

VE450FSD Roll Grooving Tool



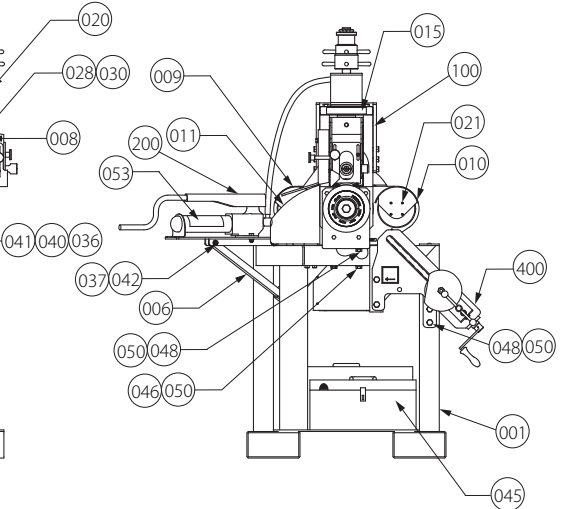
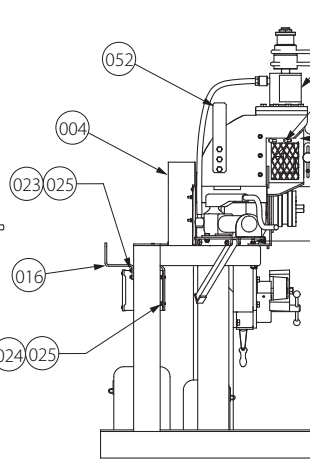
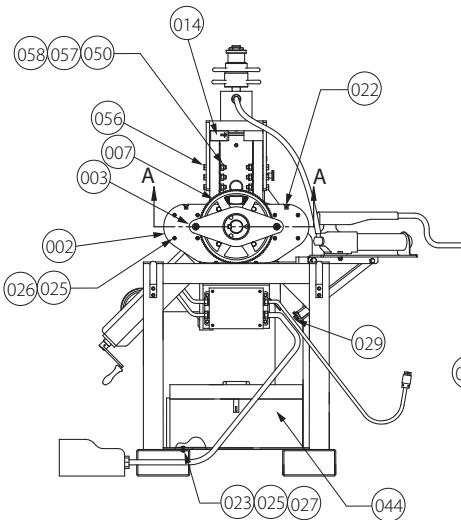
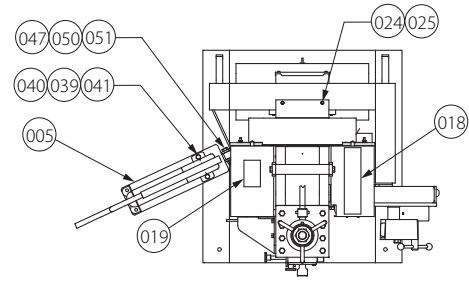
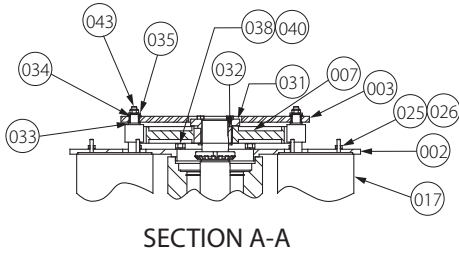
PARTS ORDERING INFORMATION

