



VE460
Fab Shop Roll Groover



VE12
Manual Roll Groover



CG1100
Cut Groover



VAPS1672
Pipe Stand

Grooved Piping System

A Victaulic grooved mechanical joint consists of a coupling and formed or machined grooved pipe ends using a grooving tool. The coupling housings, fully surrounding a gasket, are assembled around a grooved pipe end, valve or fitting, ensuring the coupling key sections are engaged into the grooves and the fasteners properly tightened. This results in a connection capable of withstanding pressure thrust loads and accommodating expansion, contraction and deflection, within the specified maximum rated operating pressure.

Job/Owner

System No.	
Location	

Contractor

Submitted By	
Date	

Roll Grooving

Roll grooving is a method for preparing pipe made of standard or lightwall carbon steel, stainless steel, aluminum, PVC, copper and other materials. Standard 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. In the event that a beveled cut pipe is used, the wall thickness must be standard or less, and the bevel must meet ASME/ANSI B16.25 (37½°) or ASTM A-53 (30°). Square cut pipe must be used with Flush-Seal™ and EndSeal™ gaskets.

Victaulic roll grooving tools are all designed to rotate the pipe or orbit the pipe as an upper grooving roll is pressed into the pipe. The lower roll provides support for the pipe as well as drives the pipe or tool from inside the pipe. Roll grooving removes no metal; the groove is cold formed into the pipe wall.

Cut Grooving

Victaulic cut grooving tools are designed to machine away material from the O.D. of the pipe, thus providing the specified groove. As the tool or pipe rotates, the cutter bit presses into the pipe removing material until a set groove depth has been reached. The design of the tool ensures a groove which is concentric with the pipe O.D., even with pipe that is slightly out-of-round. The average pipe outside diameter shall not vary from the specifications listed in the tables on the following pages. Maximum allowable pipe ovality should not vary by more than 1%. Greater variations between the major and minor diameters will result in difficult coupling assembly. 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 maximizes the key engagement of the coupling while also accommodating movement resulting from thermal expansion and contraction, deflection, building or ground settlement and seismic activity.

Engineer

Spec Section	
Paragraph	
Approved	
Date	

Table of Contents

Roll Grooving – Field Manual

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.

RG1 4
 VE12 4
 VE26 5
 VE46 6
 VE26/46 Power Drive Kit 6
 RG1200 Groove In-Place 7

Roll Grooving – Field Portable

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

VE106/107 8
 VE206 9
 VE226 10
 VE226 Power Drive Kit 10

Roll Grooving – Field Fabrication

These tools are designed for heavy duty repetitive field use.

Requires External Power Source

RG2100 11
 VE272SFS 12
 VE416FS 13

Power Drive Self-Contained with Tool

RG3212 14
 VE270FSD/VE271FSD 15
 VE416FSD/VE417FSD 16
 VE450FSD 17

Roll Grooving – Plant/Shop Fabrication

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

VE268 18
 RG3600 19
 VE414MC 20
 VE460 21
 50T 23
 RG5200i 24

Cut Grooving – Field Manual

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

VG *Vic-Groover* 25

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.

VG28GD 26
 VG28GD-ABR 26
 VDG26GD 26
 VG26GD-COR 27
 VG824 28
 VG824-ABR 28
 VG824DG 28
 VG824-COR 29
 VG828 29

Cut Grooving- Field Motorized

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

VG412 30

Plastic Groovers

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

CG3100/3300/3500 30
 CG1100 31
 VPG824 31

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.

APG 31

Hole Cutting Tools

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

HCT904 32
 HCT908 32
 VHCT900 32
Vic-Tap II 32

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 33

Pipe Cut-Off Tools

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

VCT1 34
 VCT2 34
 PC3110 34

Tool Accessories

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

Power Mule II Power Drive for Cut Grooving Tools 35
 VAPS112 Pipe Stand 36
 VAPS224 Pipe Stand 36
 VAPS270 Pipe Stand 37
 VAPS1672 Pipe Stand 37
 PT100A/PT101/PT101A Pipe Tape 38
 PT102A Pipe Tape 38
 GDC-CTS/GDC-EC/GDC-AC 39
 GDC-StrengThin™ 100 39
 GDC-PGS-300 39
 OGS-200 Groove Confirmation Gauges 39
 HDPE Double Cut Groove Confirmation Gauge 39
 IGS Groove Confirmation Gauge 40
 No.T-60 Test Cap Kit 40

Fabrication Cell

These tool accessories are part of a turn-key fab shop package to maximize productivity gains.

VAP131 Fabrication Cell Package 41
 VAPS 131R Hydraulic Adjustable Pipe Stand 41
 VAPS 131F Hydraulic Positioner 41
 VAPS 131T Assembly Table 41

VBSP Closure Tools

These tools are specifically designed for use with installing Victaulic Bolted Split Sleeve Products (VBSP).

CTM-01 Small Manual 42
 CTM-02 Large Manual 42
 CTH-01 Small Hydraulic 42
 CTH-02 Large Hydraulic 42

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 matched 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. Read the full instructions for each tool before use.

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" DN20 – DN200	Pipe Sizes 10 – 12" DN250 – DN300	Pipe Sizes 14 – 24" DN350 – DN600	Pipe Sizes 26 – 78" DN650 – DN1950
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)	
Light Wall Stainless Steel	1.6 – 3 mm	RG (StrengThin™ 100 Rolls)	RG (StrengThin™ 100 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 Super Duplex stainless steels, contact Victaulic for more information.

NOTE:

- StrengThin™ 100 rolls are only available in Europe.

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 Stripe	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 Stripe	Stainless Steel (Standard Wall Only)	RW
	Silver	Stainless Steel (Light Wall Only)	RWX
StrengThin™ 100	Blue Stripe	Stainless Steel (Light Wall Only)	RG
ES	Black	Carbon Steel	RZ
Copper	Copper	Copper	RR
PVC/Aluminum	Gold	PVC/Aluminum	RP
OGS-200	Red Stripe	Carbon Steel	R9S
		Stainless Steel	RXS

Roll Grooving – Field Manual



RG1

RG1 In-Place Grooving Tool

- Tool is manually operated using the handle supplied
- For manual grooving of Schedule 10 and 40 carbon steel pipe
- 1" IGS Groove System profile
- Roll grooves 1"/DN25 pipe

Power Requirements: None

Weight: 17 lbs/8 kg

Tool Ratings — Maximum Pipe Size and Wall Thickness Capacity		Pipe Size (in mm)
Model	Pipe Material	1 25
RG1	Steel	Sch. 10 and 40 2.8 and 3.4 mm



VE12

VE12 Groove In-Place

- Tool is manually operated using the handle supplied
- For manual grooving of Schedule 5, 10 and 40 steel; stainless steel; aluminum and PVC pipe
- Enhanced tracking rolls allow bi-directional grooving and helps to hold the tool on the pipe end during the roll grooving process
- Roll grooves ¾ – 2"/DN20 – DN50 pipe

Power Requirements: None

Weight: 17 lbs./8 kg

Tool Ratings — Maximum Pipe Size and Wall Thickness Capacity			Pipe Size (in mm)				
Model	Pipe Material	Notes	¾ 20	1 25	1¼ 32	1½ 40	2 50
VE12	Steel		Sch. 5 – 10 1.7 – 2.1 mm		Sch. 5 – 40 1.7 – 3.9 mm		
	Stainless				Sch. 40S 3.4 – 3.9 mm		
	Aluminum	2	Sch. 5 – 10 1.7 – 2.1 mm		Sch. 5 – 40 1.7 – 3.9 mm		
	PVC Plastic				Sch. 40 3.4 – 3.9 mm		
VE12SS	Lt. Wall SS			Sch. 5S – 10S 1.7 – 2.8 mm			

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

Roll Grooving – Field Manual



VE26

VE26 Groove In-Place

- Tool is manually operated using the handle supplied
- Repair and retrofit existing lightwall steel, Schedule 40 steel, stainless steel, PVC, and aluminum
- Enhanced tracking rolls allow bi-directional grooving and helps to hold the tool on the pipe end during the roll grooving process
- 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
- Roll grooves 2 – 6"/DN50 – DN150 pipe

Power Requirements: None

Weight: 22 lbs./10 kg

Tool Ratings — Maximum Pipe Size and Wall Thickness Capacity			Pipe Size (in mm)					
			2 50	2½	3 80	4 100	5	6 150
VE26S	Steel		Sch. 5–40 1.7 – 5.5 mm			Sch. 5–10 2.1 – 3.4 mm		
	Stainless		Sch. 40S Only 3.9 – 5.5 mm					
VE26C	Copper		K, L, M and DWV					
VE26AC	Australian Copper	3	A, B and D					
VE26P	Aluminum	2	Sch. 5–40 1.7 – 5.2 mm		Sch. 5–10 2.1 – 3.4 mm			
	PVC Plastic		Sch. 40 3.9 – 6.6 mm					
VE26SS	Lt. Wall SS		Sch. 5S–10S 1.7 – 3.4 mm					

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

³ See [publication 22.10](#) and [publication 22.11](#) for more details.

