

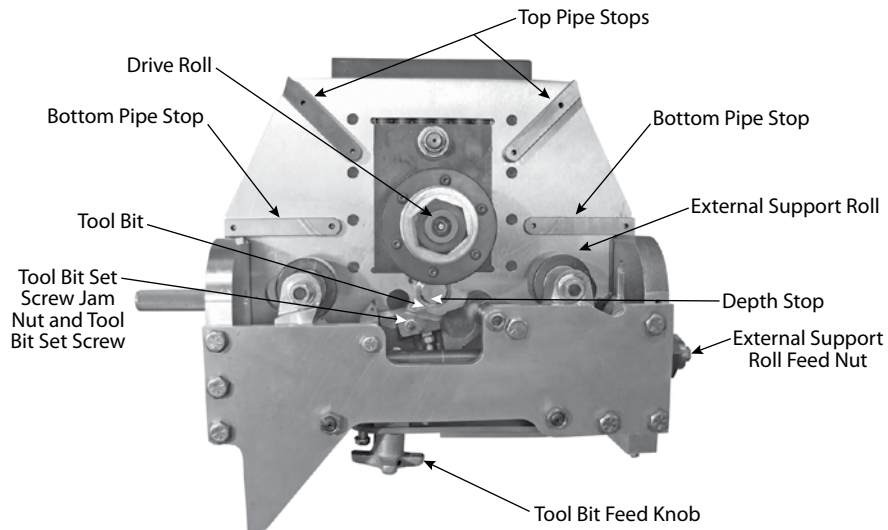
VG828 Tool for Cut Grooving to Advanced Groove System (AGS) Specifications

⚠ WARNING

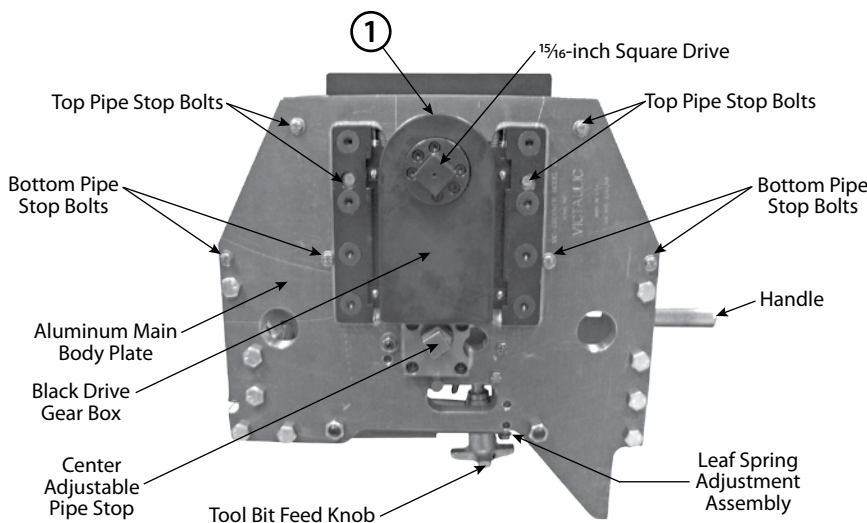


- Read and understand all instructions before attempting to operate, adjust, or maintain any Victaulic grooving tools.
 - Always disconnect the tool from the power source before attempting to perform maintenance on any components.
 - Wear safety glasses, hardhat, foot protection, and hearing protection when working with tools.
- Failure to follow these instructions could result in serious personal injury and product damage.

TOOL NOMENCLATURE



Cutting Side



Drive Side

1

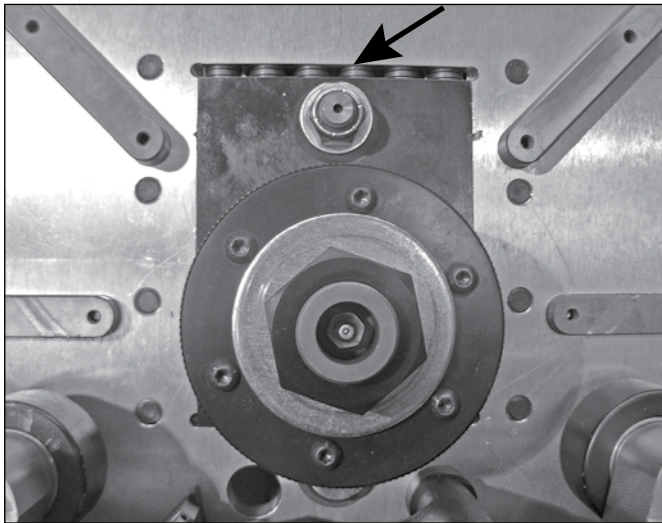
⚠ WARNING

- For cut grooving to Victaulic **AGS** specifications, the minimum pipe wall thickness requirement is "XS" (Extra Strong, 0.500 inch/12.7 mm).
 - The maximum pipe wall thickness capacity of this tool is 0.750 inch/19.1 mm.
- Failure to follow this instruction could cause joint separation, resulting in serious personal injury and/or property damage.

