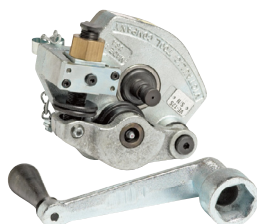
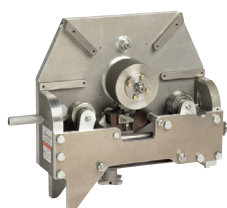




VE460
Fab Shop Roll Groover



VE12
Manual Roll Groover



VG824
Cut Groover



VAPS1672
Pipe Stand

Grooved Piping System

The distinguishing feature of the Victaulic grooved mechanical piping system is, as the name implies, a groove where the pipe and fitting engage to form a self-restraining joint. The position, depth and cross-section of this groove combine with the fitting housing in an optimal strength-to-weight relationship. The result is a permanent connection capable of withstanding thrust loads up to the maximum rated operating pressure.

Roll Grooving

Roll grooving is the method of choice for preparing pipe made of standard or lightwall carbon steel, stainless steel, aluminum, PVC, copper and other materials. Both roll and cut grooving meet the requirements of ANSI/ AWWA C-606. For optimal joint performance Victaulic recommends that each pipe end be square cut. However, beveled end pipe may be used provided the wall thickness is standard or less, and the bevel meets ASME/ ANSI B16.25 (37 1/2°) or ASTM A-53 (30°). Square cut pipe must be used with FlushSeal® and EndSeal® gaskets.

Victaulic roll grooving tools are all designed to rotate the pipe or orbit the pipe as a male grooving roll is impressed into the pipe. The support roll, in addition to driving the pipe or tool, is the female die inside the pipe. For all but the VE12, VE26, VE46, VE106, and VE226 tools, Victaulic roll groovers use hydraulic pressure to force the grooving roll into the pipe to form the groove. Roll grooving removes no metal; the groove is cold formed into the pipe wall.

Cut Grooving

All Victaulic cut groovers are designed to be driven around a stationary pipe to machine away material, providing a groove. The design of the tool assures a groove which is concentric with the pipe O.D., even with out-of-round pipe. Cut grooving is designed for standard weight or heavier wall thicknesses of pipe. A square cut groove is used for steel and other metallic IPS pipe. This provides maximum coupling gripping efficiency and the fullest pipe movement capabilities.

Job/Owner

System No.	
Location	

Contractor

Submitted By	
Date	

Engineer

Spec Section	
Paragraph	
Approved	
Date	

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These tools are designed for light duty manual field use and do not require a power source to operate. Alternatively, select field manual tools may also be operated with a compatible power drive.

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Roll Grooving – Field Portable

These tools are designed for light to heavy duty field use with tool components that can be easily unassembled and toted around the job site.

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Roll Grooving – Field Fabrication

These tools are designed for heavy duty repetitive field use.

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These tools are designed for heavy duty repetitive plant or shop fabrication use.

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Cut Grooving – Field Manual

These tools are designed for light duty manual field use and do not require an electrical power source for operation.

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Cut Grooving – Field Fabrication

These tools are designed for heavy duty repetitive field or shop use and require a power drive for operation. Victaulic offers the Power Mule II listed under tool accessories.

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Cut Grooving- Field Motorized

This tool is designed for occasional field use to cut off and cut groove ductile iron pipe.

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Plastic Groovers

These tools are designed for field fabrication use to cut a radius groove into PVC Plastic.

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Aquamine Grooving Tools

This lightweight and portable tool is designed to manually cut a spline groove and beveled end on Aquamine pipe for Aquamine reusable couplings.

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These lightweight and portable tools are designed to cut holes into pipe for branch connections.

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Vic-Press Tools

This battery-operated hand-held tool is designed for securing Vic-Press Schedule 10S products onto IPS Schedule 10S stainless steel pipe.

PFT510	27
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Pipe Cut-Off Tools

These lightweight and portable tools are designed to cut off pipe ends using a flame torch assembly.

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Tool Accessories

These tool accessories are designed to assist in the operation and grooving procedure of a variety of Victaulic tools as specifically outlined.

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Roll Groove Set Selection:

In order to achieve Victaulic specified product performance, the proper Victaulic roll grooving tool and corresponding Victaulic roll set must be selected. Failure to select the appropriate Victaulic roll set, or to use the correct Victaulic tool, may result in reduced performance or product failure. Tool specifications and capacities are listed with each tool.

The chart below provides an overview of commonly used roll sets. In addition to the roll sets detailed below, numerous specialized roll sets are also available, such as the “RZ” roll set used for grooving pipe used with EndSeal® Style HP-70ES couplings. If your preferred pipe material or size is not referenced in the below chart, please contact Victaulic for more information.

Pipe Material	IPS/CTS Wall Thickness	Recommended Roll Set			
		Pipe Sizes ¾ – 8”/20 – 200mm	Pipe Sizes 10 – 12”/250 – 300mm	Pipe Sizes 14 – 24”/350 – 600mm	Pipe Sizes 26 – 72”/650 – 1800mm
Carbon Steel	Schedule 5 through Standard Wall	R (Standard Rolls)	R9 (Standard Rolls)	RW (AGS Rolls) or RS (Extra Strong Rolls)	RW (AGS Rolls)
Stainless Steel ¹	Schedule 40S through Standard Wall	R9 (Standard Rolls)	R9 (Standard Rolls)	RW (AGS Rolls)	
Light Wall Stainless Steel ¹	Schedule 5S and 10S	RX (Light Wall Stainless Steel Rolls)	RX (Light Wall Stainless Steel Rolls)	RWX (AGS Light Wall Stainless Rolls)	
Aluminum	Schedule 5 through 40	RP (Plastic and Aluminum Rolls)	RP (Plastic and Aluminum Rolls)		
PVC Plastic	Schedule 40 and 80	RP (Plastic and Aluminum Rolls)			
Copper	K, L, M, DWV	RR (Copper Rolls)			

Additional specialized roll sets are available. If your pipe material or size is not listed here, please call Victaulic Customer Care for more information.

¹ Stainless Steel is defined as Type 304(L) or 316(L). For Duplex and Superduplex stainless steels, contact Victaulic for more information.

Victaulic Roll Grooving

For proper selection of grooving rolls for different alloys, please use the following selection guide. Also note all tools are equipped with carbon steel rolls only. All other types of grooving rolls are optional.

Groove Type	Color Code	Alloy	Part Number Identification
OGS	Black	Carbon Steel	R
AGS	Black/Yellow Strip	Carbon Steel	RW
Stainless Steel – OGS	Black	Stainless Steel (Standard Wall Only)	R
	Silver	Stainless Steel (Light Wall Only)	RX
Stainless Steel – AGS	Black/Yellow Strip	Stainless Steel (Standard Wall Only)	RW
	Silver	Stainless Steel (Light Wall Only)	RWX
ES	Black	Carbon Steel	RZ
Copper	Copper	Copper	RR
PVC/Aluminum	Gold	PVC/Aluminum	RP

**WARNING**

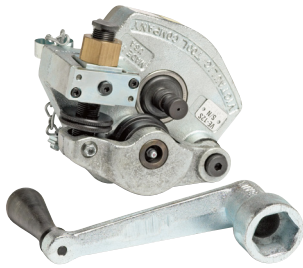
- Victaulic RX roll sets must be used when grooving light-wall/thin-wall stainless steel pipe for use with Victaulic Couplings.

Failure to use Victaulic RX roll sets when grooving light-wall/thin-wall stainless steel pipe may cause joint failure, resulting in serious personal injury and/or property damage.

NOTICE

- Victaulic grooving rolls for any pipe material other than carbon steel must be ordered separately.

Roll Grooving – Field Manual



VE12

VE12 Groove In-Place

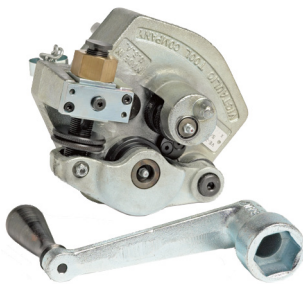
- Tool is manually operated using the supplied handle
- For manual grooving of Schedule 5, 10 and 40 steel; stainless steel; aluminum and PVC pipe
- Enhanced tracking rolls allow bi-directional grooving
- Roll grooves $\frac{3}{4}$ – 2" / 20 – 50 mm pipe

Power Requirements: None

Weight: 17 lbs./8 kg

Tool Ratings — Maximum Pipe Size Capacity			Pipe Size (in mm)/Schedule					
Model	Pipe Material	Notes	$\frac{3}{4}$ 20	1 25	1 $\frac{1}{4}$ 32	1 $\frac{1}{2}$ 40	2 50	
VE12	Steel		5 – 10			5 – 40		
	Stainless					40S		
	Aluminum	2	5 – 10			5 – 40		
	PVC Plastic					40		
VE12SS	Lt. Wall SS				5S – 10S			

² 6061-T4 or 6063-T4 Alloy must be used.



VE26

VE26 Groove In-Place

- Tool is manually operated using the supplied handle
- Repair and retrofit existing lightwall steel, Schedule 40 steel, stainless steel, PVC, and aluminum
- Enhanced tracking rolls allow bi-directional grooving
- Available for copper tubing (CTS) Types K, L, M and DWV plus British, DIN, and Australian Standard copper
- Optional power drive adapter kit available to alternately groove pipe using a Ridgid* 300 power drive or Victaulic VPD752
- Roll grooves 2 – 6" / 50 – 150 mm pipe

Power Requirements: None

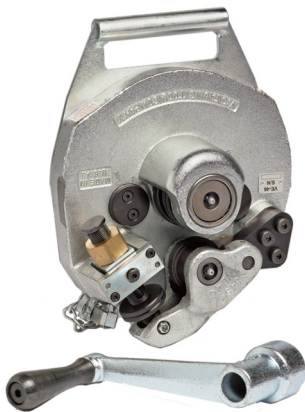
Weight: 22 lbs./10 kg

Tool Ratings — Maximum Pipe Size Capacity			Pipe Size (in mm)/Schedule					
Model	Pipe Material	Notes	2 50	2 $\frac{1}{2}$ 60	3 80	4 100	5 125	6 150
VE26S	Steel		5 – 40			5 – 10		
	Stainless		40S Only					
VE26C	Copper		K, L, M and DWV					
VE26P	Aluminum	2	5 – 40			5 – 10		
	PVC Plastic					40		
VE26SS	Lt. Wall SS				5S – 10S			

² 6061-T4 or 6063-T4 Alloy must be used.

