GEAR REDUCER OIL

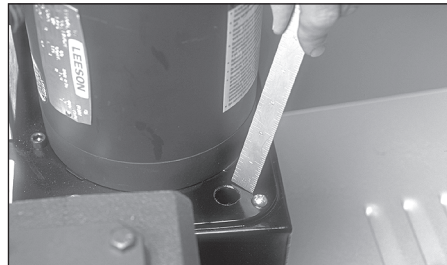
The gear reducer oil level must be checked annually. If leakage is present, repairs must be made to correct the leak.

1. Remove the oil level plug from the gear reducer (refer to drawing below). The oil level should be even with the bottom of the hole.



2. To add oil, remove the plug from the top of the gear reducer and fill to the proper level (refer to drawing above). Refer to the card attached to the gear reducer for the proper lubricant.
3. Re-install the plug(s).

CHECKING AND FILLING HYDRAULIC OIL

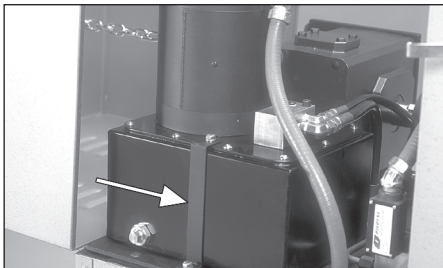


1. Check the hydraulic oil level on a monthly basis. The level should be 1 – 2 inches/25 – 50 mm below the top of the tank. DO NOT over-fill the tank, since the oil may overflow due to thermal expansion. Refer to the applicable “Recommended Lubricants” table for the proper hydraulic oil.

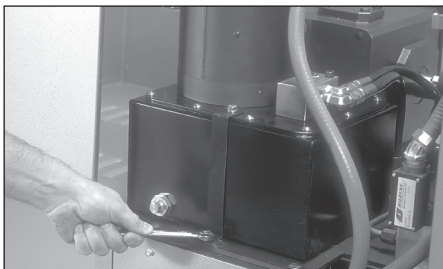
REPLACING HYDRAULIC OIL AND FILTER

Replace the hydraulic oil and oil filter annually or every 2000 hours of operation, whichever comes first.

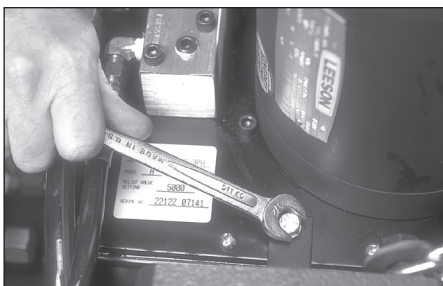
1. Raise the hood of the tool.



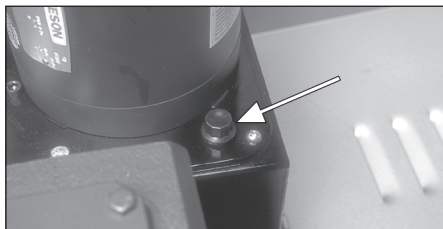
2. Locate the two brackets that hold the oil reservoir to the frame.



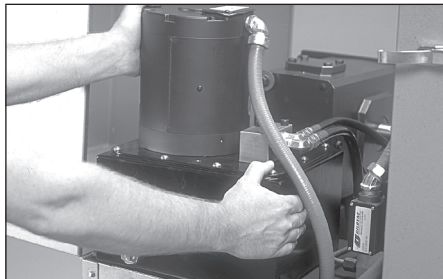
3. Loosen the screws on the bracket closest to the drain plug. Remove the bracket and set it aside.



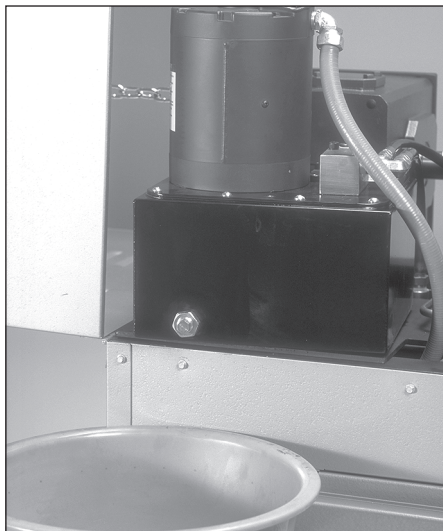
4. On the other bracket, loosen and remove the screw on top of the reservoir. There is no need to loosen the screw that holds the bracket to the frame.



5. Remove the fill/vent plug from the top of the reservoir.



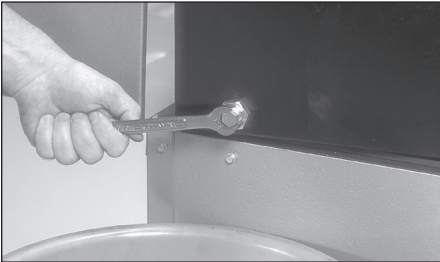
6. Slide the reservoir partially over the side of the tool. DO NOT disconnect any electrical or hydraulic lines.



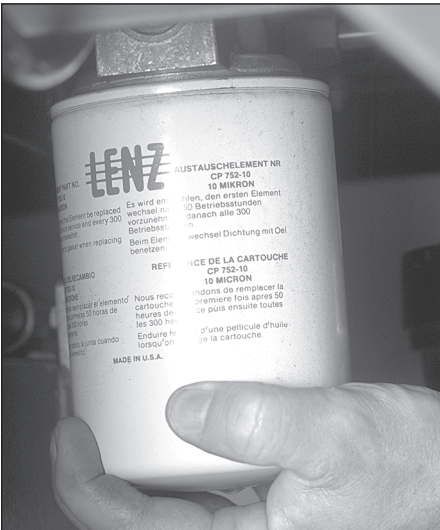
7. Position a container underneath the drain plug. Make sure the container is large enough to hold 2 gallons/8 liters of oil.



8. Remove the drain plug to drain the oil.



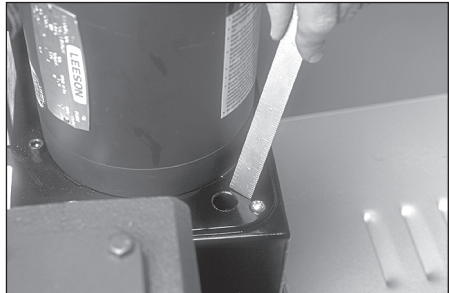
9. Replace the drain plug. Slide the reservoir back into position, and re-attach the brackets.



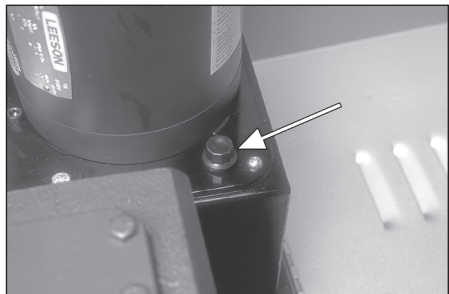
10. Place a tray under the oil filter. Unscrew the oil filter.