* Ridgid™ is a trademark of Ridgid, Inc. Victaulic is not associated with Ridgid, Inc.

Certifications/Listings:

- Compliant with the Essential Safety Requirements of 2006/42/EC – EU Machinery Directive

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 as an alternative to groove pipe using a Ridgid* 300 power drive
- Roll grooves 3½ – 6"/DN90 – DN150 pipe

Power Requirements: None

Weight: 28 lbs./13 kg

Tool Ratings — Maximum Pipe Size and Wall Thickness Capacity			Pipe Size (in mm)				
Model	Pipe Material	Notes	3½ 90	4 100	4½	5	6 150
VE46S	Steel		Sch. 5 – 40 2.1 – 7.1 mm				
	Stainless		Sch. 40S Only 5.7 – 7.1 mm				
VE46P	Aluminum	2	Sch. 5 – 40 2.1 – 7.1 mm				
	PVC Plastic		Sch. 40 – 80 5.7 – 11.0 mm				

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

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VE26/46 Power Drive Kit

The VE26/46 power drive kit is available to allow both tools to be directly mounted to a 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.

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Certifications/Listings:

- Compliant with the Essential Safety Requirements of 2006/42/EC – EU Machinery Directive

Roll Grooving – Field Manual



RG1200

RG1200 Groove In-Place

- Manual or power driven in-place grooving tool
- Designed to provide an OGS-200 roll groove in Schedules 40 and 80 carbon steel pipe
- Roll grooves 2 – 6"/DN50 – DN150 pipe

Power Requirements: None

Weight: 27.7 lbs./12.7 kg

Tool Ratings — Maximum Pipe Size and Wall Thickness Capacity		Pipe Size (in mm)				
		2 50	2½	3 80	4 100	6 150
RG1200	Carbon Steel	Sch. 40–80 3.9 – 7.6 mm			Sch. 40 6.0 – 7.1 mm	

NOTE

- Power drive optional.

Certifications/Listings:

- Compliant with the Essential Safety Requirements of 2006/42/EC – EU Machinery Directive
- See [publication 24.11](#) for details.

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 allow bi-directional grooving and helps to hold the tool on the pipe end 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 ¼ – 6"/DN32 – DN150 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 and Wall Thickness Capacity			Pipe Size (in mm)							
			1¼ 32	1½ 40	2 50	2½	3 80	3½ 90	4 100	5
Model	Pipe Material	Notes								
VE106	Steel	4, 5	Sch. 5 – 40 1.7 – 7.1 mm							
	Stainless	4	Sch. 40S 3.6 – 7.1 mm							
	Lt. Wall SS	6	Sch. 5S – 10S 1.7 – 3.4 mm							
	Copper	7	K, L, M and DWV							

⁴ Use standard grooving rolls marked with the prefix R.

⁵ EndSeal™ grooving rolls marked with the prefix RZ are available. Contact Victaulic® for details.

⁶ Use grooving rolls marked with the prefix RX.

⁷ Use grooving rolls marked with the prefix RR.

Certifications/Listings:

- Compliant with the Essential Safety Requirements of 2006/42/EC – EU Machinery Directive

Roll Grooving – Field Portable



VE206

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"/DN32 – DN150 pipe

Power Requirements: Compatible with multiple power drive units; Ridgid* 300 or 700 and REMS Amigo 2**

Weight:

Tool (assembled; including power drive, hand pump, stand assembly, & foot switch): 165 lbs./75 kg

Tool Head Assembly: 61 lbs./28 kg

Tool Ratings — Maximum Pipe Size and Wall Thickness Capacity			Pipe Size (in mm)								
Model	Pipe Material	Notes	1¼ 32	1½ 40	2 50	2½	3 80	3½ 90	4 100	5	6 150
VE206	Steel	4, 5	Sch. 5–40 1.7 – 7.1 mm								
	Stainless	4	Sch. 40S 3.6 – 7.1 mm								
	Lt. Wall SS	6	Sch. 5S–10S 1.7 – 3.4 mm								
	Copper	7	K, L, M and DWV								

* Ridgid™ is a trademark of Ridgid, Inc. Victaulic is not associated with Ridgid, Inc.

** REMS Amigo is a registered trademark of REMS GmbH & Co KG.

⁴ Use standard grooving rolls marked with the prefix R.

⁵ EndSeal™ grooving rolls marked with the prefix RZ are available. Contact Victaulic® for details.

⁶ Use grooving rolls marked with the prefix RX.

⁷ Use grooving rolls marked with the prefix RR.

Certifications/Listings:

- Compliant with the Essential Safety Requirements of 2006/42/EC – EU Machinery Directive

Roll Grooving – Field Portable



VE226

VE226 Portable Groover

- Mounts to a 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"/DN20 – DN150 pipe

Drive Requirements: Fits 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 and Wall Thickness Capacity			Pipe Size (in mm)											
			3/4 20	1 25	1 1/4 32	1 1/2 40	2 50	2 1/2	3 80	3 1/2 90	4 100	4 1/2	5	6 150
VE226S	Steel		Sch. 5 – 40 1.7 – 5.2 mm				Sch. 5 – 10 2.1 – 3.4 mm							
	Stainless		Sch. 40S Only 3.6 – 5.2 mm											
VE226B	Steel		Sch. 5 – 40 1.7 – 3.7 mm											
	Stainless		Sch. 40S Only 2.9 – 3.7 mm											
	Aluminum	2	Sch. 5 – 40 1.7 – 3.7 mm											
	PVC Plastic		Sch. 40 2.9 – 3.7 mm											
VE226M	Steel						Sch. 5 – 40 1.7 – 6.0 mm				Sch. 5 – 10 2.5 – 3.4 mm			
	Stainless						Sch. 40S Only 3.9 – 6.0 mm							
VE226C	Copper		K, L, M and DWV											
VE226AC	Australian Copper	3	A, B, and D											
VE226BSS	Lt. Wall SS		Sch. 5S – 10S 1.7 – 2.8 mm											
VE226MSS	Lt. Wall SS						Sch. 5S – 10S 1.7 – 3.4 mm							
VE226P	Aluminum	2					Sch. 5 – 40 1.7 – 6.0 mm				Sch. 5 – 10 2.5 – 3.4 mm			
	PVC Plastic						Sch. 40 3.6 – 7.1 mm							

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

³ See publication 22.10 and publication 22.11 for more details.

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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

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Certifications/Listings:

- Compliant with the Essential Safety Requirements of 2006/42/EC – EU Machinery Directive

Roll Grooving – Field Fabrication



RG2100

RG2100

- Light-weight portable roll grooving tool
- Cuts, reams and grooves an IGS groove into the pipe
- The RG2100 is available in two configurations. One includes the cutter, reamer, lever, groover and carriage. The other is the groover and carriage only.
- Roll grooves 1"/DN25 pipe

Drive Requirements: Ridgid* 300 Power Drive

Power Requirements: 115 volt, 15 amp power connection

Weight: 37.5 lbs/17 kg

Tool Ratings — Maximum Pipe Size and Wall Thickness Capacity		Pipe Size (in mm)
Model	Pipe Material	1 25
RG2100	Steel	Sch. 10 and 40 2.8 and 3.4 mm

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Certifications/Listings:

- Compliant with the Essential Safety Requirements of 2006/42/EC – EU Machinery Directive

Roll Grooving – Field Fabrication



VE272SFS

VE272SFS

- Portable roll groover mounts to the Ridgid* 300 power drive
- Hydraulic hand pump operation with a pivot arm designed to reduce handle effort required
- Enhanced tracking rolls allow bi-directional grooving and helps to hold the tool on the pipe end during the roll grooving process
- Roll grooves ¾ – 12"/DN20 – DN300 pipe (Supplied with 2 – 12"/DN50 – DN300 carbon steel roll sets)

Power Requirements: Ridgid* 300 power drive

Weight: 184 lbs./84 kg

Optional Rolls: ¾ – 1 ½"/DN20 – DN40 carbon and stainless steel rolls, light wall stainless steel rolls ¾ – 12"/DN20 – DN300, 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"/DN200 – DN300 pipe is available and is required for copper.