* Ridgid is a registered trademark of the Ridge Tool Company.

Roll Grooving – Field Manual



VE46

VE46 Groove In-Place

- Tool is manually operated using the supplied handle
- Designed for manually roll grooving Schedule 40 steel, aluminum, stainless steel and PVC pipe and Schedule 80 PVC pipe
- Enhanced tracking rolls allow bi-directional grooving and helps to hold the tool on the pipe end during the roll grooving process
- Optional power drive adapter kit available to alternately groove pipe using a Ridgid® 300 power drive or Victaulic VPD752
- Roll grooves 3½ – 6"/90 – 150 mm pipe

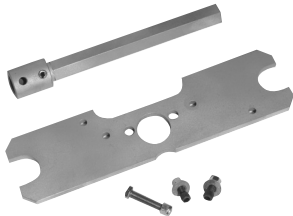
Power Requirements: None

Weight: 28 lbs./13 kg

Tool Ratings — Maximum Pipe Size Capacity			Pipe Size (in mm)/Schedule				
Model	Pipe Material	Notes	3½ 90	4 100	4½ 120	5 125	6 150
VE46S	Steel		5 – 40				
	Stainless		40S Only				
VE46P	Aluminum	2	5 – 40				
	PVC Plastic		40	40 – 80			

² 6061-T4 or 6063-T4 Alloy must be used.

* Ridgid is a registered trademark of the Ridge Tool Company.



VE26/46 Power Drive Kit

The VE26/46 power drive kit is available to allow both tools to be directly mounted to either a Victaulic VPD752 or Ridgid® 300 Power Drive.

Weight: 7lbs./3kg

Newer tools with serial numbers ending in “C” are compatible with the Power Drive Kit. Tools which do not contain the “C” suffix will require retrofit to accept the Power Drive Kit. Contact Victaulic for details.

* Ridgid is a registered trademark of the Ridge Tool Company.

Roll Grooving – Field Portable



VE106/VE107

VE106/VE107 Groove-N-Go

- Mobile light-duty roll grooving tool with an integral motor/drive unit mounted to a portable hand truck
- Tool is operated using a standard 3/8"/9.5 mm square-drive ratchet
- Enhanced tracking rolls help to keep the pipe on the tool during the roll grooving process.
- Supplied with a standard tool box for accessory storage
- Completely self-contained unit with an integral motor, safety foot switch and power plug
- Roll grooves 1 1/4 – 6"/32 – 150 mm pipe

Power Requirements: VE106 works with 110 volt, 15 amp power connection. VE107 works with 220 volt, 6 amp power connection.

Weight: 140 lbs./64 kg

Optional Accessories: Additional rolls/shafts are available for copper, lightwall stainless steel, and EndSeal (ES) grooving.

Tool Ratings — Maximum Pipe Size Capacity			Pipe Size (in mm)/Schedule									
Model	Pipe Material	Notes	1 1/4 32	1 1/2 40	2 50	2 1/2 60	3 80	3 1/2 90	4 100	5 125	6 150	
VE106/ VE107	Steel	3, 4	5 – 40									
	Stainless	3	40S									
	Lt. Wall SS	5	5S – 10S									
	Copper	6	K, L, M and DWV									

³ Use standard grooving rolls marked with the prefix R.

⁴ EndSeal® grooving rolls marked with the prefix RZ are available. Contact Victaulic® for details.

⁵ Use grooving rolls marked with the prefix RX.

⁶ Use grooving rolls marked with the prefix RR.

Roll Grooving – Field Portable



VE206 Portable Roll Groover

- Tool head mounts to any tripod stand with a Ridgid* 300 bolt pattern or the flat bed of a work truck
- Hydraulic hand pump can be mounted on either side of the tool for right or left hand operation
- Supplied with victaulic tool carry bag for accessory storage
- Roll grooves 1 ¼ – 6"/32 – 150 mm pipe

Power Requirements: Compatible with multiple power drive units; Victaulic VPD752, Ridgid* 300 or 700 and Rems Amigo II

Weight: 165 lbs./75 kg

Tool Ratings — Maximum Pipe Size Capacity			Pipe Size (in mm)/Schedule									
Model	Pipe Material	Notes	1¼ 32	1½ 40	2 50	2½ 60	3 80	3½ 90	4 100	5 125	6 150	
VE206	Steel	3, 4	5 – 40									
	Stainless	3	40S									
	Lt. Wall SS	5	5S – 10S									
	Copper	6	K, L, M and DWV									

* Ridgid is a registered trademark of the Ridge Tool Company.

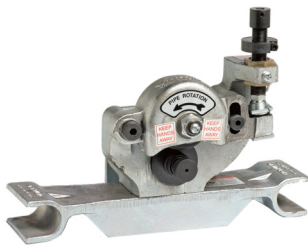
³ Use standard grooving rolls marked with the prefix R.

⁴ EndSeal® grooving rolls marked with the prefix RZ are available. Contact Victaulic® for details.

⁵ Use grooving rolls marked with the prefix RX.

⁶ Use grooving rolls marked with the prefix RR.

Roll Grooving – Field Portable



VE226

VE226 Portable Groover

- Mounts to a Victaulic VPD752 or Ridgid* 300 power drive
- Tool is operated using a standard 3/8"/9.5 mm square-drive ratchet
- Available in seven models for steel (and other IPS) pipe, copper tubing and stainless steel
- Roll grooves 3/4 – 6"/20 – 150 mm pipe

Drive Requirements: Fits Victaulic VPD752 or Ridgid* 300 power drives. Optional bases for Ridgid* 535, 1224, 1822, and Oster 310 available.

Weight: 37 lbs./17 kg

Tool Ratings — Maximum Pipe Size Capacity

Tool Ratings — Maximum Pipe Size Capacity			Pipe Size (in mm)/Schedule													
Model	Pipe Material	Notes	¾ 20	1 25	1¼ 32	1½ 40	2 50	2½ 60	3 80	3½ 90	4 100	4½ 120	5 125	6 150		
VE226S	Steel							5 – 40			5 – 10					
	Stainless							40S Only								
VE226B	Steel		5 – 40													
	Stainless		40S Only													
	Aluminum	2	5 – 40													
	PVC Plastic		40	40 – 80												
VE226M	Steel							5 – 40				5 – 10				
	Stainless							40S Only								
VE226C	Copper							K, L, M and DWV								
VE226BSS	Lt. Wall SS		5S – 10S													
VE226MSS	Lt. Wall SS							5S – 10S								
VE226P	Aluminum	2						5 – 40					5 – 10			
	PVC Plastic							40 – 80				40				

² 6061-T4 or 6063-T4 Alloy must be used.

* Ridgid is a registered trademark of the Ridge Tool Company.



VE226 Power Drive Kit

- Kit for connecting a VE226 roll grooving tool to a Ridgid* 700 power drive

Capacity: See appropriate tool

Weight: 75 lbs./34 kg

* Ridgid is a registered trademark of the Ridge Tool Company.

Roll Grooving – Field Fabrication



VE272SFS

VE272SFS

- Portable roll groover mounts easily to the Victaulic VPD752 or Ridgid® 300 power drive
- Hydraulic hand pump operation with a unique pivot arm design reduces handle effort
- Enhanced tracking rolls help to keep the pipe on the tool during the roll grooving process
- Roll grooves $\frac{3}{4}$ – 12"/20 – 300 mm pipe
(Supplied with 2 – 12"/50 – 300 mm carbon steel roll sets)

Power Requirements: Victaulic VPD752 or Ridgid® 300 power drive

Weight: 184 lbs./84 kg

Optional Rolls: $\frac{3}{4}$ "-1 1/2"/20-40mm carbon and stainless steel rolls, Lt. wall stainless steel rolls $\frac{3}{4}$ "-12"/20-300mm, EndSeal (ES), aluminum schedules 5-40 RP rolls, PVC plastic schedules 40-80 RP rolls, and copper RR rolls for type K, L, M and DWV..

Optional Accessories: An optional pipe stabilizer for 8 – 12"/200 – 300 mm pipe is available and is required for copper.

**Tool Ratings — Maximum
Pipe Size Capacity**

Tool Ratings — Maximum Pipe Size Capacity			Pipe Size (in mm)/Schedule													
Model	Pipe Material	Notes	¾ 20	1 25	1¼ 32	1½ 40	2 50	2½ 60	3 80	3½ 90	4 100	5 125	6 150	8 200	10 250	12 300
VE272SFS	Steel	3, 4	5 – 40												5 – 20	
	Stainless	3	40S												.250	
	Lt. Wall SS	5, 8	5S – 10S													
	Aluminum	2, 7					5 – 40								5 – 20	
	PVC Plastic	7, 9					40	40 – 80						40		
	Copper	6, 8					K, L, M and DWV									

* Ridgid is a registered trademark of the Ridge Tool Company.

² 6061-T4 or 6063-T4 Alloy must be used.

³ Use standard grooving rolls marked with the prefix R.

⁴ EndSeal® grooving rolls marked with the prefix RZ are available. Contact Victaulic® for details.

⁵ Use grooving rolls marked with the prefix RX.

⁶ Use grooving rolls marked with the prefix RR.

⁷ Use grooving rolls marked with the prefix RP.

⁸ Use sway brace for 8"/200 mm copper and 8"-12"/200 – 300 mm lightwall stainless steel.