11. Lubricate a new oil filter gasket with new hydraulic oil. Fill the filter with oil. Install the new filter hand-tight.



12. Fill the tank with new hydraulic oil to 1 – 2 inches/25 – 50 mm from the top of the tank. Refer to the applicable "Recommended Lubricants" table.



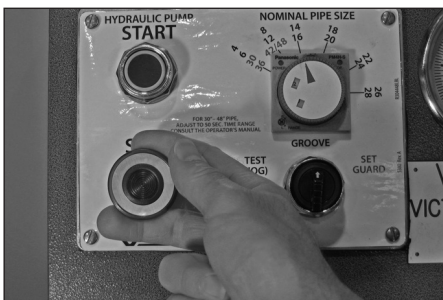
13. Install the fill/vent plug.
14. Turn on the main power supply to the tool (main breaker panel, knife switch, etc.).



15. Turn the power switch on the side of the tool to the **“ON”** position.



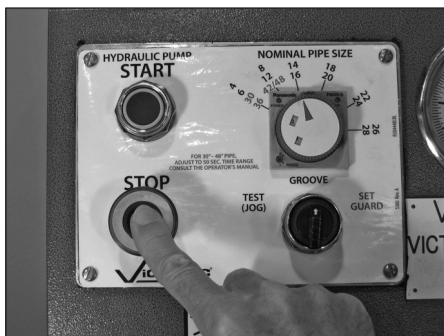
17. Push the **“HYDRAULIC PUMP START”** button.



18. Check the hydraulic oil level. Add oil, as necessary.

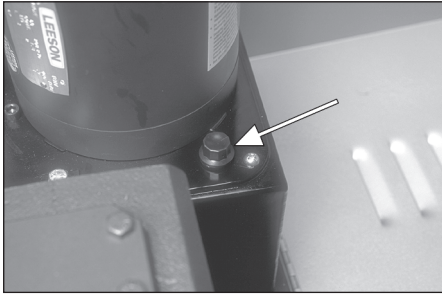


16. Pull the **“STOP”** knob on the control panel and the electrical enclosure to the out position.

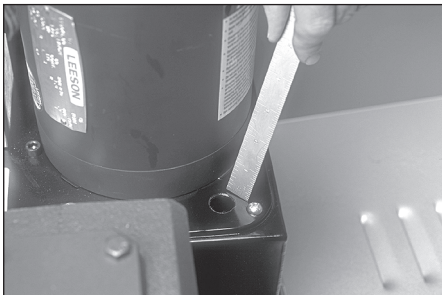


19. Push down (in) on the red **“STOP”** knob on the control panel.
20. Follow the **“Air Bleeding”** section.

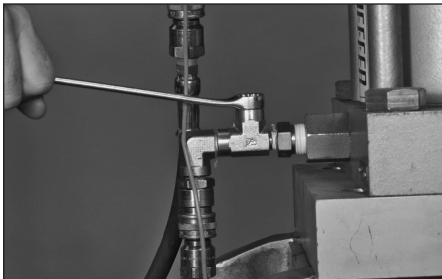
AIR BLEEDING



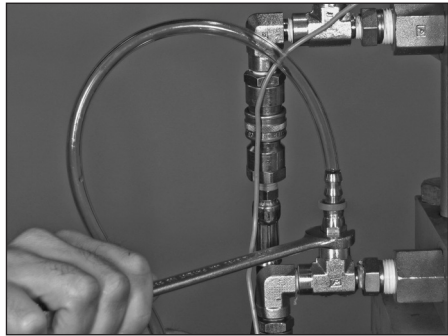
1. Remove the fill/vent plug from the hydraulic tank.



2. Bring the hydraulic oil level up to 1 – 2 inches/25 – 50 mm from the top of the tank. Refer to the applicable “Recommended Lubricants” table for the proper hydraulic oil.



3. Remove the plug from the tee at the bottom of the hydraulic cylinder port.



4. Install the bleeder tube into the tee, as shown above. Insert the other end of the bleeder tube into the fill/vent hole in the hydraulic tank. **NOTE:** The bleeder tube consists of a ¼-inch NPT barb hose fitting and 4 feet/1.2 m of ¼-inch ID clear vinyl hose (supplied with the tool).
5. Turn on the main power supply to the tool (main breaker panel, knife switch, etc.).



6. Turn the power switch on the side of the tool to the “ON” position.



7. Pull the **“STOP”** knob on the control panel to the out position.



10. Push down (in) on the red **“STOP”** knob on the control panel.



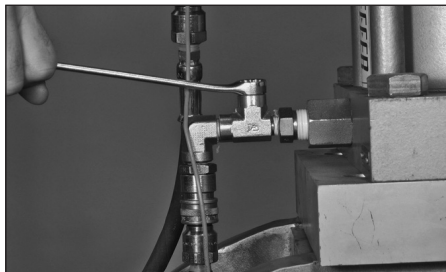
8. Push the **“HYDRAULIC PUMP START”** button. Hydraulic oil will start flowing from the tee through the bleeder tube and into the tank.



- 8a. Place the switch on the control panel to the **“SET GUARD”** mode.
9. Depress the safety foot switch, hold it down for 5 seconds, the release it for 5 seconds. Repeat this step until no air bubbles can be seen through the clear vinyl tube.

NOTICE

- To prevent oil from flowing out of the tee while removing the bleeder tube and installing the plug: Block the groove diameter stop from moving down by inserting a piece of wood between the groove diameter stop and the top of the hydraulic cylinder.



11. Remove the bleeder tube, and install the plug into the tee. **DO NOT ALLOW AIR TO GET BACK INTO THE TEE WHEN INSTALLING THE PLUG (REFER TO NOTICE BELOW).**

NOTICE

- **To prevent air from entering the tee while the bleeder tube is removed and the plug is installed: Hold the 4-way valve in the “shifted” position by pressing in on the rubber boot on the end of the valve. Keep the rubber boot depressed until the plug is installed and tightened.**

12. Repeat steps 4 – 11 for bleeding air from the tee at the top of the hydraulic cylinder port.
13. Bring the hydraulic oil level up to 1 – 2 inches/25 – 50 mm from the top of the tank. Refer to the applicable “Recommended Lubricants” table for the proper hydraulic oil.

RECOMMENDED LUBRICANTS

BEARING AND SLIDE GREASE

(General Purpose EP Lithium Base Grease)

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

GEAR OIL

Refer to the tag located on the gear reducer

HYDRAULIC OIL

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

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

PARTS ORDERING INFORMATION

When ordering parts, the following information is required for Victaulic to process the order and send the correct part(s). Request the RP-VE460 Repair Parts List for detailed drawings and parts listings.

1. Tool Model Number – VE460
2. Tool Series Number – The serial number can be found on the side of the tool on the nameplate
3. Quantity, Part Number, and Description
4. Where to Send the Part(s) – Company name and address
5. To Whose Attention to Send the Part(s)
6. Purchase Order Number
7. Billing Address

Parts can be ordered by calling 1-800-PICK VIC.