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

1. Tool Model Number – VE450FSD
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.

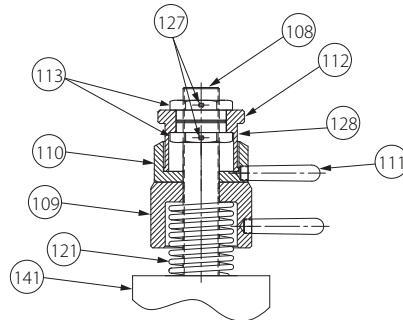
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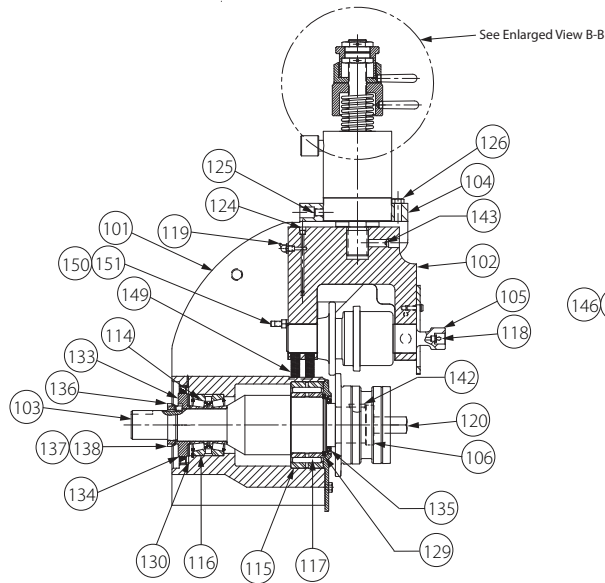
Item#	Part #	Qty.	Description
001	R-001-450-PNT	1	Frame
002	R-002-450-PNT	1	Motor Mounting Plate
003	R-003-450-PNT	1	Tie Bar
004	R-004-450-PNT	1	Gear Guard
005	R-005-450-PNT	1	Pump Channel
006	R-006-450-PNT	1	Pump Channel Support
007	R-007-450-MCH	1	Spur Gear
008	R-008-450-PNT	1	Roll Guard
009	R-009-450-PNT	1	Motor Guard, Left
010	R-010-450-PNT	1	Motor Guard, Right
011	R-011-450-PNT	1	Guard
014	R-014-450-LBL	1	Lifting Point Label
015	R-015-450-LBL	1	Identification Label
016	R-016-450-PNT	2	Cord Storage Bracket
017	R-19A-416-FSD	2	Gear Motor
018	R-009-424-LBL	1	"C" Diameter Label
019	R-011-424-LBL	1	"C" Diameter Label, AGS
020	R-009-416-LAB	1	Instruction Label
021	N-S23-008-008	8	#8 - 32 UNC x .63 Lg. Pan Hd. Cap Screw, Pltd.
022	N-S06-008-008	2	#8 - 32 UNC x .50 Lg. Pan Hd. Cap Screw, Pltd.
023	N-S01-040-012	12	1/4 - 20 UNC x .75 Lg. Hex Hd. Cap Screw, Pltd.
024	N-S01-040-008	6	1/4 - 20 UNC x .50 Lg. Hex Hd. Cap Screw, Pltd.
025	N-W03-040-000	26	1/4" Lock Washer, Pltd.
026	N-N02-040-000	8	1/4 - 28 UNF Hex Nut, Pltd.
027	N-N01-040-000	8	1/4 - 20 UNC Hex Nut, Pltd.
028	N-S01-050-100	2	5/16 - 18 UNC x 1.00 Lg. Hex Hd. Cap Screw, Pltd.
029	N-S22-050-012	1	5/16 - 18 UNC x .75 Lg. Hex Flange Screw, Pltd.
030	N-W03-050-000	2	5/16" Lock Washer, Pltd.
031	N-M38-000-002	1	Double Split Taper Bushing, Type B, ø2.00 Bore with .50 Wide Keyway