⁹ A special lower roll exclusively for grooving 2" Sch. 80 PVC is available. Part. No. RP02272L02

Roll Grooving – Field Fabrication



VE416FS

VE416FS

- For field roll grooving of 2 – 16"/50 – 400 mm
- Groove depth adjuster allows for easy adjustment for initial groove diameter
- Hydraulic hand pump operation with a unique pivot arm design reduces handle effort
- Equipped with a pipe stabilizer for 6 – 16"/50 – 400 mm pipe sizes to control pipe sway

Power Requirements: Victaulic VPD752 or Ridgid* 300 power drive

Weight: 240 lbs./109 kg

Optional Rolls: Optional rolls are available for Schedule 5S and 10S stainless steel pipe, PVC and aluminum pipe, and type K, L, M and DWV copper tubing.

Tool Ratings — Maximum Pipe Size Capacity			Pipe Size (in mm)/Schedule										
			OGS									AGS	
Model	Pipe Material	Notes	2 50	2½ 60	3 80	4 100	5 125	6 150	8 200	10 250	12 300	14 350	16 400
VE416FS	Steel	3, 4	5 – 40								10 – STD	STD Wall AGS	
	Stainless	3	40S								STD	STD Wall RW AGS	
	Lt. Wall SS	5	5S – 10S									10S RWX	
	Aluminum	2, 7	5 – 40								5 – STD		
	PVC Plastic	7	40	40 – 80					40				
	Copper	6	K, L, M and DWV										

* Ridgid is a registered trademark of the Ridge Tool Company.

² 6061-T4 or 6063-T4 Alloy must be used.

³ Use standard grooving rolls marked with the prefix R.

⁴ EndSeal® grooving rolls marked with the prefix RZ are available. Contact Victaulic® for details.

⁵ Use grooving rolls marked with the prefix RX.

⁶ Use grooving rolls marked with the prefix RR.

⁷ Use grooving rolls marked with the prefix RP.

This tool should not be used for field production grooving. For field production grooving capabilities, use a VE450FSD tool. VE416FS/FSD is designed for occasional field grooving of AGS pipe.

Roll Grooving – Field Fabrication



VE270FSD/VE271FSD

VE270FSD/VE271FSD

- Completely self-contained unit with integral gear motor, safety guards, safety foot switch and power cord/plug
- Hydraulic hand pump operation with a unique pivot arm design reduces handle effort
- Enhanced tracking rolls help to keep the pipe on the tool during the roll grooving process
- Roll grooves $\frac{3}{4}$ – 12"/20 – 300 mm pipe
(Supplied with 2 – 12"/50 – 300 mm carbon steel roll sets)

Drive Requirements: Self-contained

Power Requirements: VE270FSD works with 110 volt, 15 amp power connection. VE271FSD works with 220 volt, 6 amp power connection.

Weight: 340 lbs./154 kg

Optional Rolls: $\frac{3}{4}$ "-1 $\frac{1}{2}$ "/20-40mm carbon and stainless steel rolls, Lt. wall stainless steel rolls $\frac{3}{4}$ "-12"/20-300mm, EndSeal (ES), aluminum schedules 5-40 RP rolls, PVC plastic schedules 40-80 RP rolls, and copper RR rolls for type K, L, M and DWV.

Optional Accessories: An optional pipe stabilizer for 8 – 12"/200 – 300 mm pipe is available and is required for copper.

Tool Ratings — Maximum Pipe Size Capacity			Pipe Size (in mm)/Schedule													
Model	Pipe Material	Notes	$\frac{3}{4}$ 20	1 25	1 $\frac{1}{4}$ 32	1 $\frac{1}{2}$ 40	2 50	2 $\frac{1}{2}$ 60	3 80	3 $\frac{1}{2}$ 90	4 100	5 125	6 150	8 200	10 250	12 300
VE270FSD/ VE271FSD	Steel	2, 3	5 – 40													5 – 20
	Stainless	2	40S													.250
	Lt. Wall SS	4, 13	5S – 10S													
	Aluminum	1	5 – 40													5 – 20
	PVC Plastic	6, 14	40													
	Copper	5, 13	K, L, M and DWV													

¹ 6061-T4 or 6063-T4 Alloy must be used.

² Use standard grooving rolls marked with the prefix R.

³ EndSeal® grooving rolls marked with the prefix RZ are available. Contact Victaulic® for details.

⁴ Use grooving rolls marked with the prefix RX.

⁵ Use grooving rolls marked with the prefix RR.

⁶ Use grooving rolls marked with the prefix RP.

¹³ Use sway brace for 8"/200 mm copper and 8"-12"/200 – 300 mm lightwall stainless steel.

¹⁴ A special lower roll exclusively for grooving 2" Sch. 80 PVC is available. Part. No. RP02272L02

Roll Grooving – Field Fabrication



VE416FSD/VE417FSD

VE416FSD/VE417FSD

- For field roll grooving of 2 – 16"/50 – 400 mm
- Groove depth adjuster allows for easy adjustment for initial groove diameter
- Completely self-contained units with integral gear motors, safety foot switch and power cord/plug
- Hydraulic hand pump operation with a unique pivot arm design reduces handle effort
- Equipped with a pipe stabilizer for 6 – 16"/150 – 400 mm pipe sizes to control pipe sway

Power Requirements: VE416FSD works with 110 volt, 15 amp power connection; VE417FSD works with 220 volt, 8 amp power connection

Weight: 340 lbs./154 kg

Optional Rolls: Optional rolls are available for Schedule 5S and 10S stainless steel pipe, PVC and aluminum pipe, and type K, L, M and DWV copper tubing.

Tool Ratings — Maximum Pipe Size Capacity			Pipe Size (in mm)/Schedule											
			OGS									AGS		
Model	Pipe Material	Notes	2 50	2½ 60	3 80	4 100	5 125	6 150	8 200	10 250	12 300	14 350	16 400	
VE416FSD/ VE417FSD	Steel	3, 4	5 – 40									10 – STD	STD Wall AGS	
	Stainless	3	40S									STD	STD Wall RW AGS	
	Lt. Wall SS	5	5S – 10S									10S RWX		
	Aluminum	2, 7	5 – 40									5 – STD		
	PVC Plastic	7	40	40 – 80						40				
	Copper	6	K, L, M and DWV											

² 6061-T4 or 6063-T4 Alloy must be used.

³ Use standard grooving rolls marked with the prefix R.

⁴ EndSeal® grooving rolls marked with the prefix RZ are available. Contact Victaulic® for details.

⁵ Use grooving rolls marked with the prefix RX.

⁶ Use grooving rolls marked with the prefix RR.

⁷ Use grooving rolls marked with the prefix RP.

This tool should not be used for field production grooving. For field production grooving capabilities, use a VE450FSD tool. VE416FS/FSD is designed for occasional field grooving of AGS pipe.

Roll Grooving – Field Fabrication



VE450FSD

VE450FSD

- Designed for field roll grooving of 4 – 24"/100 – 600 mm pipe
- Tool is supplied with carbon steel roll sets for grooving 4 – 12"/100 – 300 mm original groove and 14 – 24"/350 – 600 mm AGS groove on carbon steel pipe
- Enhanced tracking rolls help to keep the pipe on the tool during the roll grooving process, and quick change upper roll design
- Hydraulic hand pump operation with a unique pivot arm design reduces handle effort
- Features:
 - Lifting point to move the tool with lifting equipment
 - Frame can accept most fork lifts
 - On board storage for tool accessories

Power Requirements: VE450FSD is a self-contained unit with two 220 volt, single phase 50/60 hz, 20 amp integral gear motors to handle heavier loads, safety foot switch and power cord/plug

Weight: 825 lbs./374 kg

Optional Rolls: Optional rolls are available for lightwall stainless steel original groove; 14 – 24"/350 – 600 mm lightwall stainless steel AGS groove; and 4 – 12"/100 – 400 mm EndSeal (ES) groove.

Tool Ratings — Maximum Pipe Size Capacity			Pipe Size (in mm)/Schedule														
			OGS									AGS					
Model	Pipe Material	Notes	4 100	5 125	6 150	8 200	10 250	12 300	14 350	16 400	18 450	14 350	16 400	18 450	20 500	22 550	24 600
VE450FSD	Steel	3,10	5 – 40					5- STD				5 – STD					
	Stainless	11	40S					STD			STD						
	Lt. Wall SS	12	5S – 10S								10S RWX						
	Aluminum	2, 7	5 – 40					STD									
	PVC Plastic	7	40 – 80		40												

² 6061-T4 or 6063-T4 Alloy must be used.

³ EndSeal® grooving rolls marked with the prefix RZ are available. Contact Victaulic® for details.

⁷ Use grooving rolls marked with the prefix RP.

¹⁰ Use standard grooving rolls marked with the prefix R for both OGS and AGS.

¹¹ Use standard grooving rolls marked with the prefix R for OGS and RW for AGS.

¹² Use grooving rolls marked with the prefix RX for OGS and RWX for AGS. (Special RWX Rolls are available for grooving true Sch. 10 (0.250 | 6.4 mm).

Roll Grooving – Plant/Shop Fabrication



VE268

VE268

- Designed for fabrication shop roll grooving
- The fully-motorized, semi-automatic, electrohydraulic tool comes complete with safety guards and safety foot switch
- Equipped with a unique pivot arm design, making roll changes quick and easy, without removing shafts
- Enhanced tracking rolls help to keep the pipe on the tool during the roll grooving process
- Roll grooves $\frac{3}{4}$ – 12"/20 – 300 mm pipe ($\frac{3}{4}$ – 1½"/20 – 32 mm rolls are optional)

Drive Requirements: Self-contained

Power Requirements: 220/440 volt, 3 phase, 60 hertz standard; the tool can also be supplied for use with various global voltage connections, contact Victaulic for details. 3 phase requires tool power to be hard wired by a local certified electrician. In Europe, this tool is fitted with a cable and 440V power plug prior to shipping.