Tool Ratings — Maximum Pipe Size and Wall Thickness Capacity			Pipe Size (in mm)													
			¾ 20	1 25	1¼ 32	1½ 40	2 50	2½	3 80	3½ 90	4 100	5 150	6 200	8 250	10 300	12 300
VE272SFS	Steel (OGS)	4, 5	Sch. 5 – 40 1.7 – 8.2 mm											Sch. 5 – 20 3.4 – 6.4 mm		
	Steel (OGS-200)	11					Sch. 40 – 80 3.9 – 7.6 mm		Sch. 40 6.0 – 7.1 mm							
	Stainless	4	Sch. 40S 2.9 – 8.2 mm											.250 6.4 mm		
	Stainless (OGS-200)						Sch. 40S 3.9 – 7.1 mm									
	Lt. Wall SS	6, 9	Sch. 5S – 10S 1.7 – 4.6 mm													
	Aluminum	2, 8					Sch. 5 – 40 1.7 – 8.2 mm						Sch. 5 – 20 3.4 – 6.4 mm			
	PVC Plastic	8, 10					Sch. 40 3.9 mm		Sch. 40 – 80 5.2 – 11.0 mm				Sch. 40 8.2 mm			
	Copper	7, 9	K, L, M and DWV													

- * Ridgid™ is a trademark of Ridgid, Inc. Victaulic is not associated with Ridgid, Inc.
- 2 6061-T4 or 6063-T4 Alloy must be used.
- 4 Use standard grooving rolls marked with the prefix R.
- 5 EndSeal™ grooving rolls marked with the prefix RZ are available. Contact Victaulic® for details.
- 6 Use grooving rolls marked with the prefix RX.
- 7 Use grooving rolls marked with the prefix RR.
- 8 Use grooving rolls marked with the prefix RP.
- 9 Use sway brace for 8"/DN200 copper and 8 – 12"/DN200 – DN300 lightwall stainless steel.
- 10 A special lower roll exclusively for grooving 2" Sch. 80 PVC is available. Part. No. RP02272L02
- 11 OGS-200 for use with Style 870 Rigid Coupling

Certifications/Listings:

- Compliant with the Essential Safety Requirements of 2006/42/EC – EU Machinery Directive

Roll Grooving – Field Fabrication



VE416FS

VE416FS

- For field roll grooving of 2 – 16"/DN50 – DN400
- Hydraulic hand pump operation with a pivot arm designed to reduce handle effort required
- Equipped with a pipe stabilizer for 6 – 16"/DN50 – DN400 pipe sizes to control pipe sway

Power Requirements: 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 and Wall Thickness Capacity			Pipe Size (in mm)											
			OGS								AGS			
Model	Pipe Material	Notes	2 50	2½ 80	3 80	4 100	5 150	6 200	8 200	10 250	12 300	14 350	16 400	
VE416FS	Steel	4, 5, 9	Sch. 5 – 80 1.7 – 7.6 mm				Sch. 5 – 40 2.1 – 9.3 mm				Sch. 10 – STD 4.6 – 9.5 mm	STD Wall AGS 9.5 mm		
	Stainless	5	Sch. 40S 3.9 – 9.3 mm								STD 9.5 mm	STD Wall RW AGS 9.5 mm		
	Lt. Wall SS	6	Sch. 5S – 10S 1.7 – 4.6 mm										10S RWX 4.8 mm	
	Aluminum	2, 8	Sch. 5 – 40 1.7 – 9.3 mm						Sch. 5 – STD 4.0 – 9.5 mm					
	PVC Plastic	8	Sch. 40 3.9 mm	Sch. 40 – 80 5.2 – 11.0 mm				Sch. 40 8.2 mm						
	Copper	7	K, L, M and DWV											

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- 2 6061-T4 or 6063-T4 Alloy must be used.
- 4 Use standard grooving rolls marked with the prefix R.
- 5 EndSeal™ grooving rolls marked with the prefix RZ are available. Contact Victaulic® for details.
- 6 Use grooving rolls marked with the prefix RX.
- 7 Use grooving rolls marked with the prefix RR.
- 8 Use grooving rolls marked with the prefix RP.
- 9 A special roll set exclusively for grooving 2-3" Sch. 80 carbon steel is available. Part. No. RS02414003

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.

Certifications/Listings:

- Compliant with the Essential Safety Requirements of 2006/42/EC – EU Machinery Directive

Roll Grooving – Field Fabrication



RG3212

RG3212

- Self-contained unit with integral gear motor, safety guards, safety foot switch, pipe stand and power cord/plug
- Hydraulic hand pump operation
- Anti-flare technology to minimize pipe end flare
- Roll grooves 2 – 12"/DN50 – DN300 carbon and stainless steel pipe

Drive Requirements: Self-contained

Power Requirements: 120V, 15KW, 60Hz, Single Phase

NOTE

- For tool rating capacity reference submittal [publication 24.19](#)

Certifications/Listings:

- Compliant with the Essential Safety Requirements of 2006/42/EC – EU Machinery Directive

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 pivot arm designed to reduce handle effort required
- Enhanced tracking rolls allow bi-directional grooving and helps to hold the tool on the pipe end during the roll grooving process
- Roll grooves ¾ – 12"/DN20 – DN300 pipe
(Supplied with 2 – 12"/DN50 – DN300 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: ¾ – 1 ½"/DN20 – DN40 carbon and stainless steel rolls, light wall stainless steel rolls ¾ – 12"/DN20 – DN40, 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"/DN200 – DN300 pipe is available and is required for copper.

Tool Ratings — Maximum Pipe Size and Wall Thickness Capacity			Pipe Size (in mm)														
Model	Pipe Material	Notes	¾ 20	1 25	1¼ 32	1½ 40	2 50	2½ 80	3 90	3½ 100	4 150	5 200	6 250	8 300	10 250	12 300	
VE270FSD/ VE271FSD	Steel (OGS)	4, 5	Sch. 5 – 40 1.7 – 8.2 mm											Sch. 5 – 20 3.4 – 6.4 mm			
	Steel (OGS-200)	11					Sch. 40 – 80 3.9 – 7.6 mm			Sch. 40 6.0 – 7.1 mm							
	Stainless	4	Sch. 40S 2.9 – 8.2 mm											.250 6.4 mm			
	Stainless (OGS-200)						Sch. 40S 3.9 – 7.1 mm										
	Lt. Wall SS	6, 9	Sch. 5S – 10S 1.7 – 4.6 mm														
	Aluminum	2					Sch. 5 – 40 1.7 – 8.2 mm								Sch. 5 – 20 3.4 – 6.4 mm		
	PVC Plastic	8, 10					Sch. 40 3.9 mm	Sch. 40 – 80 5.2 – 11.0 mm				Sch. 40 8.2 mm					
	Copper	7, 9	K, L, M and DWV														

- ² 6061-T4 or 6063-T4 Alloy must be used.
- ⁴ Use standard grooving rolls marked with the prefix R.
- ⁵ EndSeal™ grooving rolls marked with the prefix RZ are available. Contact Victaulic® for details.
- ⁶ Use grooving rolls marked with the prefix RX.
- ⁷ Use grooving rolls marked with the prefix RR.
- ⁸ Use grooving rolls marked with the prefix RP.
- ⁹ Use sway brace for 8"/DN200 copper and 8 – 12"/DN200 – DN300 lightwall stainless steel.
- ¹⁰ A special lower roll exclusively for grooving 2" Sch. 80 PVC is available. Part. No. RP02272L02
- ¹¹ OGS-200 for use with Style 870 Rigid Coupling

Certifications/Listings:

- Compliant with the Essential Safety Requirements of 2006/42/EC – EU Machinery Directive

Roll Grooving – Field Fabrication



VE416FSD/VE417FSD

VE416FSD/VE417FSD

- For field roll grooving of 2 – 16"/DN50 – DN400
- Groove depth adjuster allows for 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 pivot arm designed to reduce handle effort required
- Equipped with a pipe stabilizer for 6 – 16"/DN150 – DN400 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 and Wall Thickness Capacity			Pipe Size (in mm)										
			OGS										AGS
Model	Pipe Material	Notes	2 50	2½	3 80	4 100	5	6 150	8 200	10 250	12 300	14 350	16 400
VE416FSD/ VE417FSD	Steel (OGS)	4, 5	Sch. 5 – 80 1.7 – 7.6 mm				Sch. 5 – 40 2.1 – 9.3 mm				Sch. 10 – STD 4.6 – 9.5 mm	STD Wall AGS 9.5 mm	
	Steel (OGS-200)	11					Sch. 80 8.6 – 11.0 mm						
	Stainless	4	Sch. 40S 3.9 – 9.3 mm						STD 9.5 mm		STD Wall RW AGS 9.5 mm		
	Stainless (OGS-200)						Sch. 40S 6.0 – 7.1 mm						
	Lt. Wall SS	6	Sch. 5S – 10S 1.7 – 4.6 mm								Sch. 10S RWX 4.8 mm		
	Aluminum	2, 8	Sch. 5 – 40 1.7 – 9.3 mm						Sch. 5 – STD 4.0 – 9.5 mm				
	PVC Plastic	8	Sch. 40 3.9 mm	Sch. 40 – 80 5.2 – 11.0 mm				Sch. 40 8.2 mm					
	Copper	7	K, L, M and DWV										

- ² 6061-T4 or 6063-T4 Alloy must be used.
- ⁴ Use standard grooving rolls marked with the prefix R.
- ⁵ EndSeal™ grooving rolls marked with the prefix RZ are available. Contact Victaulic® for details.
- ⁶ Use grooving rolls marked with the prefix RX.
- ⁷ Use grooving rolls marked with the prefix RR.
- ⁸ Use grooving rolls marked with the prefix RP.
- ¹¹ OGS-200 for use with Style 870 Rigid Coupling

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.