Item#	Part #	Qty.	Description
032	N-K02-080-100	1	Key, .50 Sq. x 1.00 Lg.
033	N-B21-062-001	2	Flange Bushing
034	N-B22-062-001	2	Thrust Bearing
035	N-B40-048-001	2	Tongued Washer
036	N-S01-060-400	2	3/8 - 16 UNC x 4.00 Lg. Hex Hd. Cap Screw, Pltd.
037	N-S01-060-200	1	3/8 - 16 UNC x 2.00 Lg. Hex Hd. Cap Screw, Pltd.
038	N-S01-060-108	4	3/8 - 16 UNC x 1.50 Lg. Hex Hd. Cap Screw, Pltd.
039	N-S01-060-100	2	3/8 - 16 UNC x 1.00 Lg. Hex Hd. Cap Screw, Pltd.
040	N-W03-060-000	8	3/8" Lock Washer, Pltd.
041	N-N01-060-000	4	3/8 - 16 UNC Hex Nut, Pltd.
042	N-N08-060-000	1	3/8 - 16 UNC Nylok Hex Nut, Pltd.
043	N-N05-060-000	2	3/8 - 16 UNC Elastic Locknut, Thin, Pltd.
044	R-001-600-BOX	1	Grooving Roll Storage Box
045	R-001-700-BOX	1	Foot Switch Storage Box
046	N-S01-080-400	4	1/2 - 13 UNC x 4.00 Lg. Hex Hd. Cap Screw, Pltd.
047	N-S01-080-204	1	1/2 - 13 UNC x 2.25 Lg. Hex Hd. Cap Screw, Pltd.
048	N-S01-080-108	6	1/2 - 13 UNC x 1.50 Lg. Hex Head Cap Screw, Pltd.
050	N-W03-080-000	17	1/2" Lock Washer, Pltd.
051	N-N08-080-000	1	1/2 - 13 UNC Nylok Hex Nut, Pltd.
052	R-017-450-PNT	1	Lifting Device
053	R-062-260-0FS	1	Hydraulic Hand Pump Label
056	N-S01-080-300	6	1/2 - 13 UNC x 3.0 Lg. Hex Hd. Cap Screw, Grd. 8, Pltd.
057	N-W01-080-000	6	1/2" Flat Washer, Pltd.
058	N-N01-080-000	6	1/2 - 13 UNC Hex Nut, Grd. 8, Pltd.
059	R-077-416-ASY	1	AGS Guard Setting Pad Assembly (Not Shown)
060	R-039-272-0FS-2	1	Guard Setting Pad Assembly (Not Shown)
100	R-100-450-ASY	1	VE450FSD Tool Head Assembly
200	R-200-450-ASY	1	Hydraulic Hand Pump and Hose Assembly
200a	N-H02-006-003	1	Hydraulic Hand Pump Hose Only, 36" Length
300	R-300-450-ASY	1	Electrical Assembly
400	R-400-450-ASY	1	Stabilizer Assembly

