











**TABLE 1: Stainless Steel Grooving Guide**

| Size              |                                   | ASME B36.19 Schedule # | Wall Thickness |       | Victaulic Cutting Knives / Grooving Roll Sets |                      |      |                      |      |     |
|-------------------|-----------------------------------|------------------------|----------------|-------|-----------------------------------------------|----------------------|------|----------------------|------|-----|
| Nominal inches DN | Actual Outside Diameter inches mm |                        |                |       | "StrengThin™ 100" Groove Profile              | "OGS" Groove Profile |      | "AGS" Groove Profile |      |     |
|                   |                                   |                        |                |       | ROLL                                          | CUT                  | ROLL |                      | ROLL |     |
|                   |                                   |                        |                |       | StrengThin™ 100                               | Knives               | R    | RX                   | RW   | RWX |
|                   |                                   | inches                 | mm             |       |                                               |                      |      |                      |      |     |
| 2½ DN65           | 2.875 73.0                        | 5S                     | 0.083          | 2.11  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | 10S                    | 0.120          | 3.05  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | 40S/STD                | 0.203          | 5.16  | -                                             | ✓                    | ✓    | ✓                    | -    | -   |
|                   |                                   | 80S                    | 0.276          | 7.01  | -                                             | ✓                    | -    | ✓                    | -    | -   |
| 76.1mm            | 76.1mm                            | -                      | -              | 1.60  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 2.00  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 2.30  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 2.60  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 2.90  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 3.60  | -                                             | -                    | ✓    | -                    | -    | -   |
|                   |                                   | -                      | -              | 4.00  | -                                             | -                    | ✓    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 5.00  | -                                             | ✓                    | ✓    | -                    | -    | -   |
| 3 DN80            | 3.500 88.9                        | -                      | -              | 1.60  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 2.00  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | 5S                     | 0.083          | 2.11  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 2.30  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 2.60  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 2.90  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | 10S                    | 0.120          | 3.05  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 3.20  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 3.60  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 4.00  | -                                             | -                    | ✓    | -                    | -    | -   |
|                   |                                   | 40S/STD                | 0.216          | 5.49  | -                                             | ✓                    | ✓    | -                    | -    | -   |
|                   |                                   | -                      | -              | 5.60  | -                                             | ✓                    | ✓    | -                    | -    | -   |
| 80S               | 0.300                             | 7.62                   | -              | ✓     | -                                             | -                    | -    | -                    |      |     |
| -                 | -                                 | 8.00                   | -              | ✓     | -                                             | -                    | -    | -                    |      |     |
| 3½ DN90           | 4.000 101.6                       | 5S                     | 0.083          | 2.11  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | 10S                    | 0.120          | 3.05  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | 40S/STD                | 0.226          | 5.74  | -                                             | ✓                    | ✓    | -                    | -    | -   |
|                   |                                   | -                      | -              | 8.00  | -                                             | ✓                    | ✓    | -                    | -    | -   |
|                   |                                   | 80S                    | 0.318          | 8.08  | -                                             | ✓                    | -    | -                    | -    | -   |
| 4 DN100           | 4.500 114.3                       | -                      | -              | 1.60  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 2.00  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | 5S                     | 0.083          | 2.11  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 2.60  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 2.90  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | 10S                    | 0.120          | 3.05  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 3.60  | -                                             | -                    | ✓    | -                    | -    | -   |
|                   |                                   | -                      | -              | 4.50  | -                                             | -                    | ✓    | -                    | -    | -   |
|                   |                                   | 40S/STD                | 0.237          | 6.02  | -                                             | ✓                    | ✓    | -                    | -    | -   |
|                   |                                   | -                      | -              | 6.30  | -                                             | ✓                    | -    | -                    | -    | -   |
|                   |                                   | 80S                    | 0.337          | 8.56  | -                                             | ✓                    | -    | -                    | -    | -   |
|                   |                                   | -                      | -              | 8.80  | -                                             | ✓                    | -    | -                    | -    | -   |
| 139.7mm           | 139.7mm                           | -                      | -              | 1.60  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 2.00  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 2.60  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 3.20  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 4.00  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 5.00  | -                                             | -                    | ✓    | -                    | -    | -   |
|                   |                                   | -                      | -              | 6.30  | -                                             | ✓                    | ✓    | -                    | -    | -   |
|                   |                                   | -                      | -              | 7.10  | -                                             | ✓                    | ✓    | -                    | -    | -   |
|                   |                                   | -                      | -              | 10.00 | -                                             | ✓                    | -    | -                    | -    | -   |