Certifications/Listings:

- Compliant with the Essential Safety Requirements of 2006/42/EC – EU Machinery Directive

Roll Grooving – Field Fabrication



VE450FSD

VE450FSD

- Designed for field roll grooving of 4 – 24"/DN100 – DN600 pipe
- Tool is supplied with carbon steel roll sets for grooving 4 – 12"/DN100 – DN300 original groove and 14 – 24"/DN350 – DN600 AGS groove on carbon steel pipe
- Enhanced tracking rolls allow bi-directional grooving and helps to hold the tool on the pipe end during the roll grooving process
- Hydraulic hand pump operation with a pivot arm designed to reduce handle effort required
- Features:
 - Lifting point to move the tool with lifting equipment
 - Frame can accept most fork lifts
 - Onboard 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/DN100 – DN400 EndSeal™ (ES) groove.

Tool Ratings — Maximum Pipe Size and Wall Thickness Capacity			Pipe Size (in mm)													
			OGS									AGS				
			4 100	5	6 150	8 200	10 250	12 300	14 350	16 400	18 450	14 350	16 400	18 450	20 500	22 550
Model	Pipe Material	Notes														
VE450FSD	Steel	5, 12	Sch. 5–40 2.1 – 9.3 mm			Sch. 5–STD 4.0 – 9.5 mm						Sch. 5–STD 4.0 – 9.5 mm				
	Stainless	13	Sch. 40S 6.0 – 9.3 mm			STD 9.5 mm						STD 9.5 mm				
	Lt. Wall SS	14	Sch. 5S–10S 2.1 – 4.6 mm									Sch. 10S 4.8 – 6.4 mm				
	Aluminum	2, 8	Sch. 5–40 2.1 – 9.3 mm			STD 9.5 mm										
	PVC Plastic	8	Sch. 40 – 80 6.0 – 11.0 mm		Sch. 40 8.2 mm											

² 6061-T4 or 6063-T4 Alloy must be used.
⁵ EndSeal™ grooving rolls marked with the prefix RZ are available. Contact Victaulic® for details.
⁸ Use grooving rolls marked with the prefix RP.
¹² Use standard grooving rolls marked with the prefix R for both OGS and AGS.
¹³ Use standard grooving rolls marked with the prefix R for OGS and RW for AGS.
¹⁴ 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 semi-automatic, electrohydraulic tool comes complete with safety guards and safety foot switch
- Equipped with a pivot arm design that simplifies roll change by eliminating shaft removal
- Enhanced tracking rolls allow bi-directional grooving and helps to hold the tool on the pipe end during the roll grooving process
- Roll grooves 3/4 – 12"/DN20 – DN300 pipe (3/4 – 1 1/2"/DN20 – DN32 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 380v power plug prior to shipping.

Weight: 735 lbs./333 kg

Optional Rolls: 3/4 – 1 1/2"/DN20 – DN40 carbon and stainless steel rolls, light wall stainless steel rolls 3/4 – 12"/DN20 – DN300, 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"/DN200 – DN300 pipe is available and is required for grooving 8"/DN200 copper tubing and light wall SS.

Tool Ratings — Maximum Pipe Size and Wall Thickness Capacity			Pipe Size (in mm)													
Model	Pipe Material	Notes	3/4 20	1 25	1 1/4 32	1 1/2 40	2 50	2 1/2 80	3 90	3 1/2 100	4 150	5 200	6 250	8 300	10 250	12 300
VE268	Steel	4, 5	Sch. 5 – 40 1.7 – 8.2 mm											Sch. 5 – 20 3.4 – 6.4 mm		
	Steel (OGS-200)						Sch. 40 – 80 3.9 – 7.6 mm				Sch. 40 6.0 – 7.1 mm					
	Stainless	4	Sch. 40S 2.9 – 8.2 mm													
	Stainless (OGS-200)						Sch. 40S 3.9 – 7.1 mm									
	Lt. Wall SS	6	Sch. 5S – 10S 1.7 – 4.6 mm													
	Aluminum	2, 8					Sch. 5 – 40 1.7 – 8.2 mm						Sch. 5 – 20 3.4 – 6.4 mm			
	PVC Plastic	8, 10					Sch. 40 3.9 mm		Sch. 40 – 80 5.2 – 11.0 mm			Sch. 40 8.2 mm				
	Copper	7	K, L, M and DWV													

² 6061-T4 or 6063-T4 Alloy must be used.
⁴ Use standard grooving rolls marked with the prefix R.
⁵ EndSeal™ grooving rolls marked with the prefix RZ are available. Contact Victaulic® for details.
⁶ Use grooving rolls marked with the prefix RX.
⁷ Use grooving rolls marked with the prefix RR.
⁸ Use grooving rolls marked with the prefix RP.
¹⁰ A special lower roll exclusively for grooving 2" Sch. 80 PVC is available. Part. No. RP02272L02

Roll Grooving – Plant/Shop Fabrication



RG3600

RG3600

- Designed for field roll grooving of DN50 – DN150/2 – 6" stainless steel pipe
- Supplied with StrenThin™ 100 roll sets

Power Requirements: 230 VAC 50/60-Hz

Driver Requirements: REMS Amigo 2. Optional Ridgid™ 700 power drive may be used.

Weight: 55 lbs./29 kg

Tool Ratings — Maximum Pipe Size Capacity		Pipe Size (DN)/Nominal Wall Thickness					
		DN50	DN100	DN150	DN200	DN250	DN300
Model	Pipe Material						
RG3600	Stainless Steel	1.6 – 2.7 mm			2.0 – 3.4 mm		

Certifications/Listings:

- Compliant with the Essential Safety Requirements of 2006/42/EC – EU Machinery Directive

NOTE

- Regional availability for Europe only.

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
- Enhanced tracking rolls allow bi-directional grooving and helps to hold the tool on the pipe end during the roll grooving process
- The tool comes equipped with pipe stabilizers to provide smooth grooving operation
- Roll grooves 2 – 16"/DN50 – DN400 pipe (Supplied with carbon steel 2 – 12"/DN50 – DN300 original rolls and 14 – 16"/DN350 – DN400 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. In Europe this tool is fitted with a cable and 380v power plug prior to shipping.

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"/DN350 – DN400 Schedule 10 through 0.375"/DN13 wall carbon steel pipe are now standard.

Contact Victaulic for pricing and details.

Tool Ratings — Maximum Pipe Size and Wall Thickness Capacity			Pipe Size (in mm)											
			OGS										AGS	
Model	Pipe Material	Notes	2 50	2 ½ 80	3 80	3 ½ 100	4 100	5 150	6 200	8 200	10 250	12 300	14 350	16 400
VE414MC	Steel	5, 12	Sch. 5–80 1.7 – 7.6 mm				Sch. 5–40 2.1 – 9.3 mm				Sch. 10–STD 4.6 – 9.5 mm	Sch. 10–STD 4.8 – 9.5 mm		
	Stainless	13	Sch. 40S 3.9 – 9.5 mm										STD 9.5 mm	
	Lt. Wall SS	14	Sch. 5S–10S 1.7 – 4.6 mm										Sch. 5S–10S 4.0 – 4.8 mm	
	Aluminum	2, 8	Sch. 5–40 1.7 – 9.3 mm								Sch. 5–STD 4.0 – 9.5 mm			
	PVC Plastic	8	Sch. 40 3.9 mm	Sch. 40–80 5.2 – 11.0 mm				Sch. 40 8.2 mm						
	Copper	7	K, L, M and DWV											

- ² 6061-T4 or 6063-T4 Alloy must be used.
- ⁵ EndSeal™ grooving rolls marked with the prefix RZ are available. Contact Victaulic® for details.
- ⁷ Use grooving rolls marked with the prefix RR.
- ⁸ Use grooving rolls marked with the prefix RP.
- ¹² Use standard grooving rolls marked with the prefix R for both OGS and AGS.
- ¹³ Use standard grooving rolls marked with the prefix R for OGS and RW for AGS.
- ¹⁴ 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

- Semi-automatic, hydraulic shop tool is shipped fully assembled with safety foot switch and rolls for standard grooving (4 – 60") 0.500 wall maximum.
- Enhanced tracking rolls allow bi-directional grooving and helps to hold the tool on the pipe end during the roll grooving process
- Tool ships with 4 – 12"/DN100 – DN300 Original Groove System Groove Rolls and 14 – 24"/DN350 – DN600 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 hardwired by a local certified electrician. In Europe this tool is fitted with a cable and 380v power plug prior to shipping.