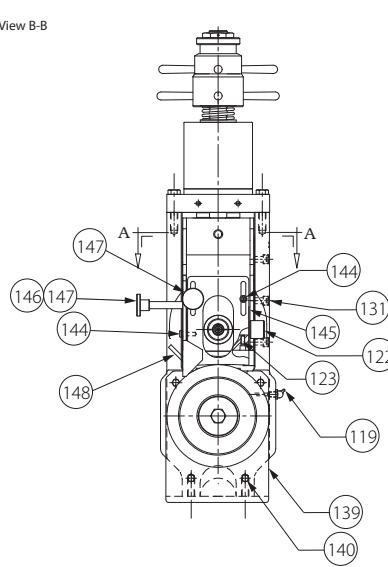
VE450FSD Roll Grooving Tool



ENLARGED VIEW B-B



Lower Roll and Upper Roll Shown for Reference Only

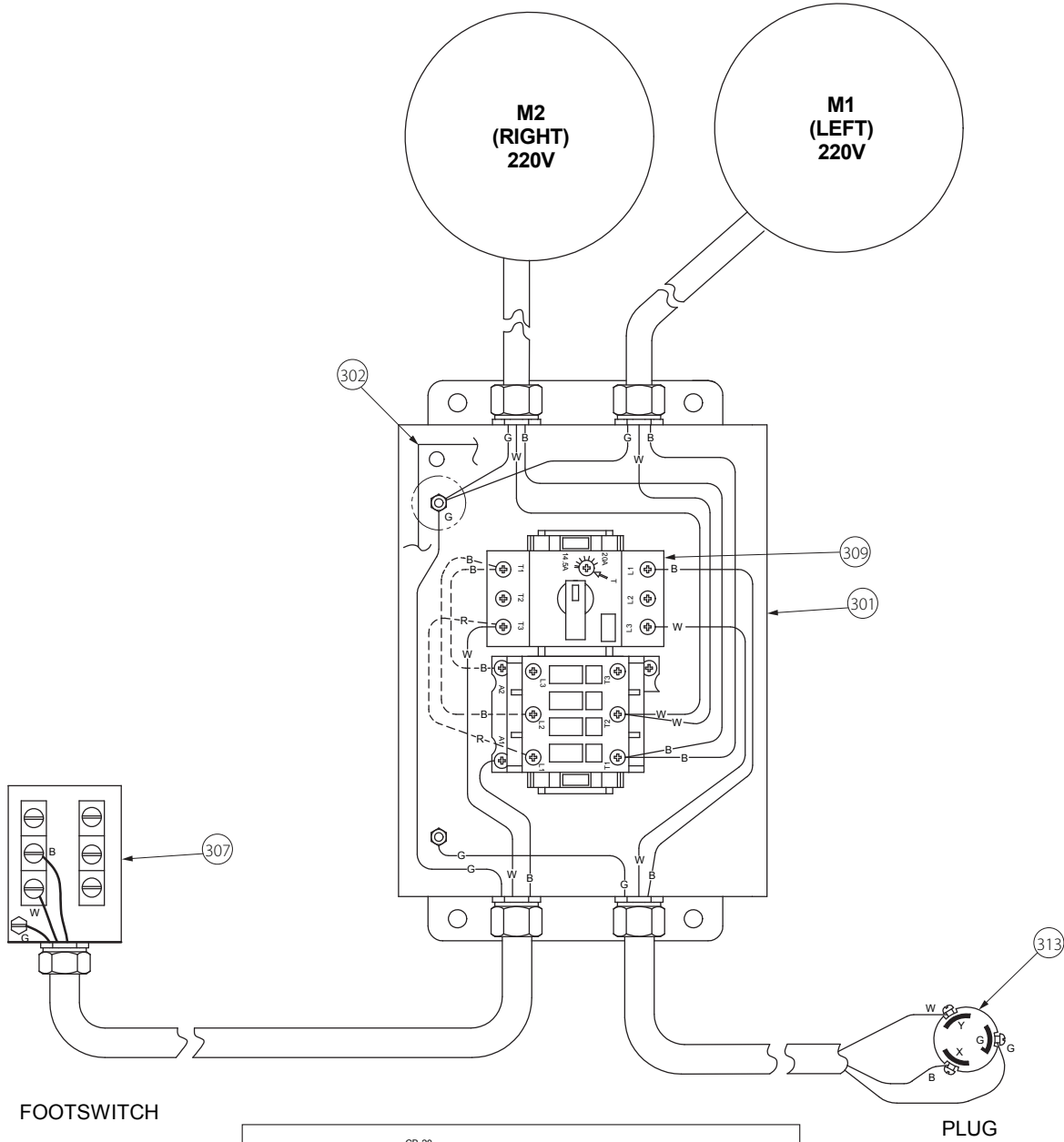


SECTION A-A

Item#	Part #	Qty.	Description
101	R-101-450-MCH	1	Tool Head
102	R-102-448-MCH	1	Slide
103	R-103-424-MAC	1	Main Shaft
104	R-104-450-PNT	1	Cylinder Mounting Plate
105	R-105-448-MCH	1	Upper Shaft
106	R-106-424-PLT	1	Lower Roll Washer
107	R-107-424-MAC	2	Gib
108	R-108-450-PLT	1	Ram Shaft
109	R-109-424-PLT	1	Depth Adjuster Lock
110	R-110-424-PLT	1	Depth Adjuster
111	R-111-424-PLT	6	Depth Adjuster Handle
112	R-112-424-PLT	1	Depth Adjuster Barrel
113	R-113-424-PLT	2	Depth Calibration Nut
114	N-B02-225-001	2	Bearing, Cone
115	N-B02-450-001	1	Bearing, Cagerol
116	N-B04-425-001	1	Bearing, Cup
117	N-B04-387-001	1	Bearing, Race
118	N-M01-000-002	1	Lub. Fitting
119	N-M01-000-001	2	Lub. Fitting
120	R-075-448-PLT	1	Lower Roll Retaining Screw
121	N-M03-000-001	1	Compression Spring
122	R-122-448-PLT	1	Upper Shaft Pin
123	N-M12-000-002	1	Ball Plunger
124	N-H16-002-001	1	3/8" Flush Socket Pressure Plug
125	N-S80-080-100	1	Set Screw, 1/2 - 13 UNC x 1.00 Lg. Brass Tip, Blk. Ox.