TROUBLESHOOTING

PROBLEM	POSSIBLE CAUSE	SOLUTION
Pipe will not stay in grooving rolls.	Incorrect pipe positioning of long pipe length.	Refer to the "Long Pipe Lengths" section.
	Lower roll and pipe are not rotating clockwise.	Refer to the "Power Hookup and Verification of Pipe Rotation Direction" section.
Pipe stops rotating during the grooving operation.	Rust or dirt buildup is present on the lower roll.	Remove rust or dirt accumulation from the lower roll with a stiff wire brush.
	Rust or dirt is excessively heavy inside the pipe end.	Remove heavy rust and dirt from inside the pipe end.
	Worn grooving rolls.	Inspect the lower roll for worn knurls. Replace the lower roll if excessive wear is present.
	The circuit breaker has tripped or a fuse has blown out on the electrical circuit that supplies the tool.	Reset the breaker, or replace the fuse.
While grooving, loud squeaks echo through the pipe.	Incorrect pipe support positioning of a long pipe length. Pipe is "over-tracking."	Move the pipe support to the right. Refer to the "Long Pipe Lengths" section.
	Pipe is not cut square.	Cut the pipe end squarely.
	Pipe is rubbing excessively on the lower-roll backstop flange.	Remove the pipe from the tool, and apply a light coating of bandsaw blade wax to the face of the pipe end.
	Ram speed is set too low.	Refer to the "Ram Speed Adjustment" section.
During grooving, loud thumps or bangs occur approximately once every revolution of the pipe.	Pipe has a pronounced weld seam.	For 12-inch/323.9-mm and smaller pipe sizes, raised internal and external weld beads and seams must be ground flush with the pipe surface 2 inches/50 mm back from the pipe ends. For 14 - 38-inch/355.6 - 965-mm pipe sizes, raised internal and external weld beads and seams must be ground flush with the pipe surface 4 inches/100 mm back from the pipe ends. For 40 - 60-inch/1016 - 1524-mm pipe sizes, raised internal and external weld beads and seams must be ground flush with the pipe surface 4 1/2 inches/115 mm back from the pipe ends.
Pipe flare is excessive.	Pipe support is adjusted too high for long pipe.	Refer to the "Long Pipe Lengths" section.
	Tool is tilted forward (out of level) while grooving long pipe.	Refer to the applicable "Tool Setup" section.
	Incorrect pipe support positioning of long pipe. Pipe is "over-tracking."	Move the pipe support to the right. Refer to the "Long Pipe Lengths" section.
	Pipe stabilizer is adjusted too far inward.	Back off the pipe stabilizer to the furthest point where it still stabilizes the pipe effectively.
	Ram speed is not set correctly.	Refer to the "Ram Speed Adjustment" section.
Larger diameter pipe sways or vibrates from side to side.	Incorrect pipe stabilizer adjustment.	Move the pipe stabilizer in or out until the pipe rotates smoothly.

TROUBLESHOOTING (CONTINUED)

PROBLEM	POSSIBLE CAUSE	SOLUTION
Tool will not groove the pipe.	Air is present in the hydraulic system.	Refer to the "Air Bleeding" section.
	Pipe is beyond the wall thickness or pipe yield strength capacity of the tool.	Refer to the applicable "Tool Rating and Roll Selection" section.
Pipe groove diameters do not meet Victaulic specifications.	Groove diameter stop is not adjusted properly.	Refer to the "Groove Diameter Stop Adjustments" section.
	Pipe is beyond the wall thickness or pipe yield strength capacity of the tool.	Refer to the applicable "Tool Rating and Roll Selection" section.
The "A" Gasket Seat or "B" Groove Width dimensions do not meet Victaulic specifications.	Upper roll bearing is not lubricated adequately.	Refer to the "Maintenance" section.
	Incorrect upper roll, lower roll, or both installed on the tool	Install the correct rolls. Refer to the applicable "Tool Rating and Roll Selection" section.
	Pipe not inserted fully onto the lower roll, or pipe is not tracking properly.	Make sure pipe is against the lower-roll backstop flange. Refer to the "Long Pipe Lengths" section for proper pipe stand positioning.

TOOL RATING AND ROLL SELECTION

ORIGINAL GROOVE SYSTEM AND "ES" ROLLS FOR STEEL AND SCHEDULE 40 STAINLESS STEEL PIPE - COLOR CODED BLACK

(For light-wall stainless steel pipe, refer to separate table)

Pipe Size		Dimensions inches/millimeters				Original Groove System Type	"ES" Type
Nominal Size inches	Actual Outside Diameter inches/mm	Steel Pipe Wall Thickness		Stainless Steel Pipe Wall Thickness		Roll Part Numbers	Roll Part Numbers
		Minimum	Maximum*	Minimum	Maximum		
4	4.500 114.3	0.083 2.1	0.375 9.5	0.237 6.0	0.237 6.0	Lower Roll R904460L06 Upper Roll R9Q1448U06 Roll Set R9Q1460006	Lower Roll RZ04460L06 Upper Roll RZQ1448U06 Roll Set RZQ1460006
4½	5.000 127.0	0.095 2.4	0.375 9.5	0.237 6.0	0.237 6.0		
5	5.563 141.3	0.109 2.8	0.375 9.5	0.258 6.6	0.258 6.6		
6	6.625 168.3	0.109 2.8	0.375 9.5	0.280 7.1	0.280 7.1	Lower Roll R908460L12 Upper Roll R9Q1448U12 Roll Set R9Q1460012	Lower Roll RZ08460L12 Upper Roll RZQ1448U12 Roll Set RZQ1460012
8	8.625 219.1	0.109 2.8	0.375 9.5	0.250 6.4	0.322 8.2		
10	10.750 273.0	0.134 3.4	0.375 9.5	0.250 6.4	0.365 9.3		
12	12.750 323.9	0.156 4.0	0.375 9.5	0.250 6.4	0.375 9.5	Lower Roll R914460L16 Upper Roll R9Q1448U16 Roll Set R9Q1460016	
14 OD	14.000 355.6	0.156 4.0	0.375 9.5	0.312 7.9	0.375 9.5		
16 OD	16.000 406.4	0.165 4.2	0.375 9.5	0.312 7.9	0.375 9.5		
18 OD	18.000 457.0	0.165 4.2	0.375 9.5	0.375 9.5	0.375 9.5		
20 OD	20.000 508.0	0.183 4.7	0.375 9.5	0.375 9.5	0.375 9.5		
22 OD	22.000 559.0	0.188 4.8	0.375 9.5	0.375 9.5	0.375 9.5		
24 OD	24.000 610.0	0.218 5.5	0.375 9.5	0.375 9.5	0.375 9.5		
26 OD	26.000 660.0	0.250 6.4	0.375 9.5	0.375 9.5	0.375 9.5		
28 OD	28.000 711.0	0.250 6.4	0.375 9.5	0.375 9.5	0.375 9.5		
30 OD	30.000 762.0	0.250 6.4	0.375 9.5	0.375 9.5	0.375 9.5		
32 OD	32.000 813.0	0.250 6.4	0.375 9.5	0.375 9.5	0.375 9.5	Lower Roll R926460L36 Upper Roll R9Q1448U36 Roll Set R9Q1460036	
36 OD	36.000 914.0	0.250 6.4	0.375 9.5	0.375 9.5	0.375 9.5		

