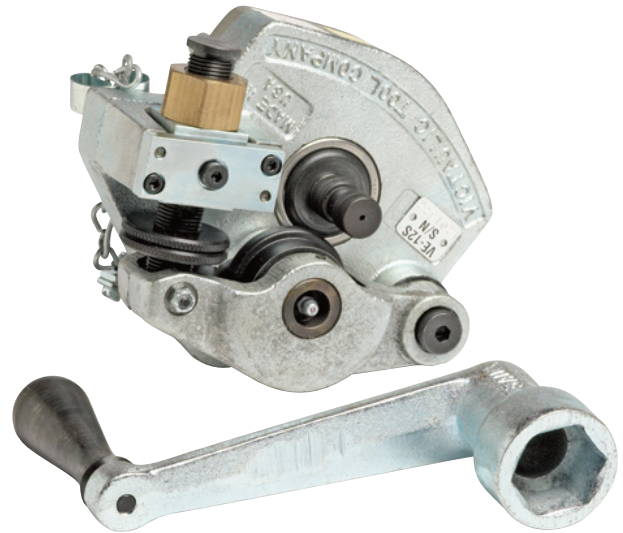


VE12 Groove-In-Place Roll Grooving Tool



For Steel, Stainless Steel, Aluminum IPS, and PVC Pipe

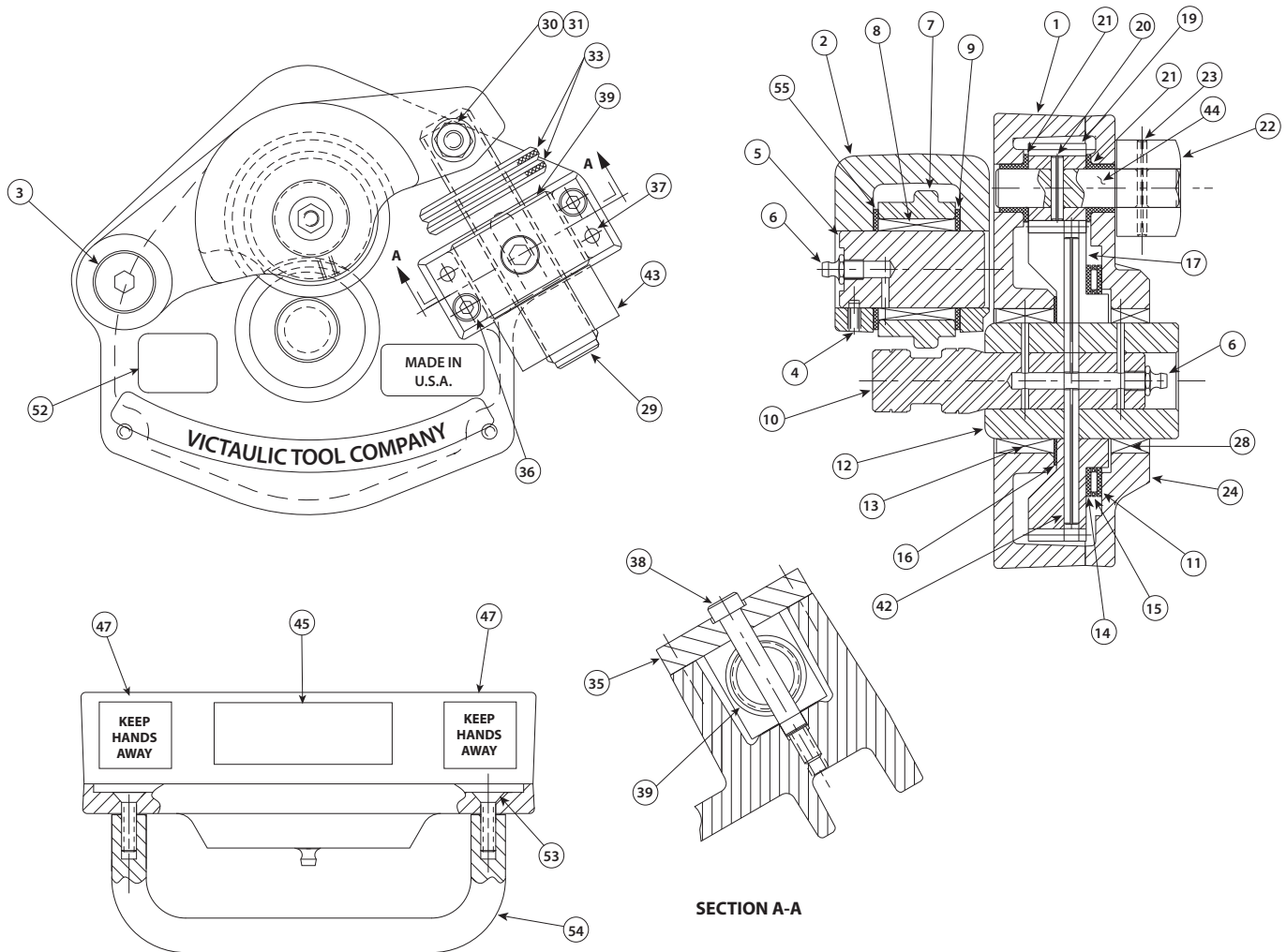
PARTS ORDERING INFORMATION

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

1. Tool Model Number – VE12
2. Tool Serial Number – The serial number can be found on the side of the tool.
3. Quantity, Item Number, Part Number, Description
4. Where to send the part(s) – Company Name and Address
5. To whose attention to send the part(s)
6. Purchase Order Number

Parts may be ordered from the nearest Victaulic Sales Office.