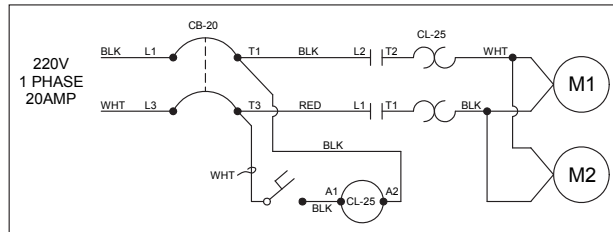
Item#	Part #	Qty.	Description
126	N-S01-080-204	8	1/2 - 13 UNC x 2.25 Lg. Hex Hd. Cap Screw, Grd. 5, Pltd.
127	N-S83-010-004	2	Set Screw, #10 - 32 UNF x .25 Lg. Brass Tip, Blk. Ox.
128	R-141-424-LAB	1	Pipe Size Indicator Label
129	N-T56-000-387	1	Retaining Ring
130	N-T53-000-425	1	Retaining Ring
131	N-S03-060-104	6	3/8 - 16 UNC x 1.25 Lg. Sock. Hd. Cap Screw, Blk. Ox.
133	R-153-424-MAC	1	Grease Seal Collar
134	N-M11-000-001	1	Grease Seal
135	N-M11-000-002	1	Grease Seal
136	R-164-424-MAC	1	Grease Seal Collar Key
137	N-B63-000-011	1	Lock Nut
138	N-B61-000-111	1	Lock Washer
139	R-003-424-MAC	1	Seal Housing
140	N-S01-050-012	4	3/16 - 18 UNC x .75 Lg. Hex Hd. Cap Screw, Pltd.
141	N-H01-000-009	1	Cylinder, 30 Ton, 2 1/2" Stroke
142	N-K01-080-900	1	Woodruff Key
143	N-S80-080-108	1	Set Screw, 1/2 - 13 UNC x 1.50 Lg. Brass Tip, Blk. Ox.
144	R-131-448-PLT	2	Guard Retaining Stud
145	R-130-448-PNT	1	Front Sliding Guard
146	R-127-448-PNT	1	Knob Stand-Off
147	N-M04-000-007	2	Knob
148	R-123-448-PNT	1	Sliding Guard
149	R-149-450-MCH	4	Die Spring
150	N-S81-060-100	2	3/8 - 16 x 1 Set Screw
151	N-S81-060-008	2	3/8 - 16 x 1/2 Set Screw