Table and notes continue on the following page

ORIGINAL GROOVE SYSTEM AND “ES” ROLLS FOR STEEL AND SCHEDULE 40 STAINLESS STEEL PIPE - COLOR CODED BLACK (CONTINUED)

(For light-wall stainless steel pipe, refer to separate table)

Pipe Size		Dimensions inches/millimeters				Original Groove System Type	“ES” Type
Nominal Size inches	Actual Outside Diameter inches/mm	Steel Pipe Wall Thickness		Stainless Steel Pipe Wall Thickness		Roll Part Numbers	Roll Part Numbers
		Minimum	Maximum*	Minimum	Maximum		
42 OD	42.000 1067.0	0.250 6.4	0.375 9.5	0.375 9.5	0.375 9.5	Lower Roll R942460L48 Upper Roll R9Q1448U48 Roll Set R9Q1460048	
44 OD	44.000 1118.0	0.250 6.4	0.375 9.5	0.375 9.5	0.375 9.5		
46 OD	46.000 1168.0	0.250 6.4	0.375 9.5	0.375 9.5	0.375 9.5		
48 OD	48.000 1219.0	0.250 6.4	0.375 9.5	0.375 9.5	0.375 9.5		

* When roll grooving pipes at or near the maximum rated thickness, the pipe must not exceed the yield strength of API-5L Grade “B”, ASTM Grade “B”, 150 Brinell Hardness Number (BHN) maximum.

Types 304/304L and 316/316L stainless steel pipe

The wall thicknesses listed are nominal minimum and maximum

In addition, the following pipe sizes may be roll grooved: 108.0 mm; 133.0 mm; 139.7 mm; 152.4 mm; 159.0 mm; 165.1 mm; 203.2 mm; 216.3 mm; 254.0 mm; 267.4 mm; 304.8 mm; 318.5 mm; 377.0 mm; and 426.0 mm. Contact Victaulic for details.

**ORIGINAL GROOVE SYSTEM ROLLS FOR ALUMINUM AND PVC PLASTIC PIPE -
COLOR CODED YELLOW ZINC**

Pipe Size		Dimensions inches/millimeters				RP Roll Part Numbers
Nominal Size inches	Actual Outside Diameter inches/mm	Aluminum Pipe Wall Thickness		PVC Plastic Pipe Wall Thickness		
		Minimum	Maximum	Minimum	Maximum	
4	4.500	0.083	0.237	0.237	0.337	Lower Roll RP04460L06 Upper Roll RPQ1448U06 Roll Set RPQ1460006
	114.3	2.1	6.0	6.0	8.6	
4½	5.000	0.095	0.237			
	127.0	2.4	6.0			
5	5.563	0.109	0.258	0.258	0.375	
	141.3	2.8	6.6	6.6	9.5	
6	6.625	0.109	0.280	0.280	0.432	
	168.3	2.8	7.1	7.1	11.0	
8	8.625	0.109	0.322	0.322	0.322	Lower Roll RP08460L12 Upper Roll RPQ1448U12 Roll Set RPQ1460012
	219.1	2.8	8.2	8.2	8.2	
10	10.750	0.134	0.250			
	273.0	3.4	6.4			
12	12.750	0.156	0.250			
	323.9	4.0	6.4			

Aluminum Alloys 6061-T4 and 6063-T4

PVC Type 1, Grade 1 - PVC 1120; PVC Type 1, Grade II - PVC 1220; PVC Type II, Grade 1 - PVC 2116

The wall thicknesses listed are nominal minimum and maximum

For aluminum pipe, the following additional pipe sizes may be roll grooved: 108.0 mm; 133.0 mm; 139.7 mm; 152.4 mm; 159.0 mm; 165.1 mm; 203.2 mm; 216.3 mm; 254.0 mm; 267.4 mm; 304.8 mm; and 318.5 mm. Contact Victaulic for details.

For PVC pipe, the following additional pipe sizes may be roll grooved: 108.0 mm; 133.0 mm; 139.7 mm; 159.0 mm; 165.1 mm; and 216.3 mm. Contact Victaulic for details.

**ORIGINAL GROOVE SYSTEM RX ROLLS FOR SCHEDULE 5S AND 10S STAINLESS STEEL
PIPE - COLOR CODED SILVER**

Pipe Size		Dimensions inches/millimeters			RX Roll Part Numbers
Nominal Size inches	Actual Outside Diameter inches/mm	Stainless Steel Pipe Wall Thickness			
		Minimum for Schedule 5S	Maximum for Schedule 10S	Maximum for Schedule 10	
4	4.500 114.3	0.083 2.1	0.120 3.1		Lower Roll RXQ4460L06
5	5.563 141.3	0.109 2.8	0.134 3.4		Upper Roll RXQ1448U06
6	6.625 168.3	0.109 2.8	0.134 3.4		Roll Set RXQ1460006
8	8.625 219.1	0.109 2.8	0.148 3.8		Lower Roll RX08460L12
10	10.750 273.0	0.134 3.1	0.165 4.2		Upper Roll RXQ1448U12
12	12.750 323.9	0.156 4.0	0.180 4.6		Roll Set RXQ1460012
14 OD	14.000 355.6	0.156 4.0	0.188 4.8	0.250 6.4	Lower Roll RX14460L16
16 OD	16.000 406.4	0.165 4.2	0.188 4.8	0.250 6.4	Upper Roll RXQ1448U16
18 OD	18.000 457.0	0.165 4.2	0.188 4.8	0.250 6.4	Roll Set RXQ1460016
20 OD	20.000 508.0	0.188 4.8	0.218 5.5	0.250 6.4	Lower Roll RX18460L20
22 OD	22.000 559.0	0.188 4.8	0.218 5.5	0.250 6.4	Upper Roll RXQ1448U20
24 OD	24.000 610.0	0.218 5.5	0.250 6.4	0.250 6.4	Roll Set RXQ1460020
26 OD	26.000 660.0			0.312 7.9	Lower Roll RX22460L24
28 OD	28.000 711.0			0.312 7.9	Upper Roll RXQ1448U24
30 OD	30.000 762.0	0.250 6.4	0.312 7.9	0.312 7.9	Roll Set RXQ1460024
32 OD	32.000 813.0			0.312 7.9	Lower Roll RX26460L36
34 OD	34.000 864.0			0.312 7.9	Upper Roll RXQ1448U36
36 OD	36.000 914.0			0.312 7.9	Roll Set RXQ1460036