VE12 Groove-In-Place Roll Grooving Tool

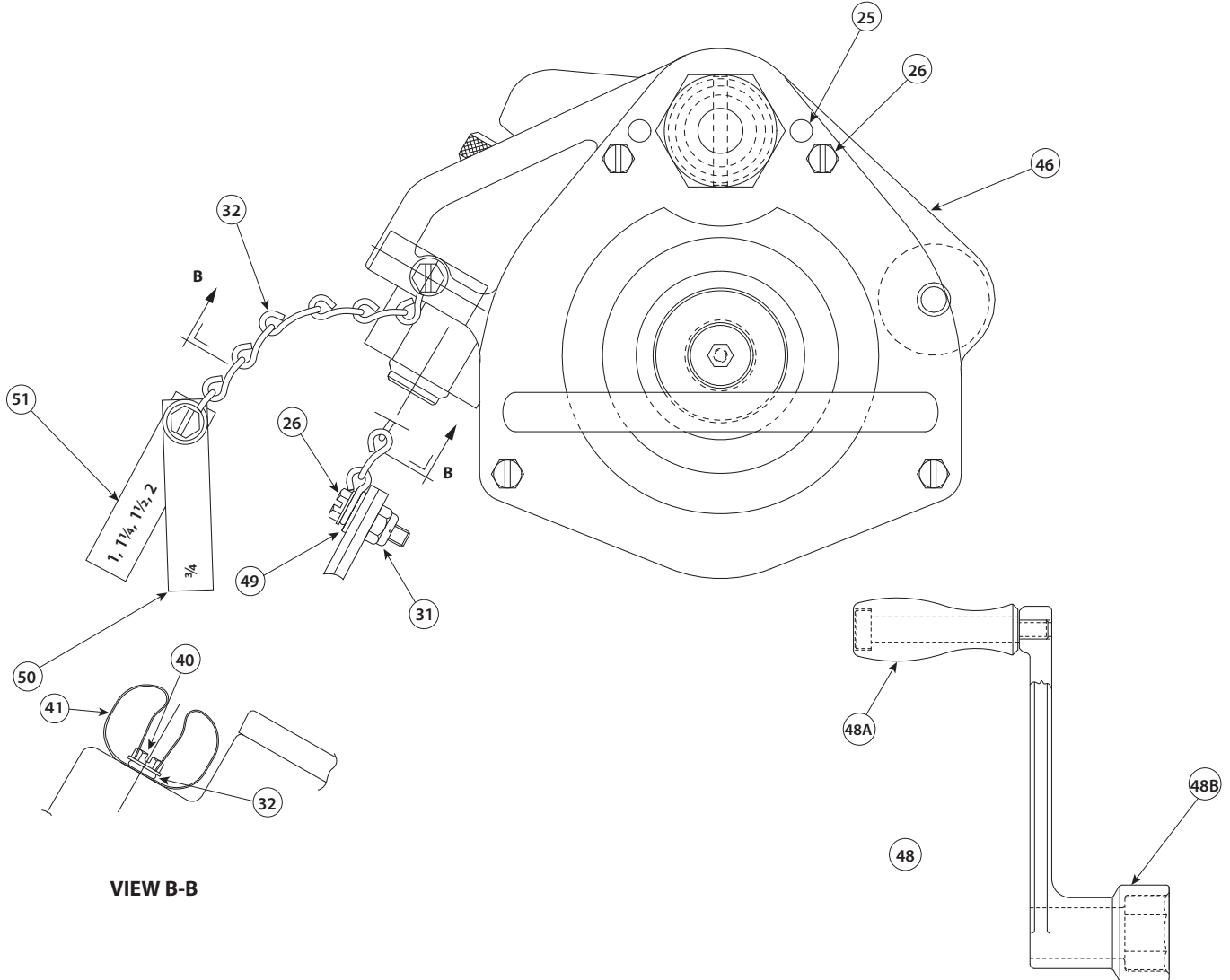


Item#	Part #	Qty.	Description
1	R-014-012-MCH	1	Body
2	R-002-012-0FS	1	Arm Machining
3	N-S05-080-012	1	Shoulder Screw, .50 Dia. X .75" Lg.
4	N-S90-010-006	1	Set Screw, Half Dog Point with Nylon Insert #10 - 24 UNC X 0.38" Lg.
5	R-008-026-0FS	1	Upper Shaft
6	N-M01-000-007	2	Grease Fitting, 1/4 - 28 Straight
7	R-900-012-UA2	1	Upper Roll Assembly
8	N-B02-100-008	1	Bearing ‡
9	N-B05-100-002	1	Thrust Washer
10	R-901-012-L02	1	Lower Roll
11	N-B05-225-001	1	Thrust Washer
12	R-902-012-A02	1	Lower Roll Adapter
13	N-B02-150-006	1	Bearing
14	N-B05-225-002	1	Thrust Washer

Item#	Part #	Qty.	Description
15	N-B03-225-001	1	Thrust Bearing
16	N-B05-150-002	1	Thrust Washer
17	R-017-012-MCH	1	Gear
19	R-015-012-MCH	1	Pinion
20	N-P80-000-010	1	Roll Pin, 1/2 Dia. X .75" Lg.
21	N-B21-050-003	2	Flange Bearing
22	R-018-026-0FS	1	Drive Nut
23	N-P01-002-104	1	Roll Pin 1/2 Dia. X 1.25" Lg.
24	R-012-012-MCH	1	Gear Cover Plate