Weight: 735 lbs./333 kg

Optional Rolls: $\frac{3}{4}$ "-1 ½"/20-40mm carbon and stainless steel rolls, Lt. wall stainless steel rolls $\frac{3}{4}$ "-12"/20-300mm, EndSeal (ES), aluminum schedules 5-40 RP rolls, PVC plastic schedules 40-80 RP rolls, and copper RR rolls for type K,L,M and DWV.

Optional Accessories: An optional pipe stabilizer for 8 – 12"/200 – 300 mm pipe is available and is required for grooving 8"/200 mm copper tubing and Lt. Wall SS.

Tool Ratings — Maximum Pipe Size Capacity			Pipe Size (in mm)/Schedule													
Model	Pipe Material	Notes	$\frac{3}{4}$ 20	1 25	1¼ 32	1½ 40	2 50	2½ 60	3 80	3½ 90	4 100	5 125	6 150	8 200	10 250	12 300
VE268	Steel	3,4	5 – 40													5 – 20
	Stainless	3	40S													
	Lt. Wall SS	5	5S – 10S													
	Aluminum	2, 7	5 – 40													5 – 20
	PVC Plastic	7, 9	40													40
	Copper	6	K, L, M and DWV													

² 6061-T4 or 6063-T4 Alloy must be used.

³ Use standard grooving rolls marked with the prefix R.

⁴ EndSeal® grooving rolls marked with the prefix RZ are available. Contact Victaulic® for details.

⁵ Use grooving rolls marked with the prefix RX.

⁶ Use grooving rolls marked with the prefix RR.

⁷ Use grooving rolls marked with the prefix RP.

⁹ A special lower roll exclusively for grooving 2" Sch. 80 PVC is available. Part. No. RP02272L02

Roll Grooving – Plant/Shop Fabrication



VE414MC

VE414MC

- Designed for fabrication shop roll grooving Schedule 5, 10, and standard wall carbon steel pipe, standard wall stainless steel pipe, Schedule 40, 80 PVC pipe, and standard wall aluminum pipe
- Unique roll design, making roll changing quick and easy, without removing main shafts
- Enhanced tracking rolls help to keep the pipe on the tool during the roll grooving process
- The tool comes equipped with pipe stabilizers to provide smooth grooving operation
- Roll grooves 2 – 16"/50 – 400 mm pipe (Supplied with carbon steel 2 – 12"/50 – 300 mm original rolls and 14 – 16"/350 – 400 mm AGS rolls)

Drive Requirements: Self-contained

Power Requirements: 220/440 volt, 3 phase, 60 hertz standard; the tool can also be supplied for use with various global voltage connections, contact Victaulic for details. 3 phase requires tool power to be hard wired by a local certified electrician.

Weight: 735 lbs./333 kg

Optional Rolls: Optional rolls are available for Schedule 10S stainless steel pipe, PVC and aluminum pipe, and type K, L, M and DWV copper tubing.

AGS roll sets for 14 – 16"/350 – 400 mm Schedule 10 through 0.375"/13 mm wall carbon steel pipe are now standard.

Tool requires modifications to groove AGS profile. Contact Victaulic for pricing and details.

Tool Ratings — Maximum Pipe Size Capacity			Pipe Size (in mm)/Schedule											
			OGS									AGS		
Model	Pipe Material	Notes	2 50	2½ 60	3 80	4 100	5 125	6 150	8 200	10 250	12 300	14 350	16 400	
VE414MC	Steel	4, 10	5 – 40									10 – STD	STD Wall AGS	
	Stainless	11	40S									STD Wall RW AGS		
	Lt. Wall SS	12	5S – 10S									10S RWX		
	Aluminum	2, 7	5 – 40									5 – STD		
	PVC Plastic	7	40	40 – 80						40				
	Copper	6	K, L, M and DWV											

² 6061-T4 or 6063-T4 Alloy must be used.

⁴ EndSeal® grooving rolls marked with the prefix RZ are available. Contact Victaulic® for details.

⁶ Use grooving rolls marked with the prefix RR.

⁷ Use grooving rolls marked with the prefix RP.

¹⁰ Use standard grooving rolls marked with the prefix R for both OGS and AGS.

¹¹ Use standard grooving rolls marked with the prefix R for OGS and RW for AGS.

¹² Use grooving rolls marked with the prefix RX for OGS and RWX for AGS. (Special RWX Rolls are available for grooving true Sch. 10 (0.250 | 6.4 mm).

Roll Grooving – Plant/Shop Fabrication



VE460

VE460

- Fully-motorized, semi-automatic, hydraulic shop tool is shipped fully assembled with safety foot switch and rolls for standard grooving (4 – 24") 0.500 wall maximum.
- Enhanced tracking rolls help to keep the pipe on the tool during the roll grooving process
- Tool ships with 4 – 12" Original Groove System Groove Rolls and 14 – 24" AGS Groove Rolls and 14 – 24" AGS Groove Rolls

Drive Requirements: Self-contained

Power Requirements: 220/440 volt, 3 phase, 60 hertz standard. The tool can also be supplied for use with various global voltage connections, contact Victaulic for details. 3 phase requires tool power to be hard wired by a local certified electrician. In Europe this tool is fitted with a cable and 440V power plug prior to shipping.

Weight: 1500 lbs./680 kg

Optional Rolls: Grooving kits available to accommodate grooving 26"/650mm and above. Each support base is 12"/305 mm in height and corresponds with a range of allowable pipe sizes it can groove. See chart below for details.

AGS roll sets for 14 – 24"/350 – 900 mm Schedule 10 through 0.375"/13 mm wall carbon steel pipe are now standard.

Tool Ratings — Maximum Pipe Size Capacity [^]			Pipe Size (in mm)/Schedule																	
			AGS																	
Model	Pipe Material	Notes	14 350	16 400	18 450	20 500	22 550	24 600	26 650	28 700	30 750	32 800	34 850	36 900	38 950	40 1000	42 1050	48 1200	50 1250	60 1500
VE460	Steel	4, 11	10 – XS						.375 – .500											
	Stainless	11	STD																	
	Lt. Wall SS	12	5S – 10S, TRUE 10																	

Tool Ratings — Maximum Pipe Size Capacity			Pipe Size (in mm)/Schedule											
			OGS											
Model	Pipe Material	Notes	4 100	5 125	6 150	8 200	10 250	12 300	14 350	16 400	18 450	20 500	22 550	24 600
VE460	Steel	4, 11	5 – 80				5 – XS							
	Stainless	11	40S				STD							
	Lt. Wall SS	12	5S – 10S				5S – 10S, TRUE 10							
	Aluminum	2, 7	5 – 40											
	PVC Plastic	7	40 – 80				40							

² 6061-T4 or 6063-T4 Alloy must be used.

⁴ EndSeal® grooving rolls marked with the prefix RZ are available. Contact Victaulic® for details.

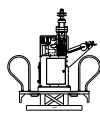
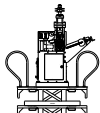
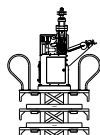
⁷ Use grooving rolls marked with the prefix RP.

¹¹ Use standard grooving rolls marked with the prefix R for OGS and RW for AGS.

¹² Use grooving rolls marked with the prefix RX for OGS and RWX for AGS. (Special RWX Rolls are available for grooving true Sch. 10 (0.250 | 6.4 mm).

Roll Grooving – Plant/Shop Fabrication

VE460 Pipe Stand Chart

Tool Model		Roll Sets Included	Railing and Platform Kit Qty	Support Base (Qty/Part No.)	Tool Weight/ Shipping Weight Lbs.	Recommended Pipe Stand ¹⁶
VE460		4 – 6"/ 100 – 150 mm 8 – 12"/ 200 – 300 mm 14 – 24"/ 350 – 600 mm	N/A	N/A	1500/1750	VAPS224 OR VAPS1672
Optional Accessories¹⁷						
26 – 38"/ 650 – 950 mm Grooving Kit		26 – 38"/ 650 – 950 mm	1	1	N/A	VAPS236 OR VAPS3036 OR VAPS1672
40 – 50"/ 1000 – 1250 mm Grooving Kit		40 – 50"/ 1000 – 1250 mm	1 ¹⁴	2 ¹⁵	N/A	VAPS1672 (R0001672PS)
54 – 60"/ 1300 – 1500 mm Grooving Kit		54 – 60"/ 1300 – 1500 mm	1 ¹⁴	3 ¹⁵	N/A	VAPS1672 (R0001672PS)

Optional Rolls: Optional rolls are available for Schedule 5S and 10S stainless steel pipe, PVC, and aluminum pipe.

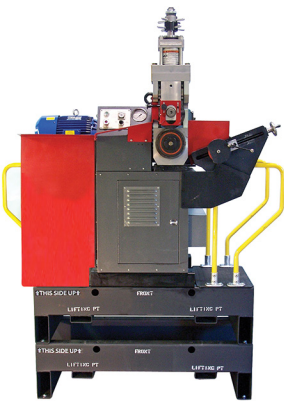
¹⁴ Railing and Platform Kit is required only if preceding kit has not been ordered.

¹⁵ Only one (1) Support Base is required if preceding kit has been ordered.

¹⁶ For proper operation, a pipe stand is required. See Accessories for details.

¹⁷ Optional Accessory Kits list REQUIRED COMPONENTS to groove up to the specified size. Kit components can be ordered individually or as a kit.

Roll Grooving – Plant/Shop Fabrication



VE872

VE872

- Designed for fabrication shop grooving of larger carbon steel AGS grooves up to 72"/1800 mm
- The fully-motorized, semi-automatic, electrohydraulic tool comes complete with safety guards and safety foot switch
- Support bases are required to groove 30-inch/762-mm and larger pipe sizes
- Each support base is 16 inches/406 mm in height and corresponds with a range of allowable pipe sizes it can groove

Drive Requirements: Self-contained

Power Requirements: 220/440 volt, 3 phase, 60 hertz standard. The tool can also be supplied for use with various global voltage connections. 3 phase requires tool power to be hard wired by a local certified electrician. Contact Victaulic for details.