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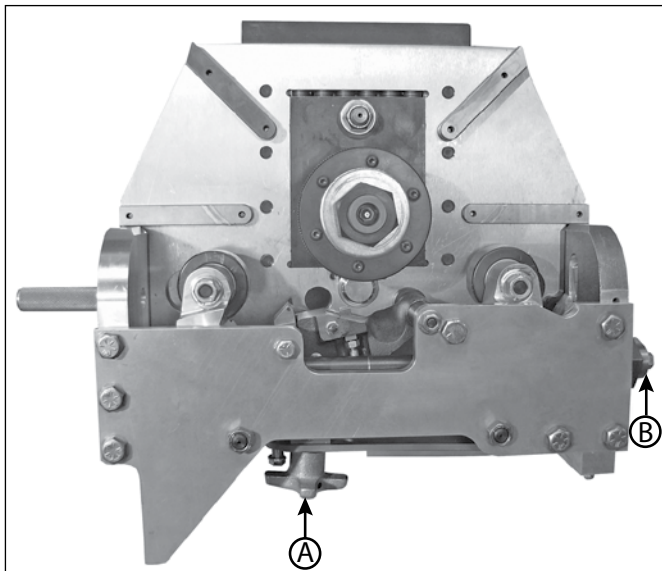
VG828 Tool for Cut Grooving to Advanced Groove System (AGS) Specifications

MOUNTING THE VG828 TOOL ONTO THE PIPE

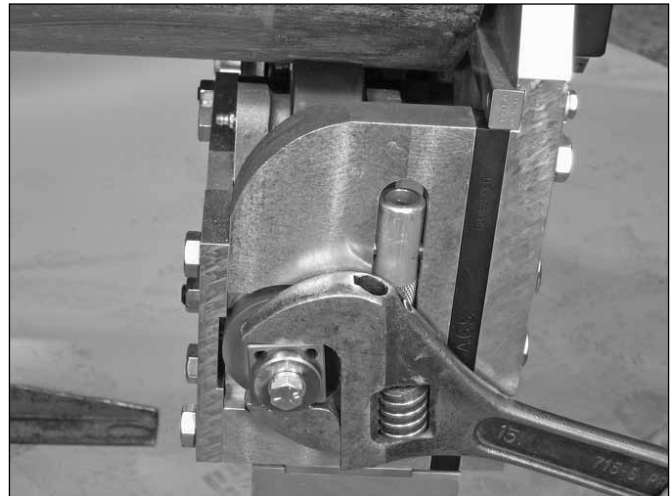


The VG828 Tool, shipped with this addendum, contains a spring-assisted drive gear box.

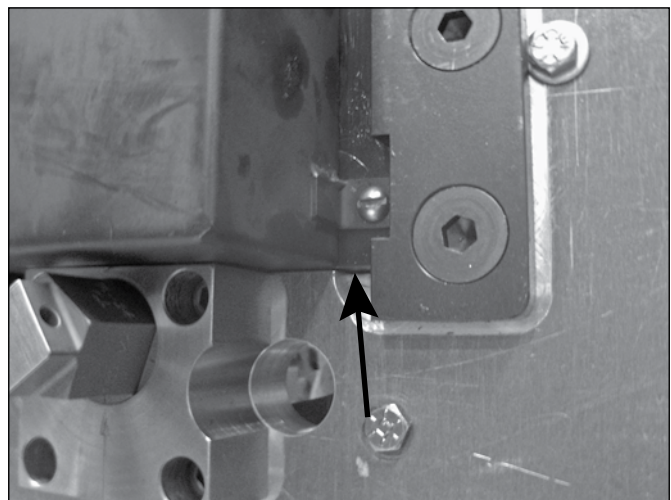
The following instructions replace the "Mounting the VG824 or VG828 Tool Onto the Pipe" section in the TM-VG824/VG828 Operating and Maintenance manual. Refer to the other sections of the TM-VG824/VG828 for complete setup, operation, and maintenance requirements.



1. Before mounting the tool onto the pipe, retract the tool bit feed knob (A) fully by turning counterclockwise. Retract the external support rolls fully by turning the external support roll feed nut (B) counterclockwise.



2. Lift the tool and mount it onto the pipe end. The tool bit feed knob should be facing downward, and the drive roll should be inside the pipe. Use caution to prevent the tool bit from hitting the pipe during mounting.
 - 2a. Hold the tool firmly against the pipe end, making sure the pipe stops are in complete contact with the pipe end. Using a 15-inch crescent wrench, tighten the external support roll feed nut by turning clockwise to bring the external support rolls into contact with the outside pipe surface.



- 2b. Load the external support rolls against the pipe by continuing to turn the external support roll feed nut clockwise until a 1/32 – 5/64-inch/1 – 2-mm gap is reached between the tool's aluminum main body plate and the black drive gear box (refer to photo above).

NOTICE

- **DO NOT over-tighten the external support rolls, since damage to the pipe and/or the tool may result.**
- **If the external support rolls are not tightened sufficiently, the tool may not "track" properly, resulting in improper grooves.**

For complete contact information, visit www.victaulic.com

TM-VG824/VG828.ADD 5949 REV A UPDATED 11/2009

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TM-VG824/VG828.ADD