25	N-P02-004-012	2	Dowel Pin, .25 Dia. X .75" Lg.
26	N-S22-010-012	5	#10 - 24 UNC X .75" Lg. Hex Washer Slotted Head Screw, Pltd.
28	N-B02-150-005	1	Bearing
29	R-010-026-0FS	1	Feed Screw

‡ Included with Item 7

VE12 Groove-In-Place Roll Grooving Tool



VIEW B-B

Item#	Part #	Qty.	Description
30	N-S05-040-104	1	Shoulder Screw, .25 Dia. X 1.25" Lg., Blk. Ox.
31	N-N15-010-000	2	Elastic Locknut #10 - 24 UNC, Pltd.
32	N-M09-000-005	1	#12 Steel Single Jack Chain, 7 Links
33	R-020-026-0FS	2	Depth Stop Collar
35	R-013-026-0FS	1	Front Plate
36	N-S03-010-008	2	Socket Hd. Cap Screw, #10-24 UNCX.50" Lg., Blk. Ox.
37	N-P02-003-012	2	Dowel Pin, .18 Dia. X .75" Lg.
38	N-S05-050-112	1	Shoulder Screw, .31 Dia. X 1.75" Lg., Blk. Ox.
39	R-012-026-0FS	1	Trunnion
40	N-S22-010-006	1	#10 - 24 UNC X .38" Lg. Hex Washer Slotted Head Screw, Pltd.
41	N-T08-000-003	1	Spring Clip
42	N-P01-003-112	2	Roll Pin, Heavy Duty, .188 X 1.75" Lg.
43	R-011-026-0FS	1	Feed Nut
44	R-016-012-MCH	1	Pinion Shaft