Weight: 1500 lbs./680 kg

Optional Rolls: Grooving kits available to accommodate grooving 26"/DN650 and above. Each support base is 12"/305 mm in height and corresponds with a range of allowable pipe sizes it can groove. See VE460 Pipe Stand Chart for details.

AGS roll sets for 14 – 24"/DN350 – DN900 Schedule 10 through 0.375"/13 mm wall carbon steel pipe are now standard.

NOTE

- Capable of grooving up to .375" nominal wall thickness API specification 5L, Grade B with a maximum yield strength of 50,000 psi. For higher yield strength use the 50T.
- Capable of grooving up to .500" nominal wall thickness API specification 5L, Grade B with a maximum yield strength of 42,000 psi. For higher yield strength use the 50T.

Roll Grooving – Plant/Shop Fabrication

VE460

Tool Ratings — Maximum Pipe Size and Wall Thickness Capacity			Pipe Size (in mm)																	
			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	5	.250 – .500 6.4 – 12.7 mm						.375 – .500 9.5 – 12.7 mm											
	Stainless		STD 9.5 mm																	
	Lt. Wall SS		Sch. 5S–10S, TRUE 10 4.0–4.8 mm, 6.4 mm																	

Tool Ratings — Maximum Pipe Size and Wall Thickness Capacity			Pipe Size (in mm)											
			OGS											
Model	Pipe Material	Notes	4 100	5	6 150	8 200	10 250	12 300	14 350	16 400	18 450	20 500	22 550	24 600
VE460	Steel (OGS)	4, 12	Sch. 5 – 80 2.1 – 9.5 mm		Sch. 5 – 40 2.8 – 8.2 mm			Sch. 5 – XS 3.4 – 12.7 mm						
	Steel (OGS-200)	11				Sch. 40 – 80 8.2 – 12.7 mm								
	Stainless		Sch. 40S 6.0 – 9.3 mm					STD 9.5 mm						
	Stainless (OGS-200)					Sch. 40 8.2 mm								
	Lt. Wall SS	13	Sch. 5S–10S 2.1 – 4.6 mm					Sch. 5S–10S, TRUE 10 4.0 – 4.8 mm, 6.4 mm						
	Aluminum	2	Sch. 5 – 40 2.1 – 10.3 mm											
	PVC Plastic	7	Sch. 40 – 80 6.0 – 11.0 mm		Sch. 40 8.2 mm									

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

⁵ EndSeal™ grooving rolls marked with the prefix RZ are available. Contact Victaulic® for details.

⁷ Use grooving rolls marked with the prefix RP.

¹¹ OGS-200 for use with Style 870 Rigid Coupling

¹² Use standard grooving rolls marked with the prefix R for OGS and RW for AGS.


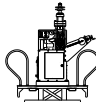
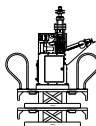
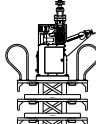
¹³ Use grooving rolls marked with the prefix RX for OGS and RWX for AGS. (Special RWX Rolls are available for grooving true Sch. 10 (0.250 | 6.4 mm).

NOTES

- Capable of grooving up to .375" nominal wall thickness API specification 5L, Grade B with a maximum yield strength of 50,000 psi. For higher yield strength use the 50T.
- Capable of grooving up to .500" nominal wall thickness API specification 5L, Grade B with a maximum yield strength of 42,000 psi. For higher yield strength use the 50T.

Roll Grooving – Plant/Shop Fabrication

VE460 Pipe Stand Chart

Tool Model		Roll Sets Included	Railing and Platform Kit Qty	Support Base (Qty.)	Tool Weight/ Shipping Weight Lbs.	Recommended Pipe Stand ¹⁵
VE460		4 – 6”/ DN100 – DN150 8 – 12”/ DN200 – DN300 14 – 24”/ DN350 – DN600	N/A	N/A	1500/1750	VAPS224 OR VAPS1672*
Optional Accessories¹⁶						
26 – 38”/ 650 – 950 mm Grooving Kit		26 – 38”/ DN650 – DN950	1	1	NA	VAPS1672
40 – 50”/ 1000 – 1200 mm Grooving Kit		40 – 50”/ DN1000 – DN1200	1 ¹⁷	2 ¹⁸	NA	VAPS1672
54 – 60”/ 1300 – 1500 mm Grooving Kit		54 – 60”/ DN1300 – DN1500	1 ¹⁷	3 ¹⁸	NA	VAPS1672

* VAPS1672 pipe stand capacity starts at 16”/DN400.

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

¹⁵ For proper operation, a pipe stand is required. See Accessories for details.

¹⁶ Optional Accessory Kits list REQUIRED COMPONENTS to groove up to the specified size. Kit components can be ordered individually or as a kit.

¹⁷ Railing and Platform Kit is required only if preceding kit has not been ordered.

¹⁸ Only one (1) Support Base is required if preceding kit has been ordered.



50T

50T

- Capable of grooving 14- 78”IDN350 - DN1800 carbon steel pipe
- Heavy-duty shop fabrication tool
- For tool rating capacity reference [publication 24.03](#)

Roll Grooving – Plant/Shop Fabrication



RG5200i

RG5200i

- Fully-automated, hydraulic shop tool is shipped fully assembled with proximity scanner, control stand and rolls for standard grooving (4 – 24"/ DN100 – DN600) Schedule 40 pipe.
- Provides a digital record for every groove; enabling full traceability of pipe preparation.

NOTES

- See publication 24.05 for more details.

Drive Requirements: Self-contained

Power Requirements: 18 amps/220 volts, 3 phase, 50/60 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: 1120 lbs./508 kg

Tool Ratings — Maximum Pipe Size and Wall Thickness Capacity		Pipe Size (in mm) †											
		4 100	5	6 150	8 200	10 250	12 300	14 350	16 400	18 450	20 500	22 550	24 600
RG5200i	Steel	Sch. 10 – 40 (OGS) 3.0 – 10.3 mm						Standard Wall (AGS) 9.5 mm					
	Stainless	Lt. Wall (OGS)						Lt. Wall (AGS)					
		Automatic						Semi-Automatic					

† Light wall pipe can only be grooved in OGS sizes.

Certifications/Listings:

- Compliant with the Essential Safety Requirements of 2006/42/EC – EU Machinery Directive

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 CPVC/PVC pipe
- Tools are supplied with a ratchet handle for manual operation
- Tools 2"/DN50 and larger are supplied with a power yoke
- Cut grooves ¾ – 8"/DN20 – DN200 pipe
- Standard tools are supplied with steel and aluminum cutting bits

Drive Requirements: Manual or external drive, min. ½ hp./0.37 kw

Drive Speed: 40 rpm max.

Shipped Set For: Standard groove, pipe size and material indicated on order. When ordering for ductile/cast pipe, must indicate rigid or flexible upon order.

Weight: 28 lbs./13 kg

Vic-Groover Tool Capacity

Tool Ratings — Maximum Pipe Size and Wall Thickness Capacity		Pipe Size (in mm)											
		¾ 20	1 25	1¼ 32	1½ 40	2 50	2½	3 80	3½ 90	4 100	5	6 150	8 200
VG	Steel	Sch. 40–80 2.9–12.7 mm											
	Stainless	Sch. 40–80 2.9–12.7 mm											
	Aluminum	Sch. 40–80 2.9–12.7 mm											
	CPVC/PVC Plastic				Sch. 40–80 3.9 – 7.6 mm			Sch. 40–80 6.0 – 8.6 mm			Sch. 40–80 7.1 – 11.0 mm		
	Ductile Iron						Class 53 - 56						

Cut Grooving – Field Fabrication



VG28GD

VG28GD

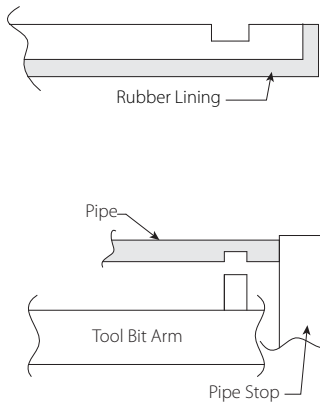
- Designed for cut grooving 2 – 8"/DN50-DN200 pipe
- A modified version (ABR) is available to groove and machine for rubber lining

Drive Requirements: External power drive

Drive Speed: 38 rpm max.