Types 304/304L and 316/316L stainless steel pipe
The wall thicknesses listed are nominal minimum and maximum

RW ROLLS FOR GROOVING LIGHT-WALL, STANDARD-WEIGHT, AND EXTRA-STRONG (XS) STEEL PIPE TO AGS SPECIFICATIONS - COLOR CODED BLACK WITH YELLOW BAND

RWX ROLLS FOR GROOVING SCHEDULE 5S AND 10S STAINLESS STEEL PIPE TO AGS SPECIFICATIONS - COLOR CODED SILVER WITH BLACK BAND

Pipe Size		Dimensions inches/millimeters				RW	RWX
Nominal Size inches	Actual Outside Diameter inches/mm	Steel Pipe Wall Thickness		Stainless Steel Pipe Wall Thickness		Roll Part Numbers for Steel Pipe	Roll Part Numbers for Schedule 5S and 10S Stainless Steel Pipe
		Minimum	Maximum	Schedule 5S	Schedule 10S‡		
14 OD	14.000 355.6	0.220 5.6	0.500 12.7	0.156 4.0	0.188 4.8	Lower Roll RWQ2460L24 Upper Roll RWQ2448U24 Roll Set RWQ2460024	Lower Roll RWQX460L18 Upper Roll RWQX448U24 Roll Set RWQX460018
16 OD	16.000 406.4	0.220 5.6	0.500 12.7	0.165 4.2	0.188 4.8		
18 OD	18.000 457.0	0.220 5.6	0.500 12.7	0.165 4.2	0.188 4.8		
20 OD	20.000 508.0	0.220 5.6	0.500 12.7	0.188 4.8	0.218 5.5		Lower Roll RWQX460L24 Upper Roll RWQX448U24 Roll Set RWQX460024
24 OD	24.000 610.0	0.220 5.6	0.500 12.7	0.218 5.5	0.250 6.4		
26 OD	26.000 660.0	0.220 5.6	0.500 12.7			Lower Roll RWQ3460L38 Upper Roll RWQ3460U38 Roll Set RWQ3460038	
28 OD	28.000 711.0	0.220 5.6	0.500 12.7				
30 OD	30.000 762.0	0.220 5.6	0.500 12.7				
32 OD	32.000 813.0	0.220 5.6	0.500 12.7				
36 OD	36.000 914.0	0.220 5.6	0.500 12.7				
38 OD	38.000 965.0	0.220 5.6	0.500 12.7				
40 OD	40.000 1016.0	0.220 5.6	0.500 12.7				
42 OD	42.000 1067.0	0.220 5.6	0.500 12.7				
44 OD	44.000 1118.0	0.220 5.6	0.500 12.7				
46 OD	46.000 1168.0	0.220 5.6	0.500 12.7				
48 OD	48.000 1219.0	0.220 5.6	0.500 12.7			Lower Roll RWQ3460L48 Upper Roll RWQ3460U48 Roll Set RWQ3460048	

Table and notes continue on the following page

RW ROLLS FOR GROOVING LIGHT-WALL, STANDARD-WEIGHT, AND EXTRA-STRONG (XS) STEEL PIPE TO AGS SPECIFICATIONS - COLOR CODED BLACK WITH YELLOW BAND (CONTINUED)

RWX ROLLS FOR GROOVING SCHEDULE 5S AND 10S STAINLESS STEEL PIPE TO AGS SPECIFICATIONS - COLOR CODED SILVER WITH BLACK BAND (CONTINUED)

Pipe Size		Dimensions inches/millimeters				RW	RWX
Nominal Size inches	Actual Outside Diameter inches/mm	Steel Pipe Wall Thickness		Stainless Steel Pipe Wall Thickness		Roll Part Numbers for Steel Pipe	Roll Part Numbers for Schedule 5S and 10S Stainless Steel Pipe
		Minimum	Maximum	Schedule 5S	Schedule 10S‡		
52 OD	52.000 1321.0	0.220 5.6	0.500 12.7			Lower Roll RWQ3460L60 Upper Roll RWQ3460U60 Roll Set RWQ3460060	
54 OD	54.000 1372.0	0.220 5.6	0.500 12.7				
56 OD	56.000 1422.0	0.220 5.6	0.500 12.7				
60 OD	60.000 1524.0	0.220 5.6	0.500 12.7				

Maximum ratings on steel are limited to pipe that does not exceed the yield strength of API-5L Grade "B", ASTM Grade "B", 150 Brinell Hardness Number (BHN) maximum.

Types 304/304L and 316/316L stainless steel pipe

The wall thicknesses listed are nominal minimum and maximum

‡ The wall thicknesses listed in this column are for Schedule 10S stainless steel pipe. In addition, stainless steel pipe in 14 - 24-inch OD sizes is available in true Schedule 10, which has a nominal wall thickness of 0.250 inch/6.4 mm. For grooving 14 - 24-inch OD true Schedule 10 stainless steel pipe (nominal wall thickness of 0.250 inch/6.4 mm), the RW0X460L24 lower roll and the RWQX448U24 upper roll should be used (roll set part number is RWQX460024).

EXPLANATION OF CRITICAL ROLL GROOVE DIMENSIONS

Pipe Outside Diameter - Nominal NPS Pipe Size (ANSI B36.10) and Basic Metric Pipe Size (ISO 4200) – The average pipe outside diameter must not vary from the specifications listed in the tables on the following pages. Maximum allowable pipe ovality should not vary by more than 1%. Greater variations between the major and minor diameters will result in difficult coupling assembly. For IPS pipe, the maximum allowable tolerance from square-cut pipe ends is 0.045 inch/1.1 mm for 4 - 6-inch/114.3 - 168.3-mm sizes and 0.060 inch/1.5 mm for 8-inch/219.1-mm and larger sizes. This is measured from the true square line. Any internal and external weld beads or seams must be ground flush to the pipe surface. The inside diameter of the pipe end must be cleaned to remove coarse scale, dirt, and other foreign material that might interfere with or damage grooving rolls.

For pipe being grooved to Advanced Groove System (AGS) specifications, the outside diameter must not vary from the specifications listed in the applicable table (API 5L end tolerance). The maximum allowable tolerance from square-cut ends is 0.063 inch/1.5 mm. This is measured from the true square line.

“A” Dimension – The “A” dimension, or the distance from the pipe end to the groove, identifies the gasket seating area. This area must be free from indentations, projections (including weld seams), and roll marks from the pipe end to the groove to ensure a leak-tight seal. All foreign material, such as loose paint, scale, oil, grease, chips, rust, and dirt must be removed.

For AGS products, beveled carbon steel pipe may be used, provided the wall thickness is standard wall (0.375 inch/9.5 mm) and the bevel meets ASTM A53 and/or API 5L (30° +5°/-0°).

“B” Dimension – The “B” dimension, or groove width, controls expansion, contraction, and angular deflection of flexible couplings by the distance it is located from the pipe and its width in relation to the coupling housings’ “key” width. The bottom of the groove must be free from all foreign material, such as dirt, chips, rust, and scale that may interfere with proper coupling assembly.