**TABLE 1: Stainless Steel Grooving Guide**

| Size              |                                   | ASME B36.19 Schedule # | Wall Thickness |       | Victaulic Cutting Knives / Grooving Roll Sets |                      |      |                      |      |     |
|-------------------|-----------------------------------|------------------------|----------------|-------|-----------------------------------------------|----------------------|------|----------------------|------|-----|
| Nominal inches DN | Actual Outside Diameter inches mm |                        |                |       | "StrengThin™ 100" Groove Profile              | "OGS" Groove Profile |      | "AGS" Groove Profile |      |     |
|                   |                                   |                        |                |       | ROLL                                          | CUT                  | ROLL |                      | ROLL |     |
|                   |                                   |                        |                |       | StrengThin™ 100                               | Knives               | R    | RX                   | RW   | RWX |
|                   |                                   | inches                 | mm             |       |                                               |                      |      |                      |      |     |
| 5<br>DN125        | 5.563<br>141.3                    | 5S                     | 0.109          | 2.77  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | 10S                    | 0.134          | 3.40  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | 40S/STD                | 0.258          | 6.55  | -                                             | ✓                    | ✓    | -                    | -    | -   |
| 6<br>DN150        | 6.625<br>168.3                    | -                      | -              | 1.60  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 2.00  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 2.60  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | 5S                     | 0.109          | 2.75  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 3.20  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | 10S                    | 0.134          | 3.40  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 4.00  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 4.50  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 5.00  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | 40S/STD                | 0.28           | 7.11  | -                                             | ✓                    | ✓    | -                    | -    | -   |
|                   |                                   | -                      | -              | 11.00 | -                                             | ✓                    | -    | -                    | -    | -   |
| 8<br>DN200        | 8.625<br>219.1                    | -                      | -              | 2.00  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 2.60  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | 5S                     | 0.109          | 2.77  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 3.00  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 3.20  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 3.60  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | 10S                    | 0.148          | 3.76  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 4.00  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | 0.188          | 4.78  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 6.30  | -                                             | ✓                    | ✓    | -                    | -    | -   |
|                   |                                   | -                      | -              | 8.00  | -                                             | ✓                    | ✓    | -                    | -    | -   |
| 40S/STD           | 0.322                             | 8.18                   | -              | ✓     | ✓                                             | -                    | -    | -                    |      |     |
| -                 | -                                 | 12.50                  | -              | ✓     | -                                             | -                    | -    | -                    |      |     |
| 10<br>DN250       | 10.750<br>273.0                   | -                      | -              | 2.00  | -                                             | -                    | -    | -                    | -    | -   |
|                   |                                   | -                      | -              | 2.60  | -                                             | -                    | -    | -                    | -    | -   |
|                   |                                   | -                      | -              | 3.00  | ✓                                             | -                    | -    | -                    | -    | -   |
|                   |                                   | -                      | -              | 3.20  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | 5S                     | 0.134          | 3.40  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 3.60  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 4.00  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | 10S                    | 0.165          | 4.19  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | 0.188          | 4.78  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 6.30  | -                                             | ✓                    | ✓    | -                    | -    | -   |
|                   |                                   | 40S/STD                | 0.365          | 9.27  | -                                             | ✓                    | ✓    | -                    | -    | -   |
| -                 | -                                 | 10.00                  | -              | ✓     | -                                             | -                    | -    | -                    |      |     |
| -                 | -                                 | 12.50                  | -              | ✓     | -                                             | -                    | -    | -                    |      |     |
| -                 | -                                 | 14.20                  | -              | ✓     | -                                             | -                    | -    | -                    |      |     |
| 12<br>DN300       | 12.750<br>323.9                   | -                      | -              | 2.00  | -                                             | -                    | -    | -                    | -    | -   |
|                   |                                   | -                      | -              | 2.60  | -                                             | -                    | -    | -                    | -    | -   |
|                   |                                   | -                      | -              | 3.00  | ✓                                             | -                    | -    | -                    | -    | -   |
|                   |                                   | -                      | -              | 3.20  | ✓                                             | -                    | -    | -                    | -    | -   |
|                   |                                   | 5S                     | 0.156          | 3.96  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 4.00  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 4.50  | ✓                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | 10S                    | 0.18           | 4.57  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | 0.188          | 4.78  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 5.00  | -                                             | -                    | -    | ✓                    | -    | -   |
|                   |                                   | -                      | -              | 7.10  | -                                             | ✓                    | ✓    | -                    | -    | -   |
| 40S/STD           | 0.375                             | 9.53                   | -              | ✓     | -                                             | -                    | -    | -                    |      |     |
| -                 | -                                 | 10.00                  | -              | ✓     | -                                             | -                    | -    | -                    |      |     |
| -                 | -                                 | 12.50                  | -              | ✓     | -                                             | -                    | -    | -                    |      |     |