Weight: 1900 lbs./862 kg

**Tool Ratings — Maximum
Pipe Size Capacity**

Tool Ratings — Maximum Pipe Size Capacity			Pipe Size (in mm)/Schedule																											
Model	Pipe Material	Note	8 200	10 250	12 300	14 350	16 400	18 450	20 500	22 550	24 600	26 650	28 700	30 750	32 800	34 850	36 900	38 950	40 1000	42 1050	48 1200	50 1250	54 1350	56 1400	60 1500	62 1550	72 1800			
VE872	Carbon Steel	14	Sch. 40 .500	.375/9.5 mm to .500/12.7 mm																										

¹⁴ Physical properties shall be in accordance with API specification 5L, Grades B, X42, X46, X52, X56 or X60, download publication 25.09.
For physical properties not listed contact Victaulic for details.

Cut Grooving – Field Manual



VG

VG Vic-Groover

- Designed for manual or power cut grooving of a single size on steel, ductile, stainless steel, aluminum and PVC pipe
- Tools are supplied with a ratchet handle for manual operation
- Tools 2 1/2" / 50 mm and larger are supplied with a power yoke
- Cut grooves 3/4" – 8" / 20 – 200 mm pipe

Drive Requirements: Manual or external drive, min. 1/2 hp./0.37 kw

Drive Speed: 40 rpm max.

Shipped Set For: Standard groove, IPS of size indicated or rigid/flexible for ductile/cast pipe

Weight: 28 lbs./13 kg

Vic-Groover Tool Capacity

Tool Ratings — Maximum Pipe Size Capacity		Pipe Size (in mm)/Schedule											
Model	Pipe Material	3/4 20	1 25	1 1/4 32	1 1/2 40	2 50	2 1/2 60	3 80	3 1/2 90	4 100	5 125	6 150	8 200
VG	Steel	40–80											
	Stainless	40–80											
	Aluminum ¹	40–80											
	PVC Plastic	40–80											
	Ductile Iron										Cl. 53	Class 53 Min.	

Cut Grooving – Field Fabrication



VG28GD

VG28GD

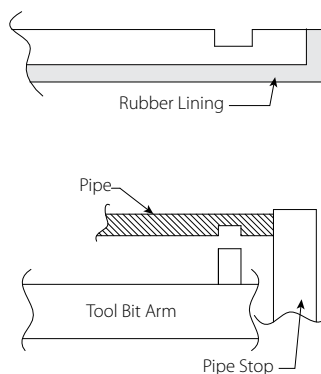
- Designed for cut grooving 2-8"/50-200 mm pipe
- A modified version (ABR) is available to groove and machine for rubber lining

Drive Requirements: External power drive

Drive Speed: 38 rpm max.

Shipped Set For: Standard groove 4 – 6"/100 – 150 mm steel pipe.

Weight: 37 lbs./17 kg



Knife Profile for Abrasion Only*

Tool Ratings — Maximum Pipe Size Capacity			Pipe Size (in mm)/Schedule							
Model	Note	Pipe Material	2 50	2½ 65	3 80	3½ 90	4 100	5 125	6 150	8 200
VG28GD	15	Steel	40 – 80							
		Stainless	40 – 80							
		Aluminum	40 – 80							
		Ductile Iron	Class 53 Min.							

Tool Ratings — Maximum Pipe Size Capacity			Pipe Size (in mm)/Schedule							
Model	Note	Pipe Material	2 50	2½ 65	3 80	3½ 90	4 100	5 125	6 150	8 200
VG28GD-ABR	15	Steel	40 – 80							



VDG26GD

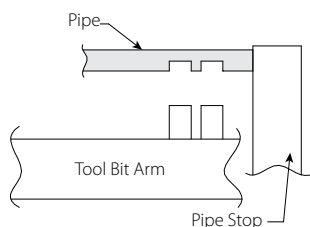
VDG26GD

- Produces a 6"/150 mm double groove for specific use with Style 808 double groove couplings

Drive Requirements: External power drive

Drive Speed: 38 rpm max.

Weight: 37 lbs./17 kg



Knife Profile for Double groove Only*

Tool Ratings — Maximum Pipe Size Capacity			Pipe Size (in mm)/Schedule							
Model	Note	Pipe Material	2 50	2½ 65	3 80	3½ 90	4 100	5 125	6 150	8 200
VDG26GD	15	Steel	40 – 80							

¹⁵ Special knives and stops may be required

NOTE: Victaulic Cut Grooving Tools require an external power source (see Power Mule in Pipe Preparation Tool Accessories).

*exaggerated for clarity

Cut Grooving – Field Fabrication



VG26GD-COR

VG26GD-COR

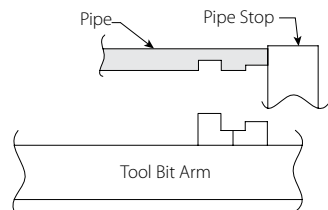
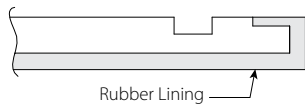
- Designed specifically to cut groove carbon steel pipe to rubber line and machine for abrasion and corrosion resistance only
- Will cut groove carbon steel 2-6"/50-150mm

Drive Requirements: External power drive

Drive Speed: 38 rpm max.

Shipped Set For: Standard groove 4 – 6"/100 – 150 mm steel pipe.

Weight: 37 lbs./17 kg



Knife Profile for Abrasion and Corrosion Only*

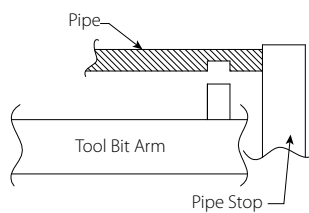
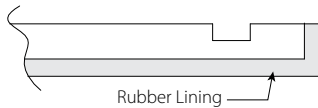
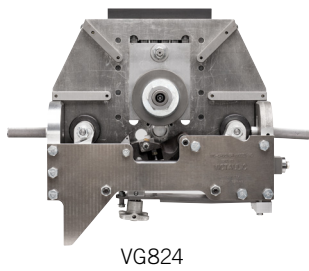
Tool Ratings — Maximum Pipe Size Capacity			Pipe Size (in mm)/Schedule							
Model	Note	Pipe Material	2 50	2½ 65	3 80	3½ 90	4 100	5 125	6 150	
VG26GD-COR	15	Steel	40 – 80							

¹⁵ Special knives and stops may be required

NOTE: Victaulic Cut Grooving Tools require an external power source (see Power Mule in Pipe Preparation Tool Accessories).

*exaggerated for clarity

Cut Grooving – Field Fabrication



Knife Profile for Abrasion Only*

VG824

- Will produce a single OGS cut groove for unlined piping systems
- The tool must be driven through its own integral gear box by an external power source
- Ideal for job site, fab shop or production cut grooving
- A modified version (ABR) is available to groove and machine for rubber lining

Drive Requirements: External power drive

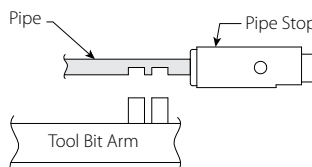
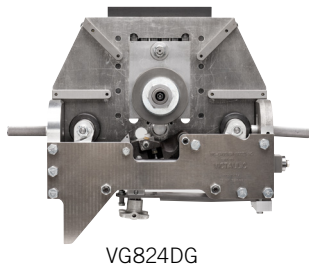
Drive Speed: 38 rpm max.

Shipped Set For: Standard groove, 8 – 12"/200 – 300 mm steel pipe

Weight: 82 lbs./37.2 kg

Tool Ratings — Maximum Pipe Size Capacity			Pipe Size (in mm)/Schedule								
Model	Note	Pipe Material	8 200	10 250	12 300	14 350	16 400	18 450	20 500	22 550	24 600
VG824	15	Steel	40 – 80					30 – STD			
		Stainless	30 – STD								
		Aluminum	30 – STD								
		Ductile Iron	Class 53 Min.								

Tool Ratings — Maximum Pipe Size Capacity			Pipe Size (in mm)/Schedule									
Model	Note	Pipe Material	8 200	10 250	12 300	14 350	16 400	18 450	20 500	22 550	24 600	
VG824-ABR	15	Steel	40 – XS									



Knife Profile for Double Groove Only*

VG824DG

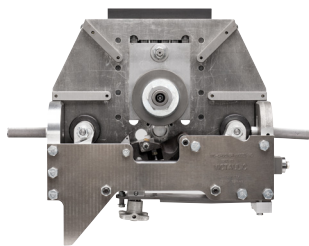
- Designed specifically for cutting a double groove on 8-12"/200-300mm pipe for use with Style 808 double groove couplings
- Ideal for job site, fab shop or production cut grooving

Tool Ratings — Maximum Pipe Size Capacity			Pipe Size (in mm)/Schedule									
Model	Note	Pipe Material	8 200	10 250	12 300	14 350	16 400	18 450	20 500	22 550	24 600	
VG824DG	15	Steel	40 – 80									

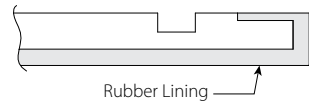
¹⁵ Special knives and stops may be required

*exaggerated for clarity

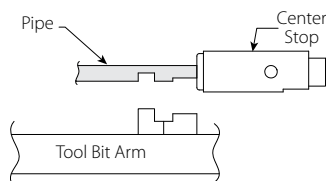
Cut Grooving – Field Fabrication



VG824-COR



Rubber Lining



Knife Profile for Abrasion and Corrosion Only*

VG824-COR

- Designed specifically to cut groove carbon steel pipe to be rubber lined and machined for abrasion and corrosion resistance only
- The tool must be driven through its own integral gear box by an external power source at a maximum speed of 38 rpm
- Ideal for job site, fab shop or production cut grooving
- Cut grooves 8 – 24"/200 – 600 mm pipe

Drive Requirements: External power drive

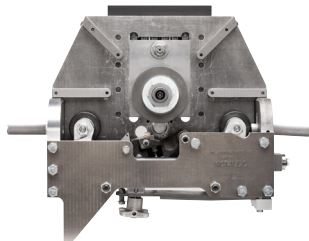
Drive Speed: 38 rpm max.