For pipe being grooved to AGS specifications, the corners at the bottom of the groove must be radiused R.09 inch/R2.3 mm. The Groove Width “B” dimension will be achieved with properly maintained Victaulic tools that are equipped with special Victaulic AGS (RW or RWX) roll sets.

“C” Dimension – The “C” dimension is the proper diameter at the base of the groove. This dimension must be within the diameter’s tolerance and concentric with the OD for proper coupling fit. The groove must be of uniform depth for the entire pipe circumference. For pipe being grooved to AGS specifications, Victaulic RW roll sets for carbon steel pipe or RWX roll sets for stainless steel pipe must be used.

“D” Dimension – The “D” dimension is the normal depth of the groove and is a reference for a “trial groove” only. Variations in pipe OD affect this dimension and must be altered, if necessary, to keep the “C” dimension within tolerance. This groove must conform to the “C” dimension described above.

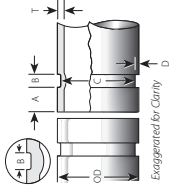
“F” Dimension (Original Roll Groove Only) – Maximum allowable pipe-end flare diameter is measured at the extreme pipe-end diameter.

“T” Dimension – The “T” dimension is the lightest grade (minimum, nominal wall thickness) of pipe that is suitable for cut or roll grooving. Pipe that is less than the minimum, nominal wall thickness for cut grooving may be roll grooved or adapted for Victaulic couplings by using Vic-Ring® adapters. Vic-Ring adapters can be used in the following situations (contact Victaulic for details):

- When the pipe is less than the minimum, nominal wall thickness suitable for roll grooving
- When the pipe outside diameter is too large to roll or cut groove
- When the pipe is used in abrasive services

For pipe being grooved to AGS specifications, the absolute minimum wall thickness is 0.290 inch/7.4 mm for 14-inch/355.6-mm pipe and 0.318 inch/8.1 mm for 16-inch/406.4-mm pipe, in accordance with EN 10217. The absolute minimum wall thickness for 18-inch/457.0-mm and larger pipe is 0.328 inch/8.3 mm, in accordance with ASTM A-53.

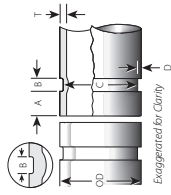
ROLL GROOVE SPECIFICATIONS
ORIGINAL GROOVE SYSTEM FOR STEEL AND STAINLESS STEEL PIPE



Pipe Size		Dimensions – Inches/millimeters														
		Pipe Outside Diameter		Gasket Seat "A"		Groove Width "B"			Groove Diameter "C"		Groove Depth "D" (ref.)		Min. Wall Thick. "T"		Max. Allow. Flare Dia.	
Nominal Size inches or mm	Actual Out. Diameter inches/mm	Max.	Min.	Basic	Max.	Min.	Basic	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.
108.0 mm	108.0	4.293	4.219	0.625	0.656	0.594	0.344	0.375	0.313	4.084	4.064	0.083	0.078	4.35	2.0	110.5
		109.0	107.2	15.9	16.7	15.1	8.7	9.5	8.0	103.7	103.2	2.2	2.0			
4	4.500	4.545	4.469	0.625	0.656	0.594	0.344	0.375	0.313	4.334	4.314	0.083	0.078	4.60	2.0	116.8
		115.4	113.5	15.9	16.7	15.1	8.7	9.5	8.0	110.1	109.6	2.2	2.0			
4½	5.000	5.050	4.969	0.625	0.656	0.594	0.344	0.375	0.313	4.834	4.814	0.083	0.078	5.10	2.0	129.5
		128.3	126.2	15.9	16.7	15.1	8.7	9.5	8.0	122.8	122.3	2.2	2.0			
133.0 mm	133.0	5.303	5.219	0.625	0.656	0.594	0.344	0.375	0.313	5.084	5.064	0.083	0.078	5.35	2.0	135.9
		134.7	132.6	15.9	16.7	15.1	8.7	9.5	8.0	129.1	128.6	2.2	2.0			
139.7 mm	139.7	5.556	5.469	0.625	0.656	0.594	0.344	0.375	0.313	5.334	5.314	0.083	0.078	5.60	2.0	142.2
		141.1	138.9	15.9	16.7	15.1	8.7	9.5	8.0	135.5	135.0	2.2	2.0			
5	5.563	5.619	5.532	0.625	0.656	0.594	0.344	0.375	0.313	5.395	5.373	0.084	0.078	5.66	2.0	143.8
		141.3	140.5	15.9	16.7	15.1	8.7	9.5	8.0	137.0	136.5	2.2	2.0			
152.4 mm	152.4	6.056	5.969	0.625	0.656	0.594	0.344	0.375	0.313	5.830	5.808	0.085	0.078	6.10	2.0	154.9
		153.8	151.6	15.9	16.7	15.1	8.7	9.5	8.0	148.1	147.5	2.2	2.0			
159.0 mm	159.0	6.313	6.219	0.625	0.656	0.594	0.344	0.375	0.313	6.032	6.002	0.109	0.109	6.35	2.8	161.3
		160.4	158.0	15.9	16.7	15.1	8.7	9.5	8.0	153.2	152.5	2.8	2.8			
165.1 mm	165.1	6.563	6.469	0.625	0.656	0.594	0.344	0.375	0.313	6.330	6.308	0.085	0.078	6.60	2.0	167.6
		166.7	164.3	15.9	16.7	15.1	8.7	9.5	8.0	160.8	160.2	2.2	2.0			
6	6.625	6.688	6.594	0.625	0.656	0.594	0.344	0.375	0.313	6.455	6.433	0.085	0.078	6.73	2.0	170.9
		168.3	167.5	15.9	16.7	15.1	8.7	9.5	8.0	164.0	163.4	2.2	2.8			

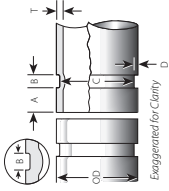
Table continued on the following page.