**TABLE 1: Stainless Steel Grooving Guide**

| Size                    |                                               | ASME<br>B36.19<br>Schedule # | Wall Thickness |      | Victaulic Cutting Knives / Grooving Roll Sets |                         |      |                         |      |     |
|-------------------------|-----------------------------------------------|------------------------------|----------------|------|-----------------------------------------------|-------------------------|------|-------------------------|------|-----|
| Nominal<br>inches<br>DN | Actual<br>Outside<br>Diameter<br>inches<br>mm |                              |                |      | "StrengThin™<br>100"<br>Groove Profile        | "OGS"<br>Groove Profile |      | "AGS"<br>Groove Profile |      |     |
|                         |                                               |                              |                |      | ROLL                                          | CUT                     | ROLL |                         | ROLL |     |
|                         |                                               |                              |                |      | StrengThin™ 100                               | Knives                  | R    | RX                      | RW   | RWX |
| 14<br>DN350             | 14.000<br>355.6                               | 5S                           | 0.156          | 3.96 | -                                             | -                       | -    | ✓                       | -    | ✓   |
|                         |                                               | 10S                          | 0.188          | 4.78 | -                                             | -                       | -    | ✓                       | -    | ✓   |
|                         |                                               | 10                           | 0.250          | 6.35 | -                                             | -                       | -    | ✓                       | ✓    | -   |
|                         |                                               | STD                          | 0.375          | 9.53 | -                                             | ✓                       | ✓    | -                       | ✓    | -   |
| 16<br>DN400             | 16.000<br>406.4                               | 5S                           | 0.165          | 4.19 | -                                             | -                       | -    | ✓                       | -    | ✓   |
|                         |                                               | 10S                          | 0.188          | 4.78 | -                                             | -                       | -    | ✓                       | -    | ✓   |
|                         |                                               | 10                           | 0.250          | 6.35 | -                                             | -                       | -    | ✓                       | ✓    | -   |
|                         |                                               | STD                          | 0.375          | 9.53 | -                                             | ✓                       | ✓    | -                       | ✓    | -   |
| 18<br>DN450             | 18.000<br>457.0                               | 5S                           | 0.165          | 4.19 | -                                             | -                       | -    | ✓                       | -    | ✓   |
|                         |                                               | 10S                          | 0.188          | 4.78 | -                                             | -                       | -    | ✓                       | -    | ✓   |
|                         |                                               | 10                           | 0.250          | 6.35 | -                                             | -                       | -    | ✓                       | ✓    | -   |
|                         |                                               | STD                          | 0.375          | 9.53 | -                                             | ✓                       | ✓    | -                       | ✓    | -   |
| 20<br>DN500             | 20.000<br>508.0                               | 5S                           | 0.188          | 4.78 | -                                             | -                       | -    | ✓                       | -    | ✓   |
|                         |                                               | 10S                          | 0.218          | 5.54 | -                                             | -                       | -    | ✓                       | -    | ✓   |
|                         |                                               | 10                           | 0.250          | 6.35 | -                                             | -                       | -    | ✓                       | ✓    | -   |
|                         |                                               | STD                          | 0.375          | 9.53 | -                                             | ✓                       | ✓    | -                       | ✓    | -   |
| 22<br>DN550             | 22.000<br>559.0                               | 5S                           | 0.188          | 4.78 | -                                             | -                       | -    | ✓                       | -    | ✓   |
|                         |                                               | 10S                          | 0.218          | 5.54 | -                                             | -                       | -    | ✓                       | -    | ✓   |
|                         |                                               | 10                           | 0.250          | 6.35 | -                                             | -                       | -    | ✓                       | ✓    | -   |
|                         |                                               | STD                          | 0.375          | 9.53 | -                                             | ✓                       | ✓    | ✓                       | ✓    | -   |
| 24<br>DN600             | 24.000<br>610.0                               | 5S                           | 0.218          | 5.54 | -                                             | -                       | -    | ✓                       | -    | ✓   |
|                         |                                               | 10S                          | 0.250          | 6.35 | -                                             | -                       | -    | ✓                       | -    | ✓   |
|                         |                                               | 10                           | 0.250          | 6.35 | -                                             | -                       | -    | ✓                       | ✓    | -   |
|                         |                                               | STD                          | 0.375          | 9.53 | -                                             | ✓                       | ✓    | -                       | ✓    | -   |