Item#	Part #	Qty.	Description
45	R-LAB-000-010	1	Warning Label#
46	R-LAB-000-009	1	"C" Diameter Label#
47	R-027-226-LBL	2	Label - Keep Hands Away#
48	R-300-026-0FS	1	Crank Assembly
48A	N-M04-000-016	1	Revolving Handle
48B	R-301-026-0FS	1	Crank Arm
49	N-W01-010-000	1	Flat Washer, #10, Pltd.
50	R-080-012-0FS	1	Gauge for 3/4" Steel Pipe
51	R-081-012-0FS	1	Gauge for 1", 1 1/4", 1 1/2", & 2" Steel Pipe
52	R-018-012-MCH	1	Serial Number Tag for Steel Groover#
53	N-S09-011-010	2	10 - 32 x 3/8 Hex Socket Flat Hd. Screw
54	N-M04-000-001	1	Handle
55	N-B05-175-004	1	Thrust Washer
56	R-207-264-LBL	1	Groove Profile Information Label (Not Shown)#

Refer to the following page for images of product labels

VE12 Groove-In-Place Roll Grooving Tool

Images of the labels on this page are not to scale.

R-LAB-000-010

⚠ WARNING

Failure to follow instructions can result in serious personal injury, property damage, and product damage.

- Before operating or servicing this tool, read and understand the operating and maintenance instructions manual and all labels located on this tool.
- **THIS IS A MANUALLY DRIVEN TOOL. DO NOT ATTEMPT TO OPERATE THIS TOOL WITH A POWER DRIVE.**
- A quarter turn of the depth stop collar will change the groove diameter 0.017 inch/0.4 mm.

3831 Rev. C RLAB000010

R-027-226-LBL

**KEEP
HANDS
AWAY**

5183 Rev. B R027226LBL

R-LAB-000-009

SIZE	MAX. SCH.	O.D.		5166 Rev. C ϕ "C" RLAB000009	
		MAXIMUM	MINIMUM	MAXIMUM	MINIMUM
3/4 [26.9]	10	1.060 [26.9]	1.040 [26.4]	0.938 [23.8]	0.923 [23.4]
1 [33.7]	40	1.328 [33.7]	1.302 [33.1]	1.190 [30.2]	1.175 [29.9]
1 1/4 [42.4]	40	1.676 [42.6]	1.644 [41.8]	1.535 [39.0]	1.520 [38.6]
1 1/2 [48.3]	40	1.919 [48.7]	1.881 [47.8]	1.775 [45.1]	1.760 [44.7]
2 [60.3]	40	2.399 [60.9]	2.351 [59.7]	2.250 [57.2]	2.235 [56.8]

R-018-012-MCH

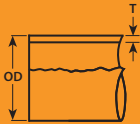
VE12S

S/N

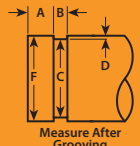
6276 Rev. C 100 000 0001

R-207-264-LBL

Pipe and groove features, noted below, must be measured to verify they are within current Victaulic specifications. Victaulic submittal publications can be downloaded at www.victaulic.com.



Measure Prior to Grooving



Measure After Grooving

OD= Average Pipe Outside Diameter B = Groove Width

T = Pipe Wall Thickness C = Average Diameter at Base of Groove

A = Distance from Pipe End to Groove D = Groove Depth

 F = Pipe-End Flare

7264 Rev. A R207264LBL

For complete contact information, visit www.victaulic.com

RP-VE12 1605 REV E UPDATED 07/2013 RPL0012000

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RP-VE12