Shipped Set For: Standard groove 4 – 6"/DN100 – DN150 steel pipe.

Weight: 37 lbs./17 kg



Knife Profile for Abrasion Only*

Tool Ratings — Maximum Pipe Size and Wall Thickness Capacity			Pipe Size (in mm)							
			2 50	2½	3 80	3½ 90	4 100	5 150	6 150	8 200
VG28GD	Steel	19	Sch. 40 – 80 3.9 – 11.0 mm						Sch. 40 8.2 mm	
	Stainless		Sch. 40 – 80 3.9 – 11.0 mm						Sch. 40 8.2 mm	
	Aluminum		Sch. 40 – 80 3.9 – 11.0 mm						Sch. 40 8.2 mm	
	Ductile Iron		Class 53 Min.							

NOTE

- Special urethane covered Idler Roll (Part No. R-033-281-AVG) recommended for grooving glass lined pipe.

Tool Ratings — Maximum Pipe Size and Wall Thickness Capacity			Pipe Size (in mm)							
			2 50	2½	3 80	3½ 90	4 100	5 150	6 150	8 200
VG28GD-ABR	Steel	19	Sch. 40 – 80 3.9 – 11.0 mm						Sch. 40 8.2 mm	

¹⁹ Special knives and stops may be required



VDG26GD

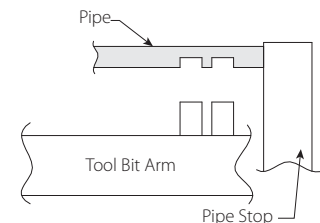
VDG26GD

- Produces a 6"/DN150 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 and Wall Thickness Capacity			Pipe Size (in mm)							
			2 50	2½	3 80	3½ 90	4 100	5 150	6 150	8 200
VDG26GD	Steel	19							Sch. 40 – 80 7.1 – 11.0 mm	

¹⁹ Special knives and stops may be required

NOTE

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

*exaggerated for clarity

Cut Grooving – Field Fabrication



VG26GD-COR

VG26GD-COR

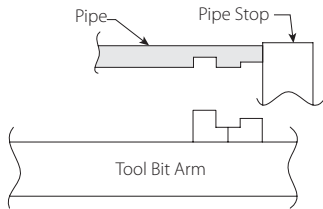
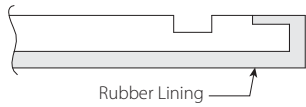
- Designed specifically to cut groove carbon steel pipe to rubber line and machine for abrasion and corrosion resistance only
- Will cut groove carbon steel 2 – 6"/DN50 – DN150

Drive Requirements: External power drive

Drive Speed: 38 rpm max.

Shipped Set For: Standard groove 4 – 6"/DN100 – DN150 steel pipe.

Weight: 37 lbs./17 kg



Knife Profile for Abrasion and Corrosion Only*

*exaggerated for clarity

Tool Ratings — Maximum Pipe Size and Wall Thickness Capacity

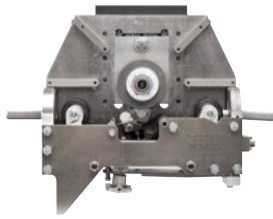
Model	Pipe Material	Note	Pipe Size (in mm)					
			2 50	2½	3 80	3½ 90	4 100	5
VG26GD-COR	Steel	19	Sch. 40–80 3.9 – 11.0 mm					

¹⁹ Special knives and stops may be required

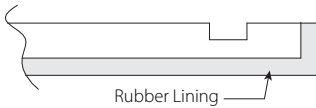
NOTE

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

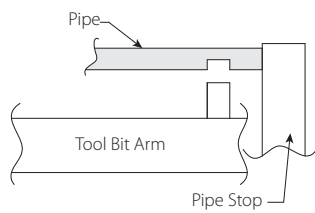
Cut Grooving – Field Fabrication



VG824



Rubber Lining



Pipe

Tool Bit Arm

Pipe Stop

Knife Profile for Abrasion Only*

VG824

- Produces 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
- Designed 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"/DN200 – DN300 steel pipe

Weight: 82 lbs./37.2 kg

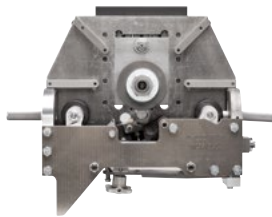
Tool Ratings — Maximum Pipe Size and Wall Thickness Capacity			Pipe Size (in mm)								
Model	Pipe Material	Note	8 200	10 250	12 300	14 350	16 400	18 450	20 500	22 550	24 600
VG824	Steel	19	Sch. 40–80 8.2 – 19.1 mm				Sch. 30–.750 9.5 – 31 mm				
	Stainless		Sch. 30–STD 7.0 – 9.5 mm								
	Aluminum		Sch. 30–STD 7.0 – 9.5 mm								
	Ductile Iron		Class 53 Min.								

NOTE

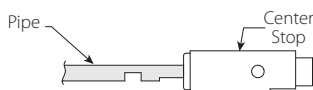
- Special urethane covered Idler Roll (Part No. R-042-828-MCH) recommended for grooving glass lined pipe

Tool Ratings — Maximum Pipe Size and Wall Thickness Capacity			Pipe Size (in mm)								
Model	Pipe Material	Note	8 200	10 250	12 300	14 350	16 400	18 450	20 500	22 550	24 600
VG824-ABR	Steel	19	Sch. 40–XS 8.2 – 12.7 mm								

¹⁹ Special knives and stops may be required

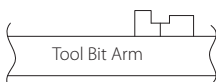


VG824DG



Pipe

Center Stop



Tool Bit Arm

Knife Profile for Double Groove Only*

VG824DG

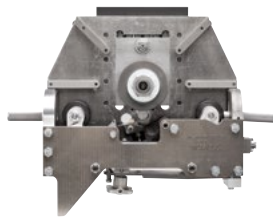
- Designed specifically for cutting a double groove on 8 – 12"/DN200 – DN300 pipe for use with Style 808 double groove couplings
- Designed for job site, fab shop or production cut grooving

Tool Ratings — Maximum Pipe Size and Wall Thickness Capacity			Pipe Size (in mm)								
Model	Pipe Material	Note	8 200	10 250	12 300	14 350	16 400	18 450	20 500	22 550	24 600
VG824DG	Steel	19	Sch. 40–80 8.2 – 17.5 mm								

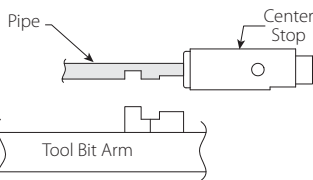
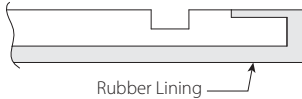
¹⁹ Special knives and stops may be required

*exaggerated for clarity

Cut Grooving – Field Fabrication



VG824-COR



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
- Designed for job site, fab shop or production cut grooving
- Cut grooves 8 – 24"/DN200 – DN600 pipe

Drive Requirements: External power drive

Drive Speed: 38 rpm max.

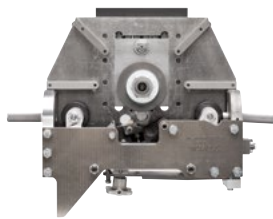
Shipped Set For: Standard groove, 8 – 12"/DN200 – DN300 steel pipe

Weight: 82 lbs./37.2 kg

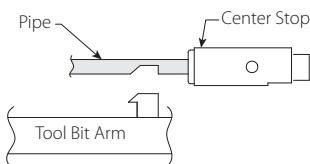
Tool Ratings — Maximum Pipe Size and Wall Thickness Capacity

Model	Pipe Material	Note	Pipe Size (in mm)							
			8 200	10 250	12 300	14 350	16 400	18 450	20 500	22 550
VG824-MRL	Steel	19	Sch. 40 – .500 8.2 – 12.7 mm							

¹⁹ 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 and Wall Thickness Capacity

Model	Pipe Material	Note	Pipe Size (in mm)					
			14 350	16 400	18 450	20 500	22 550	24 600
VG828	Steel	19	.500-.750 12.7 – 19.0 mm					

¹⁹ 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 cutting and grooving of ductile iron pipe to meet AWWA and other industry specifications for mechanical couplings
- External mounting and drive action is designed for use on 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"/DN100 – DN300 pipe
- Safety foot switch

Drive Requirements: 120 volt/11.5 amp

Shipped Set For: Rigid radius groove profile, 4 – 12"/DN100 – DN300 ductile iron pipe

Weight: 151 lbs./69 kg

Options: Capable of grooving 4 – 12"/DN100 – DN300 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 and Wall Thickness Capacity		Pipe Size (in mm)						
		4 100	4½	5	6 150	8 200	10 250	12 300
VG412	Steel	Sch. 40–80 6.0 – 17.5 mm						
	Ductile Iron	Class 53 Min.						