ROLL GROOVE SPECIFICATIONS
ORIGINAL GROOVE SYSTEM FOR STEEL AND STAINLESS STEEL PIPE (CONTINUED)



Pipe Size		Dimensions – Inches/millimeters													
		Pipe Outside Diameter		Gasket Seat "A"			Groove Width "B"			Groove Diameter "C"		Groove Depth "D" (ref.)	Min. Wall Thick. "T"	Max. Allow. Flare Dia.	
Nominal Size inches or mm	Actual Out. Diameter inches/mm	Max.	Min.	Basic	Max.	Min.	Basic	Max.	Min.	Max.	Min.				Max.
203.2 mm	8.000 203.2	8.063 204.8	7.969 202.4	0.750 19.1	0.781 19.8	0.719 18.3	0.469 11.9	0.500 12.7	0.438 11.1	7.816 198.5	7.791 197.9	0.092 2.4	0.109 2.8	8.17 207.5	
216.3 mm	8.515 216.3	8.578 217.9	8.484 215.5	0.750 19.1	0.781 19.8	0.719 18.3	0.469 11.9	0.500 12.7	0.438 11.1	8.331 211.6	8.306 211.0	0.092 2.4	0.109 2.8	8.69 220.7	
8	8.625 219.1	8.688 220.7	8.594 218.3	0.750 19.1	0.781 19.8	0.719 18.3	0.469 11.9	0.500 12.7	0.438 11.1	8.441 214.4	8.416 213.8	0.092 2.4	0.109 2.8	8.80 223.5	
254.0 mm	10.000 254.0	10.063 255.6	9.969 253.2	0.750 19.1	0.781 19.8	0.719 18.3	0.469 11.9	0.500 12.7	0.438 11.1	9.812 249.2	9.785 248.5	0.094 2.4	0.134 3.4	10.17 258.3	
267.4 mm	10.528 267.4	10.591 269.0	10.497 266.6	0.750 19.1	0.781 19.8	0.719 18.3	0.469 11.9	0.500 12.7	0.438 11.1	10.340 262.6	10.313 262.0	0.094 2.4	0.134 3.4	10.70 271.8	
10	10.750 273.0	10.813 274.7	10.719 272.3	0.750 19.1	0.781 19.8	0.719 18.3	0.469 11.9	0.500 12.7	0.438 11.1	10.562 268.3	10.535 267.6	0.094 2.4	0.134 3.4	10.92 277.4	
304.8 mm	12.000 304.8	12.063 306.4	11.969 304.0	0.750 19.1	0.781 19.8	0.719 18.3	0.469 11.9	0.500 12.7	0.438 11.1	11.781 299.2	11.751 298.5	0.109 2.8	0.156 4.0	12.17 309.1	
318.5 mm	12.539 318.5	12.602 320.1	12.508 317.7	0.750 19.1	0.781 19.8	0.719 18.3	0.469 11.9	0.500 12.7	0.438 11.1	12.321 313.0	12.291 312.2	0.109 2.8	0.156 4.0	12.71 322.8	
12	12.750 323.9	12.813 325.5	12.719 323.1	0.750 19.1	0.781 19.8	0.719 18.3	0.469 11.9	0.500 12.7	0.438 11.1	12.531 318.3	12.501 317.5	0.109 2.8	0.156 4.0	12.92 328.2	

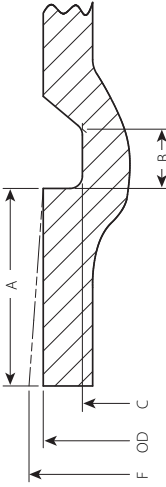
ROLL GROOVE SPECIFICATIONS
ORIGINAL GROOVE SYSTEM FOR STEEL PIPE AND ALL MATERIALS GROOVED WITH "ES" ROLLS



Pipe Size		Dimensions – inches/millimeters											
		Pipe Outside Diameter		Gasket Seat "A"		Groove Width "B"		Groove Diameter "C"		Groove Depth "D" (ret.)	Min. Allow. Wall Thick. "I"	Max. Allow. Flare Dia.	
Nominal Size inches/ mm	Actual Out. Diameter inches/ mm	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.				Max.
4	4.500	4.545	4.469	0.590	0.320	0.300	4.314	4.334	0.083	0.237	4.600		
	114.3	115.4	113.5	15.0	8.1	7.6	109.6	110.1	2.1	6.0	116.8		
6	6.625	6.688	6.594	0.590	0.320	0.300	6.433	6.455	0.085	0.280	6.730		
	168.3	169.9	167.5	15.0	8.1	7.6	163.4	164.0	2.2	7.1	170.9		
8	8.625	8.688	8.594	0.699	0.410	0.390	8.416	8.441	0.092	0.322	8.800		
	219.1	220.7	218.3	17.8	10.4	9.9	213.8	214.4	2.3	8.2	223.5		
10	10.750	10.813	10.719	0.699	0.410	0.390	10.535	10.562	0.094	0.365	10.920		
	273.0	274.7	272.3	17.8	10.4	9.9	268.3	267.6	2.4	9.3	277.4		
12	12.750	12.813	12.719	0.699	0.410	0.390	12.531	12.531	0.109	0.375	12.920		
	323.9	325.5	323.1	17.8	10.4	9.9	318.3	317.5	2.8	9.5	328.2		

ROLL GROOVE SPECIFICATIONS

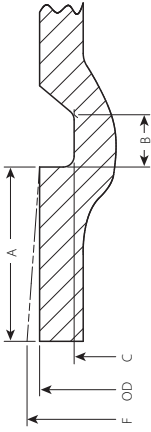
ADVANCED GROOVE SYSTEM (AGS) ROLL GROOVE



NOTICE

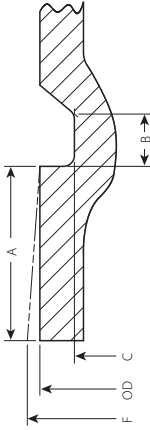
- Grooving pipe to Advanced Groove System (AGS) specifications enlarges the pipe length by approximately $\frac{1}{8}$ inch (0.125 inch/3.2 mm) for each groove. For a pipe length with an AGS groove at each end, the length will grow approximately $\frac{1}{4}$ inch (0.250 inch/6.4 mm) total. Therefore, the cut length should be adjusted to accommodate this growth. **EXAMPLE:** If you need a 24-inch/610-mm length of pipe that will contain an AGS groove at each end, cut the pipe to a length of 23 $\frac{3}{4}$ inches/603 mm to allow for this growth.
- It is critical to measure the Groove Diameter "C" dimension, along with the Gasket Seat "A" dimension and the Flare Diameter "F" dimension. These measurements must be within the specifications listed in the following tables for proper joint performance.