VE450FSD
Roll Grooving Tool



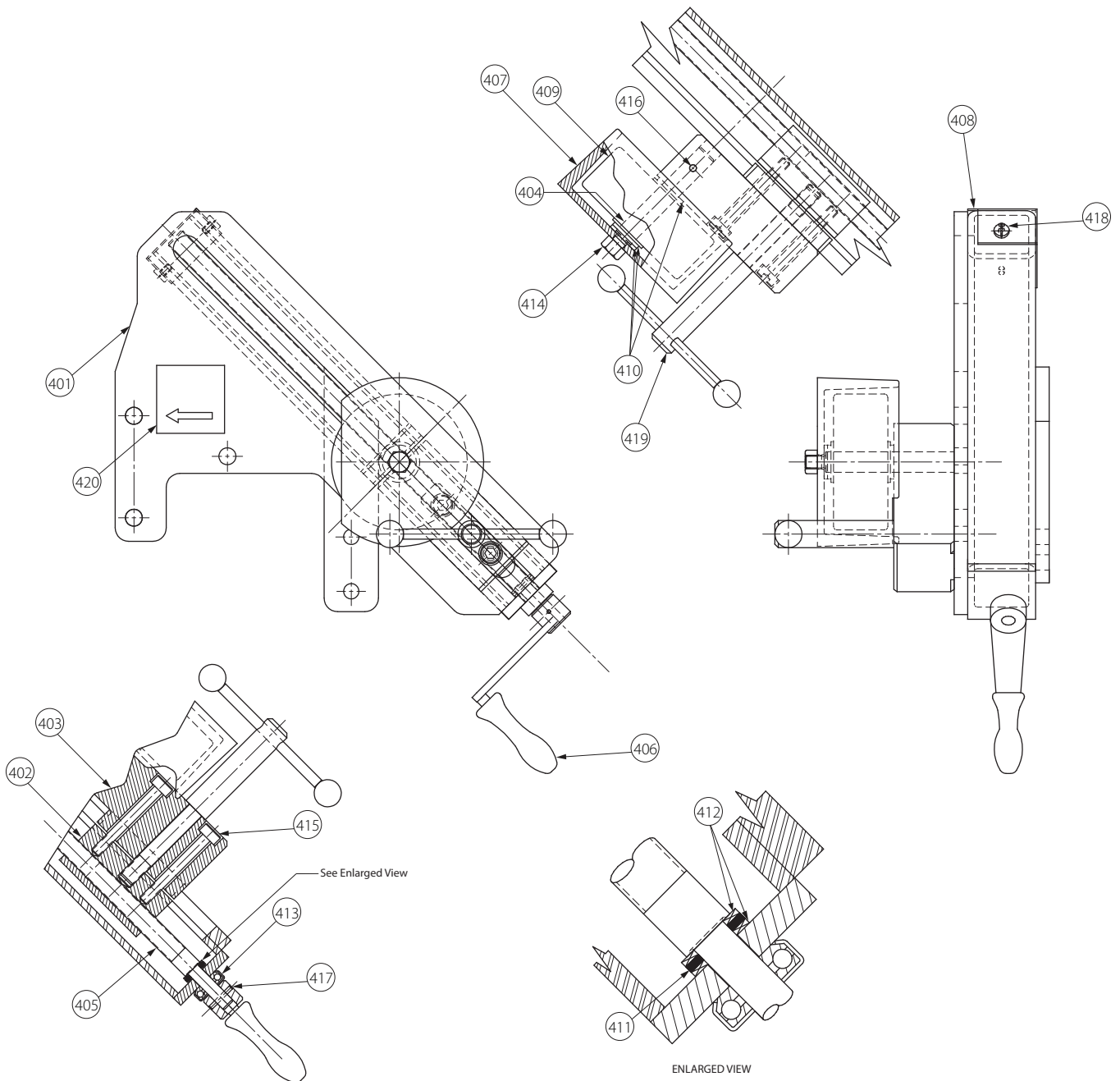
FOOTSWITCH

PLUG



Item#	Part #	Qty.	Description
301	R-301-450-MCH	1	Main Enclosure
302	R-302-450-MCH	1	Enclosure Panel
307	N-E03-000-003	1	Foot Switch
309	N-E15-000-003	1	Circuit Breaker
313	N-E19-000-005	1	Plug, Grounding Lock

VE450FSD Roll Grooving Tool



Item#	Part #	Qty.	Description
401	R-401-450-PNT	1	Stabilizer Body
402	R-402-424-PLT	1	Stabilizer Guide Nut
403	R-403-424-PLT	1	Stabilizer Guide
404	R-404-424-MAC	1	Stabilizer Roller Shaft
405	R-405-450-MCH	1	Stabilizer Adjusting Screw
406	R-406-450-MCH	1	Stabilizer Crank Handle
407	R-407-450-PNT	1	Stabilizer Roller Guard
408	R-408-424-PNT	1	Stabilizer Tube Cap
409	N-M05-000-002	1	Wheel, Polyurethane Tread, 5 x 2 x 3/4"
410	N-B05-075-004	3	Thrust Washer

Item#	Part #	Qty.	Description
411	N-B03-050-001	1	Thrust Bearing
412	N-B05-050-003	2	Thrust Washer
413	N-B03-050-002	1	Thrust Bearing
414	N-N02-080-000	1	Hex Nut, 1/2 - 20 UNF, Std., Pltd.
415	N-S03-080-208	2	Sock. Hd. Shoulder Screw, ø.50 x 2.50 Lg., Blk. Ox.
416	N-P01-004-208	1	Roll Pin ø.25 x 2.50 Lg., Steel
417	N-P01-002-102	1	Roll Pin ø.125 x 1.125 Lg., Steel
418	N-S06-040-006	2	Pan Hd. Phillips Screw, 1/4 - 20 UNC x .38 Lg., Pltd.
419	R-419-424-PLT	1	Stabilizer Locking Handle
420	R-420-450-LBL	1	Stabilizer Mounting Bolt Instruction Label

VE450FSD

Roll Grooving Tool

STANDARD GROOVING ROLL INFORMATION

The following information identifies grooving rolls that are shipped standard with the VE450FSD Roll Grooving Tool. Refer to the VE450FSD Roll Grooving Tool Operating and Maintenance Instructions Manual for complete information regarding tool capacities (i.e. minimum and maximum pipe wall thicknesses, etc.).