Shipped Set For: Standard groove, 8 – 12"/200 – 300 mm steel pipe

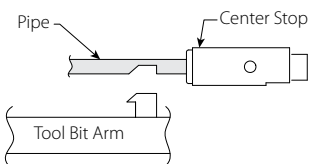
Weight: 82 lbs./37.2 kg

Tool Ratings — Maximum Pipe Size Capacity			Pipe Size (in mm)/Schedule									
Model	Note	Pipe Material	8 200	10 250	12 300	14 350	16 400	18 450	20 500	22 550	24 600	
VG824-COR	15	Steel	40 – .500									

¹⁵ Special knives and stops may be required



VG828



Knife Profile for Abrasion and Corrosion Only*

VG828

- VG828 will produce a single AGS cut groove
- Designed to be driven by the Power Mule II

Drive Requirements: External drive, min. 1½ hp

Drive Speed: 38 rpm max.

Weight: 82 lbs./37.2 kg

Tool Ratings — Maximum Pipe Size Capacity			Pipe Size (in mm)/Schedule					
Model	Note	Pipe Material	14 350	16 400	18 450	20 500	22 550	24 600
VG828	15	Steel	.500-.750					

¹⁵ Special knives and stops may be required

*exaggerated for clarity

Cut Grooving – Field Motorized



VG412

VG412 Orbital Machining Tool

- Complete modular pipe end preparation system providing quick, accurate cutting and grooving of ductile iron pipe to meet AWWA and other industry specifications for mechanical couplings
- External mounting and drive action is particularly suited to cement lined ductile iron pipe grooving
- The hinged frame design allows cutting at any point along the pipeline
- Blade setting and replacement is fast and easy
- Cut grooves 4 – 12"/100 – 300 mm pipe
- Safety foot switch

Drive Requirements: 120 volt/11.5 amp

Shipped Set For: Rigid radius groove profile, 4 – 12"/100 – 300 mm ductile iron pipe

Weight: 151 lbs./69 kg

Options: Capable of grooving 4 – 12"/100-300 mm IPS steel for closure piece grooving only.

NOTE: Specifically designed for field closure pieces. Not suitable for production grooving.

VG412 Tool Capacity

Tool Ratings — Maximum Pipe Size Capacity		Pipe Size (in mm)/Schedule						
Model	Pipe Material	4 100	4½ 120	5 125	6 150	8 200	10 250	12 300
VG412	Steel	40 – 80						
	Ductile Iron	Class 53 Min.						

Plastic Groovers



VPG26

VPG26 AND VPG824

- PVC plastic pipe requires a radius groove to reduce any point of stress concentration in this notch sensitive material
- Tools feature a high speed, router-type tool bit which cuts a radiused groove, to full depth, in one manual rotation of the tool around the pipe

VPG26

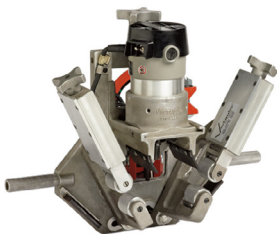
- Grooves 2 – 6"/50 – 150 mm pipe

Power Requirements: 110 volt, 1 phase, 60 Hz, 7 amps

Rotation Drive: Manual (clockwise)

Weight: 41 lbs./19 kg

Shipped Set For: VPG26 for 2 – 3 1/2"/50 – 90 mm



VPG824

VPG824

- Grooves 8 – 16"/200 – 400 mm pipe

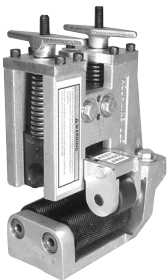
Power Requirements: 110 volt, 1 phase, 60 Hz, 7 amps

Rotation Drive: Manual (Clockwise)

Weight: 47 lbs./21 kg

Shipped Set For: VPG824 for 8 – 12"/200 – 300 mm

Aquamine Grooving Tools



APG

The APG is a manually operated tool used for producing a cut spline groove and beveled end on 4 - 12"/ 100 - 300 mm Aquamine pipe to prepare the pipe to receive an Aquamine coupling. It is an orbital tool which is rotated around a stationary, secured pipe. The tool may be operated on pipe held in a pipe vise or on supported in-place piping that is depressurized and drained.

Weight: 13.1 lbs./5.9kg

Hole Cutting Tools



HCT904

HCT904

- One piece cutting tool designed to cut holes up to 2 3/4"/70mm carbon and stainless steel pipe with OD up to 8"/200mm
- Allows for use of Mechanical-T, Vic-Let, and Vic-O-Well outlets
- This tool is only available in Europe

Capacity: 1 – 2 3/4"/25-70 mm holes for Mechanical-T, and Vic-Let connections

Power Requirements: 220 volt, 1 phase, 60 Hz, 10.0 amp

Weight: 23 lbs./10 kg



HCT908

HCT908

- One-piece hole cutting tool designed to cut holes up to 4 1/2"/120 mm in carbon and stainless steel pipe with OD up to 8"/200mm
- Allows for use of Mechanical-T, Vic-Let, and Vic-O-Well outlets

Capacity: 1 – 4 1/2"/25 – 120 mm holes for 1/2 – 4"/15 – 100 mm Mechanical-T, and Vic-Let connections

Power Requirements: 110 volt, 1 phase, 60 Hz, 7.0 amp

Weight: 23 lbs./10 kg



VHCT900

VHCT900

- Three-piece hole cutting tool designed to cut holes up to 3 1/2"/90 mm in diameter for Mechanical-T, Vic-Let, and Vic-O-Well outlets
- Base unit clamps quickly onto the pipe in vertical, horizontal or overhead positions
- Heavy-duty drill mounts to the alignment guides and a manual feed assembly provides uniform pressure on the saw for maximum cutting efficiency

Capacity: 1 – 3 1/2"/25 – 90 mm holes for 1/2 – 3"/15 – 80 mm Mechanical-T, Vic-Let connections

Power Requirements: grounded 120 volt, 1 phase, 60 Hz, 10 amp electrical supply. (220 volt, 1 phase, 60 Hz, 5 amp available on request)

Weight: 36 lbs./16 kg

Accessories: Extended chain for 10 – 24"/250 – 600 mm pipe



VIC-TAP II

VIC-TAP II

- Hole cutting tool designed for use with Style 931 Vic-Tap II Mechanical-T unit for tapping into steel pipe systems under pressures up to 500 psi/3450 kPa

Capacity: Vic-Tap II 4 – 8"/100 – 200 mm Run x 2 1/2"/65 mm (IPS) Outlet

Power Requirements: 115 volt, 1 phase, 60 Hz, 7.5 amp

Weight:

(A) Drill guide base 15 lbs./6.8 kg

(B) Drill motor and feed assembly, total wgt. 16 lbs./7.3 kg

(C) Style 931/Valve unit, 12 lb./5.4 kg – 15 lb./6.8 kg, depending upon size (4, 5, 6 and 8"/100, 125, 150 200 mm available)

Hole Size: 2 3/8"/60.5 mm

Vic-Press Tool



PFT510

PFT510

- The Vic-Press Schedule 10S System requires a Vic-Press Schedule 10S tool designed for securing Vic-Press Schedule 10S products onto IPS Schedule 10S stainless steel pipe.
- Tool package include one (1) Vic-Press PFT510 tool, two (2) 18V Lithium Ion batteries, one (1) battery charger, one (1) corded adapter, one (1) tool carrying case, one (1) jaw carrying case, one (1) ½"/15mm jaw, one (1) ¾"/20mm jaw, one (1) 1"/25mm jaw, one (1) 1 ½"/40mm hinged jaw, 2"/50mm hinged jaw, and one (1) adapter jaw.
- Jaws are included with every tool purchase.
- Vic-Press PFT510 is designed for industrial and trade use only

Capacity: ½"/15mm, ¾"/20mm, 1"/25mm, 1½"/40mm, 2"/50mm Sch10S stainless steel pipe

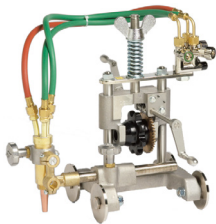
Power Requirements: 110 volt/60 cycle/6.5 amp

Optional: 220 volt

Note: The Vic-Press Schedule 10S System is not compatible with PFT505 and/or PFT509 tools/components. The Vic-Press Schedule 10S System requires the use of a Vic-Press PFT510 tool package.

Weight: PFT510 with 1"/25mm jaw 21 lbs./ 9.5kg

Pipe Cutting Tools



VCT1

VCT1 Manual

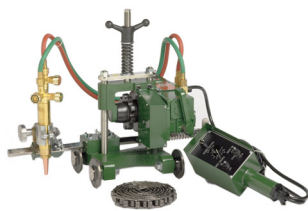
- Lightweight and portable pipe cut-off tool handles 4 – 24"/100 – 600 mm pipe, up to 0.500/12.7 mm thick
- Worm gear drive crank handle provides smooth, manual travel, easy control and accurate cutting

Capacity: 4 – 24"/100 – 600 mm

Wall Thickness: 0.065 – 0.500"/1.65 – 12.7 mm (with tips supplied)

Tips: Acetylene – 1 ea. #00, #0, #1

Weight: 22 lbs./10 kg



VCT2

VCT2 Automatic

- Rotation is powered by a small 120 VAC motor with SCR remote control
- Unique distributor design has stainless steel insert which extends tip life, eases cleaning and reduces backfire

Capacity: 6 – 24"/150 – 600 mm

Wall Thickness: 0.065 – 0.500"/1.65 – 12.7 mm (with tips supplied)

Tips: Acetylene – 1 ea. #00, #0, #1

Speed Control: SCR

Power Required: 120 volt, 1 phase, 60 Hz, 15 amp

Motor Rating: 15 W 10,000 rpm

Weight: 33 lbs./15 kg

Accessories: Guide rail is sold separately. Recommended for pipe 12"/300 mm and above. Order Guide Rail D-600 for up to 24"/600 mm pipe (others available).