ADVANCED GROOVE SYSTEM (AGS) ROLL GROOVING SPECIFICATIONS FOR CARBON STEEL PIPE



Size	Dimensions - Inches/millimeters														Maximum Allowable Flare Diameter "F"								
	Outside Diameter "OD"		Gasket Seat "A"		Groove Width "B"			Groove Diameter "C"		Maximum		Minimum		Maximum		Minimum							
	Maximum	Minimum	Basic	Maximum	Minimum	Basic	Maximum	Minimum	Maximum	Minimum	Maximum	Minimum											
Nominal Size inches/ Actual mm	14	14.094	13.969	1.500	1.531	1.437	0.455	0.460	0.450	13.500	13.455	14.23	355.6	358.0	354.8	38.1	38.9	36.5	11.6	11.7	342.9	341.8	361.4
16	16.094	15.969	1.500	1.531	1.437	0.455	0.460	0.450	15.500	15.455	16.23	406.4	408.8	405.6	38.1	38.9	36.5	11.6	11.7	393.7	392.6	412.2	
18	18.094	17.969	1.500	1.531	1.437	0.455	0.460	0.450	17.500	17.455	18.23	457.0	459.6	456.4	38.1	38.9	36.5	11.6	11.7	444.5	443.4	463.0	
20	20.094	19.969	1.500	1.531	1.437	0.455	0.460	0.450	19.500	19.455	20.23	508.0	510.4	507.2	38.1	38.9	36.5	11.6	11.7	495.3	494.2	513.8	
24	24.094	23.969	1.500	1.531	1.437	0.455	0.460	0.450	23.500	23.455	24.23	610.0	612.0	608.8	38.1	38.9	36.5	11.6	11.7	596.9	595.8	615.4	
26	26.094	25.969	1.750	1.781	1.687	0.535	0.540	0.530	25.430	25.370	26.30	660.0	662.8	659.6	44.5	45.2	42.8	13.6	13.7	645.9	644.4	668.0	
28	28.094	27.969	1.750	1.781	1.687	0.535	0.540	0.530	27.430	27.370	28.30	711.0	713.6	710.4	44.5	45.2	42.8	13.6	13.7	696.7	695.2	718.8	
30	30.094	29.969	1.750	1.781	1.687	0.535	0.540	0.530	29.430	29.370	30.30	762.0	764.4	761.2	44.5	45.2	42.8	13.6	13.7	747.5	746.0	769.6	
32	32.094	31.969	1.750	1.781	1.687	0.535	0.540	0.530	31.430	31.370	32.30	813.0	815.2	812.0	44.5	45.2	42.8	13.6	13.7	798.3	796.8	820.4	
36	36.094	35.969	1.750	1.781	1.687	0.535	0.540	0.530	35.430	35.370	36.30	914.0	916.8	913.6	44.5	45.2	42.8	13.6	13.7	899.9	898.4	922.0	
40	40.094	39.969	2.000	2.031	1.937	0.562	0.567	0.557	39.375	39.315	40.30	1016.0	1018.4	1015.2	50.8	51.6	49.2	14.3	14.4	1000.1	998.6	1023.6	
42	42.094	41.969	2.000	2.031	1.937	0.562	0.567	0.557	41.375	41.315	42.30	1067.0	1069.2	1066.0	50.8	51.6	49.2	14.3	14.4	1050.9	1049.4	1074.4	

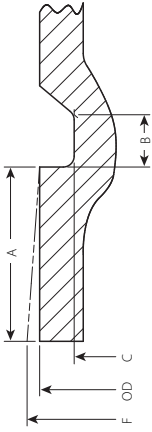
ADVANCED GROOVE SYSTEM (AGS) ROLL GROOVING SPECIFICATIONS FOR CARBON STEEL PIPE (CONTINUED)



Size	Dimensions – inches/millimeters												Maximum Allowable Flare Diameter "F"
	Outside Diameter "OD"		Gasket Seat "A"		Groove Width "B" ‡			Groove Diameter "C"		Flare Diameter "F"			
	Maximum	Minimum	Basic	Maximum	Minimum	Basic	Maximum	Minimum	Maximum	Minimum	Maximum		
46 1168.0	46.094 1170.8	45.969 1167.6	2.000 50.8	2.031 51.6	1.937 49.2	0.562 14.3	0.567 14.4	0.557 14.1	45.315 1152.5	45.315 1151.0	46.30 1176.0	46.30 1176.0	
48 1219.0	48.094 1221.6	47.969 1218.4	2.000 50.8	2.031 51.6	1.937 49.2	0.562 14.3	0.567 14.4	0.557 14.1	47.315 1203.3	47.315 1201.8	48.30 1226.8	48.30 1226.8	
54 1372.0	54.094 1374.0	53.969 1370.8	2.500 63.5	2.531 64.3	2.437 61.9	0.562 14.3	0.567 14.4	0.557 14.1	53.375 1354.2	53.375 1354.2	54.30 1379.2	54.30 1379.2	
56 1422.0	56.094 1424.8	55.969 1421.6	2.500 63.5	2.531 64.3	2.437 61.9	0.562 14.3	0.567 14.4	0.557 14.1	55.375 1406.5	55.375 1405.0	56.30 1430.0	56.30 1430.0	
60 1524.0	60.094 1526.4	59.969 1523.2	2.500 63.5	2.531 64.3	2.437 61.9	0.562 14.3	0.567 14.4	0.557 14.1	59.375 1508.1	59.375 1506.6	60.30 1531.6	60.30 1531.6	

‡ The Groove Width "B" dimension is listed for information only. The Groove Width "B" dimension will be achieved with properly maintained Victaulic tools that are equipped with special Victaulic AGS (RW) roll sets made specifically for use with carbon steel pipe.

ADVANCED GROOVE SYSTEM (AGS) ROLL GROOVING SPECIFICATIONS FOR STAINLESS STEEL PIPE



Pipe Size		Dimensions – inches/millimeters												
		Actual Outside Diameter		Outside Diameter "OD"		Gasket Seat "A"		Groove Width "B" ‡		Groove Diameter "C"		Max. Allow. Flare Dia. "F"		
Nominal Size	inches/mm	Max.	Min.	Basic	Max.	Min.	Basic	Max.	Min.	Max.	Min.	Max.	Min.	Max.
14	14.000	14.094	13.969	1.500	1.531	1.437	0.455	0.460	0.450	13.500	13.455	14.23	13.455	14.23
	355.6	358.0	354.8	38.1	38.9	36.5	11.6	11.7	11.4	342.9	341.8	361.4	341.8	361.4
16	16.000	16.094	15.969	1.500	1.531	1.437	0.455	0.460	0.450	15.500	15.455	16.23	15.455	16.23
	406.4	408.8	405.6	38.1	38.9	36.5	11.6	11.7	11.4	393.7	392.6	412.2	392.6	412.2
18	18.000	18.094	17.969	1.500	1.531	1.437	0.455	0.460	0.450	17.500	17.455	18.23	17.455	18.23
	457.0	459.6	456.4	38.1	38.9	36.5	11.6	11.7	11.4	444.5	443.4	463.0	443.4	463.0
20	20.000	20.125	19.969	1.500	1.531	1.437	0.455	0.460	0.450	19.500	19.455	20.23	19.455	20.23
	508.0	511.2	507.2	38.1	38.9	36.5	11.6	11.7	11.4	495.3	494.2	513.8	494.2	513.8
24	24.000	24.125	23.969	1.500	1.531	1.437	0.455	0.460	0.450	23.500	23.455	24.23	23.455	24.23
	610.0	612.8	608.8	38.1	38.9	36.5	11.6	11.7	11.4	596.9	595.8	615.4	595.8	615.4

‡ The Groove Width "B" dimension is listed for information only. The Groove Width "B" dimension will be achieved with properly maintained Victaulic tools that are equipped with special Victaulic AGS (RWX) roll sets made specifically for use with stainless steel pipe.

VE460

PIPE ROLL GROOVING TOOL

For complete contact information, visit www.victaulic.com

TM-VE460 5855 REV A UPDATED 10/2009 RM00460000

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