Original Groove System Rolls for Steel and Schedule 40 Stainless Steel Pipe - Color-Coded Black

Pipe Size		Original-Type
Nominal Size inches	Actual Outside Diameter inches/mm	Roll Part Numbers
4	4.500 114.3	Lower Roll R904436L06 Upper Roll R9Q1448A06 Roll Set R9Q1448006
4½	5.000 127.0	
5	5.563 141.3	
6	6.625 168.3	
8	8.625 219.1	Lower Roll R908436L12 Upper Roll R9Q1448A12 Roll Set R9Q1448012
10	10.750 273.0	
12	12.750 323.9	

RW Rolls for Grooving Steel Pipe to AGS Specifications - Color-Coded Black with Yellow Band

Pipe Size		RW
Nominal Size inches	Actual Outside Diameter inches/mm	Roll Part Numbers
14 OD	14.000 355.6	Lower Roll RW01436L24 Upper Roll RWQ2448A24 Roll Set RWQ2448024
16 OD	16.000 406.4	
18 OD	18.000 457.0	
20 OD	20.000 508.0	
24 OD	24.000 610.0	

VE450FSD Roll Grooving Tool

OPTIONAL GROOVING ROLL INFORMATION

The following information identifies grooving rolls that are optional for the VE450FSD Roll Grooving Tool. These grooving rolls can be ordered by contacting your nearest Victaulic Sales Office listed on the last page. Refer to the VE450FSD Roll Grooving Tool Operating and Maintenance Instructions Manual for complete information regarding tool capacities (i.e. minimum and maximum pipe wall thicknesses, etc.).

Original Groove System Rolls for Steel and Schedule 40 Stainless Steel Pipe - Color-Coded Black

Pipe Size		Original-Type
Nominal Size inches	Actual Outside Diameter inches/mm	Roll Part Numbers
14 OD	14.000 355.6	Lower Roll R914436L16 Upper Roll R9Q1448A16 Roll Set R9Q1448016
16 OD	16.000 406.4	Lower Roll R918436L20 Upper Roll R9Q1448A20 Roll Set R9Q1448020
18 OD	18.000 457.0	Lower Roll R922436L24 Upper Roll R9Q1448A24 Roll Set R9Q1448024
20 OD	20.000 508.0	Lower Roll R908436L12 Upper Roll RXQ1448A12 Roll Set RXQ1448012
22 OD	22.000 559.0	Lower Roll RX04436L06 Upper Roll RXQ1448A06 Roll Set RXQ1448006
24 OD	24.000 610.0	Lower Roll RWQX448L18 Upper Roll RWQX448A24 Roll Set RWQX448018

EndSeal® "ES" Rolls for Steel and Schedule 40 Stainless Steel Pipe - Color-Coded Black

Pipe Size		"ES"
Nominal Size inches	Actual Outside Diameter inches/mm	Roll Part Numbers
4	4.500 114.3	Lower Roll RZQ1448L06 Upper Roll RZQ1448A06 Roll Set RZQ1448006
4½	5.000 127.0	Lower Roll RX08436L12 Upper Roll RXQ1448A12 Roll Set RXQ1448012
5	5.563 141.3	Lower Roll RX04436L06 Upper Roll RXQ1448A06 Roll Set RXQ1448006
6	6.625 168.3	Lower Roll RX08436L12 Upper Roll RXQ1448A12 Roll Set RXQ1448012
8	8.625 219.1	Lower Roll RX18436L20 Upper Roll RXQ1448A20 Roll Set RXQ1448020
10	10.750 273.0	Lower Roll RWQX448L18 Upper Roll RWQX448A24 Roll Set RWQX448018
12	12.750 323.9	Lower Roll RWQX448L24 Upper Roll RWQX448A24 Roll Set RWQX448024