**TABLE 2: Victaulic roll grooving tools and corresponding roll sets for preparing stainless steel pipe**

| Tool Type                   | Victaulic Groove Profile | Roll Sets       | Tool Roll Grooving Range for 304/316 |                                 |                                  |                                 |
|-----------------------------|--------------------------|-----------------|--------------------------------------|---------------------------------|----------------------------------|---------------------------------|
|                             |                          |                 | Nominal Size Min<br>inches<br>mm     | Actual Size Min<br>inches<br>mm | Nominal Size Max<br>inches<br>mm | Actual Size Max<br>inches<br>mm |
| RG3600                      | StrengThin™              | StrengThin™ 100 | 2<br>50                              | 2.375<br>60.3                   | 12<br>300                        | 12.75<br>323.9                  |
| VE12                        | OGS                      | R               | 1<br>25                              | 1.315<br>33.4                   | 2<br>50                          | 2.375<br>60.3                   |
| VE12SS                      | OGS                      | RX              | ¾<br>20                              | 1.050<br>26.7                   | 1½<br>40                         | 1.900<br>48.3                   |
| VE26S                       | OGS                      | R               | 2<br>50                              | 2.375<br>60.3                   | 2½<br>65                         | 2.875<br>73.0                   |
| VE26SS                      | OGS                      | RX              | 2<br>50                              | 2.375<br>60.3                   | 6<br>150                         | 6.625<br>168.3                  |
| VE46                        | OGS                      | R               | 3½<br>90                             | 4.000<br>101.6                  | 6<br>150                         | 6.625<br>168.3                  |
| VE226B                      | OGS                      | R               | ¾<br>20                              | 1.050<br>26.7                   | 1½<br>40                         | 1.900<br>48.3                   |
| VE226BSS                    | OGS                      | RX              | ¾<br>20                              | 1.050<br>26.7                   | 1½<br>40                         | 1.900<br>48.3                   |
| VE226S                      | OGS                      | R               | 1¼<br>32                             | 1.660<br>42.2                   | 2½<br>65                         | 2.875<br>73.0                   |
| VE226MSS                    | OGS                      | RX              | 2<br>50                              | 2.375<br>60.3                   | 6<br>150                         | 6.625<br>168.3                  |
| VE106 / VE206               | OGS                      | R               | 1¼<br>32                             | 1.660<br>42.2                   | 2½<br>65                         | 2.875<br>73.0                   |
|                             | OGS                      | RX              | 1¼<br>32                             | 1.660<br>42.2                   | 6<br>150                         | 6.625<br>168.3                  |
| VE272SFS                    | OGS                      | R               | ¾<br>20                              | 1.050<br>26.7                   | 8<br>200                         | 8.625<br>219.1                  |
|                             | OGS                      | RX              | ¾<br>20                              | 1.050<br>26.7                   | 12<br>300                        | 12.750<br>323.9                 |
| VE270 / 271FSD <sup>5</sup> | OGS                      | R               | ¾<br>20                              | 1.050<br>26.7                   | 8<br>200                         | 8.625<br>219.1                  |
|                             | OGS                      | RX              | ¾<br>20                              | 1.050<br>26.7                   | 12<br>300                        | 12.750<br>323.9                 |
| VE416FS                     | OGS                      | R               | 2<br>50                              | 2.375<br>60.3                   | 12<br>300                        | 12.750<br>323.9                 |
|                             | OGS                      | RX              | 2<br>50                              | 2.375<br>60.3                   | 12<br>300                        | 12.750<br>323.9                 |
|                             | AGS                      | RW/RWX          | 14<br>350                            | 14.000<br>355.6                 | 16<br>400                        | 16.000<br>406.4                 |
| VE416 / 417FSD              | OGS                      | R               | 2<br>50                              | 2.375<br>60.3                   | 12<br>300                        | 12.750<br>323.9                 |
|                             | OGS                      | RX              | 2<br>50                              | 2.375<br>60.3                   | 12<br>300                        | 12.750<br>323.9                 |
|                             | AGS                      | RW/RWX          | 14<br>350                            | 14.000<br>355.6                 | 16<br>400                        | 16.000<br>406.4                 |
| VE268 <sup>5</sup>          | OGS                      | R               | ¾<br>20                              | 1.050<br>26.7                   | 8<br>200                         | 8.625<br>219.1                  |
|                             | OGS                      | RX              | ¾<br>20                              | 1.050<br>26.7                   | 12<br>300                        | 12.750<br>323.9                 |
| VE414                       | OGS                      | R               | 2<br>50                              | 2.375<br>60.3                   | 12<br>300                        | 12.750<br>323.9                 |
|                             | OGS                      | RX              | 2<br>50                              | 2.375<br>60.3                   | 12<br>300                        | 12.750<br>323.9                 |
| VE414MC                     | AGS                      | RW/RWX          | 14<br>350                            | 14.000<br>355.6                 | 16<br>400                        | 16.000<br>406.4                 |