Accessories – Power Drive



VPD752

VPD752

- Can be used as the power drive unit for the VE226, VE26, VE46, VE416FS and VE272SFS roll grooving tools, provided the tool is equipped with the correct base plate and the VG, VG28GD, and VG824 cut grooving tools with universal drive shaft
- Operated with a safety foot switch

Capacity: See appropriate tool

Power Requirements: 115 volts, 15 amp, 50/60 Hz (220 volt, 6 amp, 50/60Hz optional)

Weight: 140 lbs./634 kg

Optional: Universal drive shaft



Mule II

Power Mule II

- Ideal for driving individual Victaulic cut grooving tools
- Heavy-duty, two-wheeled unit drives Victaulic cut grooving tools at the speed and power necessary for accurate grooving
- Rotating head for horizontal and vertical applications
- Power Mule is equipped with a Forward-Off-Reverse control and integral foot switch

Capacity: Victaulic individual Vic-Groover tools – VG28GD, VG28GD-ABR, VG26GD, VG26GD-COR, VG824, VG824-ABR, VG824-COR, VG824DG, VG828

Power Requirements: 115 volts, 15 amp 50/60Hz

Full Load Speed: 35 rpm

Weight: 190 lbs./86 kg

Accessories – Adjustable Pipe Stand



VAPS112

VAPS112

- Designed for supporting pipe to be roll grooved
- Four adjustable legged portable self-standing unit
- Turnstile design allows pipe to be spun around for grooving of both pipe ends without dismounting pipe from stand
- Unique trough design allows for rotational and forward/traverse movement

Capacity: $\frac{3}{4}$ – 12"/20 – 300 mm IPS pipe

Load Rating: 1075 lbs./490 kg

Vertical Stroke: 14 $\frac{1}{2}$ "/368 mm for adjusting rod, 8 $\frac{1}{2}$ "/216 mm leg adjustment, 23"/584 mm

Minimum Pipe Height from Floor: 23"/584 mm on 12"/300 mm pipe
21"/533 mm on 1"/25 mm pipe

Handle Effort Required to Raise 1075 lbs./490 kg Load: 50 lbs./23 kg maximum



VAPS224

VAPS224

- Designed specifically for supporting pipe to be roll grooved
- Self-standing heavy-duty unit permits free pipe rotation and traversing on ball transfers
- Ball transfers are mounted in a manner permitting use of pipe slings
- Turnstile design allows pipe to be spun around for grooving of both pipe ends without dismounting pipe from stand

Capacity: 2 – 24"/50 – 600 mm IPS pipe

Load Rating: 1800 lbs./816 kg

Vertical Stroke: 23"/584 mm

Minimum Pipe Height from Floor: 13"/325 mm on 24"/600 mm IPS pipe

Maximum Pipe Height from Floor: 38"/965 mm on 2"/50 mm IPS pipe

Weight: 260 lbs./118 kg

Handle Effort Required to Raise 1800 lbs./817 kg Load: 50 lbs./23 kg maximum



VAPS1672

VAPS1672

Vic-Easy Adjustable Pipe Stands are portable and self-standing units that permit free pipe rotation and traversing on ball transfers. They are designed for direct use with Vic-Easy roll grooving tools.

Capacity: 16 – 72" pipe

Load Rating: 10000 lbs

Vertical Stroke: 17"

Minimum Pipe Height from Floor: 16" on 72" pipe

Maximum Pipe Height from Floor: 28" on 16" pipe

Accessories – Pipe Diameter Tape



PT100A



PT101

PT100A / PT101

- Go/No-Go pocket-sized steel tapes are available for taking circumferential measurements on pipe sizes $\frac{3}{4}$ - 24".
- Tape contains Go/No-Go markings on one side for use with $\frac{3}{4}$ - 24" pipe in ANSI B36.19 and many ISO-4200 sizes and is marked in 1/100th of an inch increments on the other side.
- The Go/No-Go side can be used to check cut or roll grooved pipe conformance to Victaulic original and Machined for Rubber Lining (ABR) ($\frac{3}{4}$ - 12") and Advanced Groove System (AGS) (14 - 24") groove diameter specifications.
- Tapes are notched on the lead end to allow proper overlap within the groove for more accurate measurement.
- The Go/No-Go side of the tape is not intended for use on sizes 76.1; 139.7; 165.1; 165.2; 216.3; 267.4; and 318.5 mm steel or stainless steel pipe sizes. For cast or ductile iron pipe sizes (up to 20"), copper tube sizes, and the steel and stainless steel pipe sizes listed above, use the side of the tape marked in 0.01" increments.
- The Go/No-Go pipe tape is a quick reference guide only. To ensure proper grooving dimensions, always refer to the I-100 Victaulic Field Installation Handbook or to the latest groove specifications publications located on www.victaulic.com.
- Metric version, PT101, is also available for 20 - 600 mm pipe sizes.

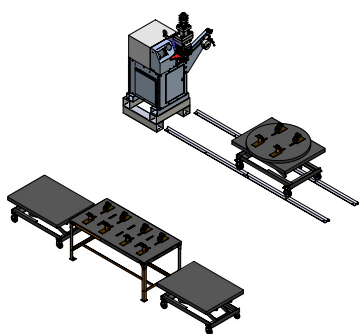
PT102



PT102

- Go/No-Go pocket-sized steel tapes are available for taking circumferential measurements on pipe sizes 8 - 72"/200 - 1800 mm.
- Tape contains Go/No-Go markings on one side for use with Original Groove System sizes 8 - 12"/200 - 300 mm pipe and Advanced Groove System sizes 14 - 72"/300 - 1800 mm pipe in ANSI B36.10/B36.19 and many ISO-4200 sizes. In addition, the PT102 contains markings in 0.02"/0.5 mm increments on the opposite side.
- The opposite side of the diameter tape can be used to check Victaulic original groove specifications in 14 - 42"/200 - 1050 mm pipe sized, including China pipe sizes and JIS specifications 8 - 12"/200 - 300 mm pipe sizes.
- The Go/No-Go pipe tape is a quick reference guide only, it is not a replacement for a calibrated diameter measuring instrument. To ensure proper grooving dimensions, always refer to the I-PT102 Victaulic Go/No-Go Pipe Diameter Tape Instructions Manual or to the latest groove specifications publications located on www.victaulic.com.

Accessories – Fabrication Cell



VAP131

VAP131- Fabrication Cell Package

- Turn-key, fab-shop solution
- Maximize productivity gains associated with Victaulic® grooved systems
- Comes standard with the VE460 shop tool, VAPS 131R pipe stand and track system, two VAPS 131F tables, VAPS 131T assembly table



VAPS 131R Hydraulic
Adjustable Pipe Stand

VAPS 131R HYDRAULIC ADJUSTABLE PIPE STAND

- Designed for supporting pipe to be roll grooved
- Permits free pipe rotation and traversing on ball transfers
- Turnstile design allows pipe to be spun around for grooving of both pipe ends without dismounting pipe from stand

Capacity: 4 – 24"/100 – 600 mm IPS pipe; load rating: 2000 lbs./907 kg

Vertical stroke: 30.5"/775 mm

Minimum pipe height from floor: Compatible with Victaulic® production roll grooving tools

Power Requirements: 115 VAC

Weight: 500 lbs./227 kg



VAPS 131F Hydraulic
Positioner

VAPS 131F HYDRAULIC POSITIONER

- Designed to support grooved pipe, valves, and fittings when used in conjunction with the VAPS 131T Assembly Table
- Foot control provided for hands-free operation
- Swivel caster wheel design for better mobility

Capacity: 4 – 24"/100 – 600 mm IPS pipe; load rating: 1200 lbs./544 kg with wheels installed, 2000 lbs./907 kg without wheels

Vertical stroke: 29.25"/743 mm

Power Requirements: 115 VAC

Weight: 400 lbs./181 kg



VAPS 131T Assembly Table

VAPS 131T ASSEMBLY TABLE

- Designed to support grooved pipe, valves, and fittings when used in conjunction with VAPS 131F Hydraulic Positioner
- Ball transfer assemblies can be positioned to accommodate pipe from 2 – 24"/50 – 600 mm

Capacity: 4 – 24"/100 – 600 mm IPS pipe; load rating: 8000 lbs./3629 kg, ball transfers load rating 700 lbs./318 kg

Vertical stroke: 29.25"/743 mm

Weight: 500 lbs./227 kg

Accessories – Victaulic Bolted Split-Sleeve Products (VBSP) Closure Tools



CTM-01 Small Manual Tool
CTM-02 Large Manual Tool

CTM-01 Small Manual Tool
CTM-02 Large Manual Tool

- Offered in small and large sizes and is ideal for joining select VBSP couplings
- The tool brings the coupling housings together to allow the bolts and nuts to be installed
- For specific information on the appropriate tool by coupling, please download individual VBSP coupling product submittals

Weight: CTM-01 10lbs./4.5kg
CTM-02 20lbs./9kg



CTH-01 Small 10-Ton Hydraulic Tool
CTH-02 Large 25-Ton Hydraulic Tool

CTH-01 SMALL 10-TON HYDRAULIC TOOL
CTH-02 LARGE 25-TON HYDRAULIC TOOL

- CTH-01 applies up to 10 tons of hydraulic force
- CTH-02 applies up to 25 tons of pressure and is designed for joining VBSP with a wall thickness of $\frac{3}{4}$ "/19 mm or 1"/25.4 mm
- For specific information on the appropriate tool by coupling, please download individual VBSP coupling product submittals

Weight: CTH-01 55lbs./25kg
CTH-02 120lbs./54kg

Grooving Times

Time for pipe preparation obviously depends on widely varied factors including productivity, location, type, hardness, and wall thickness of pipe. As a gauge for typical grooving times, the following chart was prepared to include grooving time with pipe in position and tool properly set for the size and depth of groove. Times will be extended when going from one size to another for roll changes, depth stop setting, trial grooving and other minor adjustments incidental to changing pipe sizes or initial set-up time prior to the first production groove.