RWX Rolls for Grooving Schedule 5S and 10S Stainless Steel Pipe to AGS Specifications - Color-Coded Silver with Black Band

Pipe Size		RWX
Nominal Size inches	Actual Outside Diameter inches/mm	Roll Part Numbers
14 OD	14.000 355.6	Lower Roll RWQX448L18 Upper Roll RWQX448A24 Roll Set RWQX448018
16 OD	16.000 406.4	Lower Roll RWQX448L24 Upper Roll RWQX448A24 Roll Set RWQX448024
18 OD	18.000 457.0	Lower Roll RWQX448L18 Upper Roll RWQX448A24 Roll Set RWQX448018
20 OD	20.000 508.0	Lower Roll RWQX448L24 Upper Roll RWQX448A24 Roll Set RWQX448024
24 OD	24.000 610.0	Lower Roll RWQX448L18 Upper Roll RWQX448A24 Roll Set RWQX448018

Original Groove System RP Rolls for Aluminum and PVC Plastic Pipe - Color-Coded Yellow Zinc

Pipe Size		RP
Nominal Size inches	Actual Outside Diameter inches/mm	Roll Part Numbers
4	4.500 114.3	Lower Roll RPQ1448L06 Upper Roll RPQ1448A06 Roll Set RPQ1448006
4½	5.000 127.0	Lower Roll RPQ1448L12 Upper Roll RPQ1448A12 Roll Set RPQ1448012
5	5.563 141.3	Lower Roll RX04436L06 Upper Roll RXQ1448A06 Roll Set RXQ1448006
6	6.625 168.3	Lower Roll RX08436L12 Upper Roll RXQ1448A12 Roll Set RXQ1448012
8	8.625 219.1	Lower Roll RX18436L20 Upper Roll RXQ1448A20 Roll Set RXQ1448020
10	10.750 273.0	Lower Roll RWQX448L18 Upper Roll RWQX448A24 Roll Set RWQX448018
12	12.750 323.9	Lower Roll RWQX448L24 Upper Roll RWQX448A24 Roll Set RWQX448024

Original Groove System RX Rolls for Schedule 5S and 10S Stainless Steel Pipe - Color-Coded Silver

Pipe Size		RX
Nominal Size inches	Actual Outside Diameter inches/mm	Roll Part Numbers
4	4.500 114.3	Lower Roll RX04436L06 Upper Roll RXQ1448A06 Roll Set RXQ1448006
5	5.563 141.3	Lower Roll RX08436L12 Upper Roll RXQ1448A12 Roll Set RXQ1448012
6	6.625 168.3	Lower Roll RX04436L06 Upper Roll RXQ1448A06 Roll Set RXQ1448006
8	8.625 219.1	Lower Roll RX08436L12 Upper Roll RXQ1448A12 Roll Set RXQ1448012
10	10.750 273.0	Lower Roll RX18436L20 Upper Roll RXQ1448A20 Roll Set RXQ1448020
12	12.750 323.9	Lower Roll RWQX448L18 Upper Roll RWQX448A24 Roll Set RWQX448018
14 OD	14.000 355.6	Lower Roll RWQX448L18 Upper Roll RWQX448A24 Roll Set RWQX448018
16 OD	16.000 406.4	Lower Roll RWQX448L24 Upper Roll RWQX448A24 Roll Set RWQX448024
18 OD	18.000 457.0	Lower Roll RWQX448L18 Upper Roll RWQX448A24 Roll Set RWQX448018
20 OD	20.000 508.0	Lower Roll RWQX448L24 Upper Roll RWQX448A24 Roll Set RWQX448024
22 OD	22.000 559.0	Lower Roll RWQX448L18 Upper Roll RWQX448A24 Roll Set RWQX448018
24 OD	24.000 610.0	Lower Roll RWQX448L24 Upper Roll RWQX448A24 Roll Set RWQX448024

VE450FSD

Roll Grooving Tool

For complete contact information, visit www.victaulic.com

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