5 ¾ – 1 ½/20 – 40 mm roll sets are not provided with the tool and must be purchased separately. Contact Victaulic for details.

**TABLE 2: Victaulic roll grooving tools and corresponding roll sets for preparing stainless steel pipe**

| Tool     | Victaulic Groove Profile | Roll Sets | Tool Roll Grooving Range for 304/316 |                                 |                                  |                                 |
|----------|--------------------------|-----------|--------------------------------------|---------------------------------|----------------------------------|---------------------------------|
|          |                          |           | Nominal Size Min<br>inches<br>mm     | Actual Size Min<br>inches<br>mm | Nominal Size Max<br>inches<br>mm | Actual Size Max<br>inches<br>mm |
| VE450    | OGS                      | R         | 4<br>100                             | 4.500<br>114.3                  | 12<br>300                        | 12.750<br>323.9                 |
|          | OGS                      | RX        | 4<br>100                             | 4.500<br>114.3                  | 12<br>300                        | 12.750<br>323.9                 |
| VE450FSD | AGS                      | RW/RWX    | 14<br>350                            | 14.000<br>355.6                 | 24<br>600                        | 24.000<br>610.0                 |
| VE460    | OGS                      | R         | 4<br>100                             | 4.500<br>114.3                  | 12<br>300                        | 12.750<br>323.9                 |
|          | OGS                      | RX        | 4<br>100                             | 4.500<br>114.3                  | 12<br>300                        | 12.750<br>323.9                 |
| VE460    | AGS                      | RW        | 14<br>350                            | 14.000<br>355.6                 | 24<br>600                        | 24.000<br>610.0                 |
|          |                          | RWX       | 14<br>350                            | 14.000<br>355.6                 | 18<br>450                        | 18.000<br>457.0                 |