CG3100

Cut Grooving Tool for High Density Polyethylene (HDPE) Pipe

- The 3000 Series cut grooving tools are designed for grooving 8 – 36"/DN200 – DN900 HDPE (DR7 – DR21) pipe. The tool mounts on the exterior pipe wall and cuts and grooves the end of the pipe in a single operation.

Power Requirements:

- The CG3100 and CG3300 tools connect directly to a 120- volt, 50-60 Hz, 20-amp power source. An optional 220-volt single phase, 50-60 Hz model is also available.
- The CG3500 tool connects directly to a 220-volt single phase, 50-60 Hz, 20-amp power source.

Tool Ratings — Maximum Pipe Size and Wall Thickness Capacity		Pipe Size (in mm)												
		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
CG3100/CG3101	HDPE	DR7 – DR21												
CG3300/CG3301								DR7 – DR21						
CG3500/CG3501								DR7 – DR21						

NOTE

- See publication 24.06 for more details.

Certifications/Listings:

- Compliant with the Essential Safety Requirements of 2006/42/EC – EU Machinery Directive:

Plastic Groovers



CG1100

CG1100

- Grooves 2 – 12"/DN50 – DN300 pipe
- Portable, light-weight field or shop fabrication tool
- Designed to provide a radius PGS-300 cut groove in Schedule 40 - 80 CPVC/PVC pipe

Power Requirements: 120VAC, 50/60HZ, 7A

Rotation Drive:

Weight: 17 lbs./7.7 kg

Tool Ratings — Maximum Pipe Size and Wall Thickness Capacity		Pipe Size (in mm)						
		2 50	2½	3 80	4 100	6 150	8 200	10 250
CG1100	CPVC/PVC	Sch. 40-80 3.9 – 17.5 mm						

NOTE

- See [publication 24.09](#) for more details.

VPG824

- Grooves 8 – 16"/DN200 – DN400 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"/DN200 – DN300



VPG824

Tool Ratings — Maximum Pipe Size and Wall Thickness Capacity		Pipe Size (in mm)				
		8 200	10 250	12 300	14 350	16 400
VPG824	CPVC/PVC Plastic	Sch. 40-80 8.2 – 21.4 mm				

Aquamine Grooving Tools

The APG is a manually operated tool used for producing a cut spline groove and beveled end on 4 – 12"/DN100 – DN300 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



APG

Hole Cutting Tools



HCT904

HCT904

- One piece cutting tool designed to cut holes up to 2 ¾"/70 mm in carbon and stainless steel pipe with OD up to 8"/DN200
- Allows for use of *Mechanical-T*, *Vic-Let*, and *Vic-O-Well* outlets
- This tool is only available in Europe

Capacity: 1 – 2 ¾"/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 2 ¾"/70 mm in carbon and stainless steel pipe with OD up to 3 ½"/DN90
- Allows for use of *Mechanical-T*, *Vic-Let*, and *Vic-O-Well* outlets

Capacity: 1 ¼ – 2 ¾"/32 – 70 mm holes for ½ – 2 ½"/DN15 – 73.0 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 4 ½"/127 mm in diameter for *Mechanical-T*, *Vic-Let*, and *Vic-O-Well* outlets
- Base unit clamps 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 – 4 ½"/25 – 120 mm holes for ½ – 4"/DN15 – DN100 *Mechanical-T*, Strapless Outlet 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"/DN250 – DN600 pipe; Motor speed control accessory for cutting 3 – 4 ½"/80 – 127 mm holes

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"/DN100 – DN200 Run × 2 ½"/DN65 (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 ¾"/DN60.5



VIC-TAP II

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"/DN15 jaw, one (1) ¾"/DN20 jaw, one (1) 1"/DN25 jaw, one (1) 1 ½"/DN40 hinged jaw, 2"/DN50 hinged jaw, and one (1) adapter jaw.
- Jaws are included with each tool purchase.
- Vic-Press™ PFT510 is designed for industrial and trade use only

Capacity: ½"/DN15, ¾"/DN20, 1"/DN25, 1½"/DN40, 2"/DN50 Sch. 10S 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"/DN25 jaw 21 lbs./ 9.5kg

Certifications/Listings:

- Compliant with the Essential Safety Requirements of 2006/42/EC – EU Machinery Directive:

Pipe Cutting Tools



VCT1

VCT1 Manual

- Lightweight and portable pipe cut-off tool handles 4 – 24"/DN100 – DN600 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"/DN100 – DN600

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
- Distributor design has stainless steel insert which extends tip life, eases cleaning and reduces backfire

Capacity: 6 – 24"/DN150 – DN600

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"/DN300 and above. Order Guide Rail D-600 for up to 24"/DN600 pipe (others available).



PC3110

PC3110

- Lightweight pipe cut-off tool
- Marks the outside diameter of the pipe with insertion marks for proper installation of the QuickVic™ SD couplings and fittings
- Designed for operation with a power drive.

Capacity: ½ – 2"/DN15 – DN50

Accessories – Power Drive



Mule II

Power Mule II

- Designed 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 II 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
- Trough design allows for rotational and forward/transverse movement

Capacity: 3/4 – 12"/DN20 – DN300 IPS pipe

Load Rating: 1075 lbs./490 kg

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

Minimum Pipe Height from Floor: 23"/584 mm on 12"/DN300 pipe
21"/533 mm on 1"/DN25 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"/DN50 – DN600 IPS pipe

Load Rating: 1800 lbs./816 kg

Vertical Stroke: 23"/584 mm

Minimum Pipe Height from Floor: 13"/325 mm on 24"/DN600 IPS pipe

Maximum Pipe Height from Floor: 38"/965 mm on 2"/DN50 IPS pipe

Weight: 260 lbs./118 kg

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

Accessories – Adjustable Pipe Stand



VAPS270

VAPS270

- Designed specifically for supporting pipe to be roll grooved
- Self-standing, heavy-duty unit permits free pipe rotation and traversing on ball transfers
- Designed for use with VE108H, VE270FSD, VE271FSD and VE272SFS grooving tools
- Turnstile design allows grooving of both pipe ends without dismounting pipe from stand

Capacity: 3/4 – 12"/DN20 – DN300 pipe

Load Rating: 660 lbs./300 kg

Minimum Pipe Height from Floor: 25"/635 mm

Maximum Pipe Height from Floor: 37"/940 mm

Weight: 44 lbs/20 kg

NOTE

- Only available in Europe. Contact Victaulic for details.



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"/DN400 – DN1800 pipe

Load Rating: 10000 lbs

Vertical Stroke: 17"

Minimum Pipe Height from Floor: 16" on 72"/DN1800 pipe

Maximum Pipe Height from Floor: 28" on 16"/DN400 pipe

Accessories – Pipe Diameter Tape



PT100A



PT101

PT100A / PT101 /PT101A

- Go/No-Go pocket-sized steel tapes are available for taking circumferential measurements on pipe sizes ¾ – 24"/DN20 – DN600.
- Tape contains Go/No-Go markings on one side for use with ¾ – 24"/DN20 – DN600 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) (¾ – 12"/DN20 – DN300) and Advanced Groove System (AGS) (14 – 24"/DN35 – DN600) 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"/DN500), 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 DN20 – DN600 pipe sizes.

PT102A



PT102A

- Go/No-Go pocket-sized steel tapes are available for taking circumferential measurements on pipe sizes 8 – 72"/DN200 – DN1800.
- Tape contains Go/No-Go markings on one side for use with Original Groove System sizes 8 – 12"/DN200 – DN300 pipe and Advanced Groove System sizes 14 – 72"/DN300 – DN1800 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"/DN200 – DN1050 pipe size, including China pipe sizes and JIS specifications 8 - 12"/DN200– DN300 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 – Pipe Diameter Tape



GDC-CTS



GDC-EC



GDC-AC

GDC-CTS/GDC-EC/GDC-AC

- Go/No-Go pocket-sized cable provides a method to quickly inspect that your groove is within specification on Copper Tube Size pipe, European Copper and Australian Copper.
- The Go/No-Go cable is a quick reference guide only. It is not a replacement for a calibrated diameter measuring instrument. Always refer to the I-100 Victaulic Field Installation Handbook or to the latest groove specifications publications located on www.victaulic.com.