Approximate Grooving Time In Minutes – Steel Pipe²²

Nominal Size	Roll Groovers – Powered							Cut Groovers			
								Vic-Groover		Vic-Adjustable	
								Power	Hand	VG28GD	VG824 Power
Inches	VE226	VE272SFS	VE270FSD	VE268	VE416FSD	VE414MC	VE460				
¾	0.5 ¹⁹	—	0.2	0.2	—	—		0.5	1.5	—	—
1	0.6 ¹⁹	—	0.2	0.2	—	—		0.5	1.5	—	—
1 ¼	0.7 ^{19 20}	—	0.2	0.2	—	—		0.7	2.0	—	—
1 ½	0.8 ^{19 20}	—	0.2	0.2	—	—		0.7	2.5	—	—
2	1.0 ^{20 21}	0.3	0.3	0.3	0.3	0.2		1.0	3.0	1.0	—
2 ½	1.3 ^{20 21}	0.3	0.3	0.3	0.3	0.2		1.2	3.8	1.3	—
3	1.4 ^{20 21}	0.4	0.4	0.4	0.4	0.2		1.4	4.5	1.5	—
3 ½	1.4 ^{20 21}	0.4	0.4	0.4	0.4	0.2		1.7	5.5	2.0	—
4	1.5 ^{20 21}	0.5	0.4	0.5	0.5	0.2	<1	1.9	7.0	2.5	—
4 ½	1.5 ^{20 21}	0.8	0.6	0.6	0.6	0.2	<1	2.3	8.0	2.8	—
5	1.6 ^{20 21}	1.0	0.8	0.8	0.8	0.2	<1	2.5	9.0	3.5	—
6	1.8 ^{20 21}	1.5	1.2	0.8	1.0	0.3	<1	3.0	10.0	4.5	—
8	—	1.7	1.5	0.9	1.7	0.4	<1	4.0	15.0	5.0	5.0
10	—	2.0	1.8	1.5	2.5	0.6	1.1	—	—	—	8.0
12	—	2.5	2.3	1.8	3.5	0.7	1.4	—	—	—	10.0
14	—	—	—	—	7.4 ²³	3.6 ²³	2.7	—	—	—	12.0
16	—	—	—	—	8.0 ²³	4.0 ²³	3	—	—	—	16.0
18	—	—	—	—	—	—	3.5	—	—	—	20.0
20	—	—	—	—	—	—	3.8	—	—	—	23.0
22	—	—	—	—	—	—	4	—	—	—	27.0
24	—	—	—	—	—	—	4.2	—	—	—	30.0
26	—	—	—	—	—	—	3.2 ²⁴	—	—	—	—
28	—	—	—	—	—	—	3.2 ²⁴	—	—	—	—
30	—	—	—	—	—	—	3.4 ²⁴	—	—	—	—
32	—	—	—	—	—	—	3.6 ²⁴	—	—	—	—
36	—	—	—	—	—	—	4.0 ²⁴	—	—	—	—
38	—	—	—	—	—	—	4.2 ²⁴	—	—	—	—
42	—	—	—	—	—	—	4.5 ²⁴	—	—	—	—
46	—	—	—	—	—	—	4.8 ²⁴	—	—	—	—
48	—	—	—	—	—	—	5.0 ²⁴	—	—	—	—
54	—	—	—	—	—	—	5.5 ²⁴	—	—	—	—
56	—	—	—	—	—	—	5.8 ²⁴	—	—	—	—
60	—	—	—	—	—	—	6.5 ²⁴	—	—	—	—

¹⁹ VE226B ²⁰ VE226S ²¹ VE226M

²² For roll groovers the times apply to the thickest pipe wall for which the tool is rated. See tool capacities. For cut groovers, the times apply to standard wall steel pipe. For other materials and thicknesses contact Victaulic for details.

²³ For AGS roll grooves

²⁴ Based on 3/8"/10 mm wall thickness. For ½"/13 mm wall thickness add 10% to grooving times.

Standard Pipe Wall Thickness

(ANSI B 36.10 & B 36.19 for Stainless Steel Pipe)

Nominal Size	Actual Outside Diameter	Pipe Schedule/Wall Thickness – Inches/millimeters								
		5S	5	10S	10	20	30	40	STD.	80
¾ 20	1.050 26.9	0.065 1.65	0.065 1.65	0.083 2.11	—	—	—	0.113 2.87	0.113 2.87	0.154 3.91
1 25	1.315 33.7	0.065 1.65	0.065 1.65	0.109 2.77	—	—	—	0.133 3.38	0.133 3.38	0.179 4.55
1 ¼ 32	1.660 42.4	0.065 1.65	0.065 1.65	0.109 2.77	—	—	—	0.140 3.56	0.140 3.56	0.191 4.85
1 ½ 40	1.900 48.3	0.065 1.65	0.065 1.65	0.109 2.77	—	—	—	0.145 3.68	0.145 3.68	0.200 5.08
2 50	2.375 60.3	0.065 1.65	0.065 1.65	0.109 2.77	—	—	—	0.154 3.91	0.154 3.91	0.218 5.54
2 ½ 65	2.875 73.0	0.083 2.11	0.083 2.11	0.120 3.05	—	—	—	0.203 5.16	0.203 5.16	0.276 7.01
3 80	3.500 88.9	0.083 2.11	0.083 2.11	0.120 3.05	—	—	—	0.216 5.49	0.216 5.49	0.300 7.62
3 ½ 90	4.000 101.6	0.083 2.11	0.083 2.11	0.120 3.05	—	—	—	0.226 5.74	0.226 5.74	0.318 8.08
4 100	4.500 114.3	0.083 2.11	0.083 2.11	0.120 3.05	—	—	—	0.237 6.02	0.237 6.02	0.337 8.56
5 125	5.563 141.3	0.109 2.77	0.109 2.77	0.134 3.40	—	—	—	0.258 6.55	0.258 6.55	0.375 9.53
6 150	6.625 168.3	0.109 2.77	0.109 2.77	0.134 3.40	—	—	—	0.280 7.11	0.280 7.11	0.432 10.97
8 200	8.625 219.1	0.109 2.77	0.109 2.77	0.148 3.76	—	0.250 6.35	0.277 7.04	0.322 8.18	0.322 8.18	0.500 12.70
10 250	10.750 273.0	0.134 3.40	0.134 3.40	0.165 4.19	—	0.250 6.35	0.307 7.80	0.365 9.27	0.365 9.27	0.594 15.09
12 300	12.750 323.8	0.156 3.96	0.156 3.96	0.180 4.57	—	0.250 6.35	0.330 8.38	0.406 10.31	0.375 9.53	0.688 17.48
14 350	14.000 355.6	0.156 3.96	—	0.188 4.78	0.250 6.35	0.312 7.92	0.375 9.53	0.438 11.13	0.375 9.53	0.750 19.05
16 400	16.000 406.4	0.165 4.19	—	0.188 4.78	0.250 6.35	0.312 7.92	0.375 9.53	0.500 12.70	0.375 9.53	0.844 21.44
18 450	18.000 457.0	0.165 4.19	—	0.188 4.78	0.250 6.35	0.312 7.92	0.438 11.13	0.562 14.27	0.375 9.53	0.938 23.83
20 500	20.000 508.0	0.188 4.78	—	0.218 5.54	0.250 6.35	0.375 9.53	0.500 12.70	0.594 15.09	0.375 9.53	1.031 26.19
24 600	24.000 610.0	0.218 5.54	—	0.250 6.35	0.250 6.35	0.375 9.53	0.562 14.27	0.688 17.48	0.375 9.53	1.219 30.96
26 650	26.000 660.4	—	—	—	0.312 7.92	0.500 12.70	—	—	0.375 9.53	—
28 700	28.000 711.0	—	—	—	0.312 7.92	0.500 12.70	0.625 15.88	—	0.375 9.53	—

Standard Pipe Wall Thickness

(ANSI B 36.10 & B 36.19 for Stainless Steel Pipe)

Nominal Size	Actual Outside Diameter	Pipe Schedule/Wall Thickness – Inches/millimeters								
		5S	5	10S	10	20	30	40	STD.	80
30 750	30.000 762.0	0.250 6.35	—	0.312 7.92	0.312 7.92	0.500 12.70	0.625 15.88	—	0.375 9.53	—
32 800	32.000 813.0	—	—	—	0.312 7.92	0.500 12.70	0.625 15.88	0.688 17.48	0.375 9.53	—
36 900	36.000 914.0	—	—	—	0.312 7.92	0.500 12.70	0.625 15.88	0.750 19.05	0.375 9.53	—
36	36.000 914.4	—	—	—	—	—	—	+	—	+
38	38.000 965.2	—	—	—	—	—	—	+	—	+
42	42.000 1066.8	—	—	—	—	—	—	+	—	+
46	46.000 1168.4	—	—	—	—	—	—	+	0.375 9.52	0.5 12.70
48	48.000 1219.2	—	—	—	—	—	—	+	0.375 9.52	0.5 12.70
54	54.000 1371.6	—	—	—	—	—	—	+	—	+
56	56.000 1422.4	—	—	—	—	—	—	+	—	+
60	60.000 1524.0	—	—	—	—	—	—	+	—	+
72	72.000 1828.8	—	—	—	—	—	—	+	—	+

Installation

Reference should always be made to the [I-100 Victaulic Field Installation Handbook](#) for the product you are installing. Handbooks are included with each shipment of Victaulic products for complete installation and assembly data, and are available in PDF format on our website at www.victaulic.com.

Warranty

Refer to the Warranty section of the current Price List or contact Victaulic for details.

Note

This product shall be manufactured by Victaulic or to Victaulic specifications. All products to be installed in accordance with current Victaulic installation/assembly instructions. Victaulic reserves the right to change product specifications, designs and standard equipment without notice and without incurring obligations.

Trademarks

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