**TABLE 3: Victaulic cut grooving tools and corresponding knives for preparing stainless steel pipe**

| Tool           | Victaulic Groove Profile | Knives          | Tool Cut Grooving Range for 304/316              |                                  |                                 |                                  |                                 |
|----------------|--------------------------|-----------------|--------------------------------------------------|----------------------------------|---------------------------------|----------------------------------|---------------------------------|
|                |                          |                 | Maximum Allowable Wall Thickness<br>inches<br>mm | Nominal Size Min<br>inches<br>mm | Actual Size Min<br>inches<br>mm | Nominal Size Max<br>inches<br>mm | Actual Size Max<br>inches<br>mm |
| VG Vic-Groover | OGS                      | Stainless Steel | unlimited                                        | ¾<br>20                          | 1.315<br>33.4                   | 8<br>200                         | 8.625<br>219.1                  |
| VG28GD         | OGS                      | Stainless Steel | 0.63<br>16                                       | 2<br>50                          | 2.375<br>60.3                   | 8<br>200                         | 8.625<br>219.1                  |
| VG824          | OGS                      | Stainless Steel | 0.75<br>19                                       | 8<br>200                         | 8.625<br>219.1                  | 16<br>400                        | 16.000<br>406.4                 |

## NOTIFICATIONS

### WARNING

- The proper roll set must be selected when grooving stainless steel pipe.
- Proper cutting techniques must be used to prevent pipe end distortion during the grooving process.

Failure to follow these instructions will cause joint failure, resulting in serious personal injury and/or property damage.

### WARNING

Failure to use proper roll sets when grooving pipe will cause joint failure, resulting in serious personal injury and/or property damage.

For Victaulic Original Groove System (OGS) Specifications (refer to publication 25.01):

- Victaulic RX roll sets shall be used roll grooving pipe with wall thicknesses less than std. wt. Please refer to Table 1 for more details.
- Victaulic OGS products shall not be installed on pipe that is prepared to Victaulic Advanced Groove System (AGS) specifications or Victaulic StrengThin™ 100 specifications.

For Victaulic Advanced Groove System (AGS) Specifications (refer to publication 25.09):

- Victaulic RW roll sets shall be used when preparing standard-wall stainless steel pipe to Victaulic AGS specifications.
- Victaulic RWX roll sets shall be used when preparing Schedules 5S and 10S stainless steel pipe to Victaulic AGS specifications. Please refer to Table 1 for more details.
- Victaulic AGS products shall not be installed on pipe that is prepared to Victaulic OGS specifications. Please refer to Table 1 for more details.

For Victaulic StrengThin™ 100 Specifications (refer to publication 25.13):

- A dedicated Victaulic roll grooving tool, equipped with the appropriate Victaulic ST roll set, shall be used to prepare pipe of the proper material and wall thickness to StrengThin™ 100 specifications. Contact Victaulic for additional information.
- Victaulic StrengThin™ 100 products shall not be installed on pipe that is prepared to Victaulic OGS specifications.

## REFERENCE MATERIALS

[24.01 Victaulic Tools](#)

[25.01 Victaulic OGS Roll Groove Specifications](#)

[25.09 Victaulic AGS Roll Groove Specifications](#)

[25.13 Victaulic StrengThin™ 100 Roll Groove Specifications](#)

### User Responsibility for Product Selection and Suitability

Each user bears final responsibility for making a determination as to the suitability of Victaulic products for a particular end-use application, in accordance with industry standards and project specifications, as well as Victaulic performance, maintenance, safety, and warning instructions. Nothing in this or any other document, nor any verbal recommendation, advice, or opinion from any Victaulic employee, shall be deemed to alter, vary, supersede, or waive any provision of Victaulic Company's standard conditions of sale, installation guide, or this disclaimer.

### Intellectual Property Rights

No statement contained herein concerning a possible or suggested use of any material, product, service, or design is intended, or should be construed, to grant any license under any patent or other intellectual property right of Victaulic or any of its subsidiaries or affiliates covering such use or design, or as a recommendation for the use of such material, product, service, or design in the infringement of any patent or other intellectual property right. The terms "Patented" or "Patent Pending" refer to design or utility patents or patent applications for articles and/or methods of use in the United States and/or other countries.

### 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.

### Installation

Reference should always be made to the Victaulic installation handbook or installation instructions of the product you are installing. Handbooks are included with each shipment of Victaulic products, providing complete installation and assembly data, and are available in PDF format on our website at [www.victaulic.com](http://www.victaulic.com).

### Warranty

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

### Trademarks

*Victaulic* and all other Victaulic marks are the trademarks or registered trademarks of Victaulic Company, and/or its affiliated entities, in the U.S. and/or other countries.