GDC-StrengThin™ 100

GDC-StrengThin™ 100

- Go/No-Go pocket-sized Groove Diameter Cables provide a method to quickly inspect that your groove is within specification on pipe sizes DN50 – DN300/2 – 12".
- The Go/No-Go side can be used to check roll grooved pipe conformance to Victaulic StrengThin™ 100 groove diameter specifications.
- The Go/No-Go cable is a quick reference guide only. To ensure proper grooving dimensions, always refer to the I-E497 StrengThin™ 100 Installation Instructions or to the latest groove specifications ([publication 25.13](#)) located on www.victaulic.com.



GDC-PGS-300

GDC-PGS-300

- The PGS-300 Groove Diameter Cable provides a method to quickly inspect that your groove is within specification on CPVC/PVC pipe.
- This cable is a quick reference guide and is not a replacement for a calibrated diameter measuring instrument. To ensure proper grooving dimensions, always refer to the relevant installation instructions or to the latest groove specifications ([publication 25.18](#)) located on www.victaulic.com.



OGS-200 Groove Confirmation Gauge

OGS-200 Groove Confirmation Gauges

- The OGS-200 Groove Confirmation Gauges allow the operator to check the groove without removing the tool from the pipe.
- Three gauges are in the set for 2", 2.5 – 3", 4 – 6".
- This confirmation gauge is a quick reference guide and is not a replacement for a calibrated diameter measuring instrument. To ensure proper grooving dimensions, always refer to the relevant installation instructions or to the latest groove specifications ([publication 25.12](#)) located on www.victaulic.com.



HDPE Double Cut Groove Confirmation Gauge

HDPE Double Cut Groove Confirmation Gauge

- The HDPE double cut groove go/no-go gauge is designed to check HDPE cut grooves to ensure that they meet Victaulic specifications.
- Three gauges are in the set for 8 – 18", 16 – 26", 24 – 36".
- This confirmation gauge is a quick reference guide only. To ensure proper grooving dimensions, always refer to Victaulic's HDPE Cut Groove Specifications ([publication 25.16](#)) or to the I-900 HDPE Field Installation Handbook located on victaulic.com.

Accessories – Pipe Diameter Tape



IGS Groove
Confirmation Gauge

IGS Groove Confirmation Gauge

- The IGS Groove Confirmation Gauge is designed to check IGS roll grooves to ensure that they meet Victaulic specifications.
- This confirmation gauge is a quick reference guide only. To ensure proper grooving dimensions, always refer to Victaulic's IGS Roll Groove Specifications ([publication 25.14](#)).

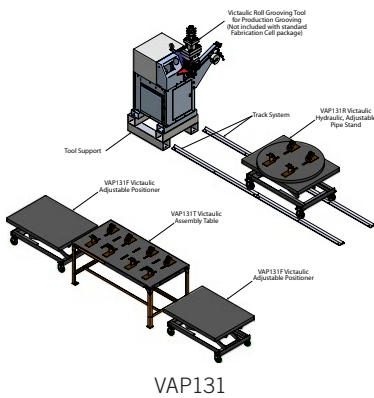
Accessories – System Safety Test



Test Cap Kit No. T-60

- **Complete Kit** - Includes case, dividers and two No. T-60 Test Caps per size in 2 – 8"/DN50 – DN200.

Accessories – Fabrication Cell



VAP131



VAPS 131R Hydraulic Adjustable Pipe Stand



VAPS 131F Hydraulic Positioner



VAPS 131T Assembly Table

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

- 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"/DN100 – DN600 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

- 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"/DN100 – DN600 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

- 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"/DN50 – DN600

Capacity: 4 – 24"/DN100 – DN600 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 designed 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 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



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

Grooving Times

Time for pipe preparation 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 Pipe²⁰

Nominal Size	Roll Groovers – Powered								Cut Groovers				
	Inches	VE226	VE272SFS	VE270FSD	VE268	VE416FSD	VE414MC	VE460	RG1200	Vic-Groover		Vic-Adjustable	
										Power	Hand	VG28GD	VG824 Power
¾	0.5 ²¹	—	0.2	0.2	—	—	—	—	0.5	1.5	—	—	
1	0.6 ²¹	—	0.2	0.2	—	—	—	—	0.5	1.5	—	—	
1¼	0.7 ^{21 22}	—	0.2	0.2	—	—	—	—	0.7	2.0	—	—	
1½	0.8 ^{21 22}	—	0.2	0.2	—	—	—	—	0.7	2.5	—	—	
2	1.0 ^{22 23}	0.3	0.3	0.3	0.3	0.2	—	1–2	1.0	3.0	1.0	—	
2½	1.3 ^{22 23}	0.3	0.3	0.3	0.3	0.2	—	1–2	1.2	3.8	1.3	—	
3	1.4 ^{22 23}	0.4	0.4	0.4	0.4	0.2	—	1–2	1.4	4.5	1.5	—	
3½	1.4 ^{22 23}	0.4	0.4	0.4	0.4	0.2	—	—	1.7	5.5	2.0	—	
4	1.5 ^{22 23}	0.5	0.4	0.5	0.5	0.2	<1	2–3	1.9	7.0	2.5	—	
4½	1.5 ^{22 23}	0.8	0.6	0.6	0.6	0.2	<1	2–3	2.3	8.0	2.8	—	
5	1.6 ^{22 23}	1.0	0.8	0.8	0.8	0.2	<1	2–3	2.5	9.0	3.5	—	
6	1.8 ^{22 23}	1.5	1.2	0.8	1.0	0.3	<1	2–3	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 ²⁴	3.6 ²⁴	2.7	—	—	—	—	12.0	
16	—	—	—	—	8.0 ²⁴	4.0 ²⁴	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 ²⁵	—	—	—	—	—	
28	—	—	—	—	—	—	3.2 ²⁵	—	—	—	—	—	
30	—	—	—	—	—	—	3.4 ²⁵	—	—	—	—	—	
32	—	—	—	—	—	—	3.6 ²⁵	—	—	—	—	—	
36	—	—	—	—	—	—	4.0 ²⁵	—	—	—	—	—	
38	—	—	—	—	—	—	4.2 ²⁵	—	—	—	—	—	
42	—	—	—	—	—	—	4.5 ²⁵	—	—	—	—	—	
46	—	—	—	—	—	—	4.8 ²⁵	—	—	—	—	—	
48	—	—	—	—	—	—	5.0 ²⁵	—	—	—	—	—	
54	—	—	—	—	—	—	5.5 ²⁵	—	—	—	—	—	
56	—	—	—	—	—	—	5.8 ²⁵	—	—	—	—	—	
60	—	—	—	—	—	—	6.5 ²⁵	—	—	—	—	—	

²⁰ 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.

²¹ VE226B ²² VE226S ²³ VE226M

²⁴ For AGS roll grooves

²⁵ Based on 3/8"/10 mm wall thickness. For ½"/13 mm wall thickness add 10% to grooving times.

NOTE: Grooving times are for the grooving cycles only. These times do not include pipe preparation or handling.

Standard Pipe Wall Thickness

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

Nominal Size Inches DN	Actual Outside Diameter Inches mm	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
1¼ 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
1½ 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
2½	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
3½ 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	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 Inches DN	Actual Outside Diameter Inches mm	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	+
38 950	38.000 965.2	—	—	—	—	—	—	+	—	+
42 1050	42.000 1066.8	—	—	—	—	—	—	+	—	+
46 1150	46.000 1168.4	—	—	—	—	—	—	+	0.375 9.52	0.5 12.70
48 1200	48.000 1219.2	—	—	—	—	—	—	+	0.375 9.52	0.5 12.70
54 1350	54.000 1371.6	—	—	—	—	—	—	+	—	+
56 1400	56.000 1422.4	—	—	—	—	—	—	+	—	+
60 1500	60.000 1524.0	—	—	—	—	—	—	+	—	+
72 1800	72.000 1828.8	—	—	—	—	—	—	+	—	+

+ Contact Victaulic for details.

Notifications

NOTICE
<ul style="list-style-type: none"> • Victaulic does not recommend the use of any furnace butt-welded pipe with sizes 2"/DN50 and smaller Victaulic gasketed joint products. This includes, but is not limited to, ASTM A53 Type F pipe.

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.

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