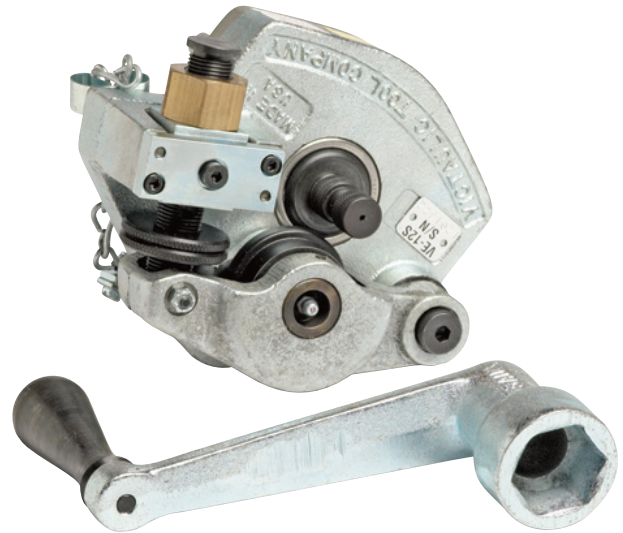


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## VE12 Roll Grooving Tool

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FOR STEEL, STAINLESS STEEL, ALUMINUM IPS, AND PVC PIPE

**OGS**

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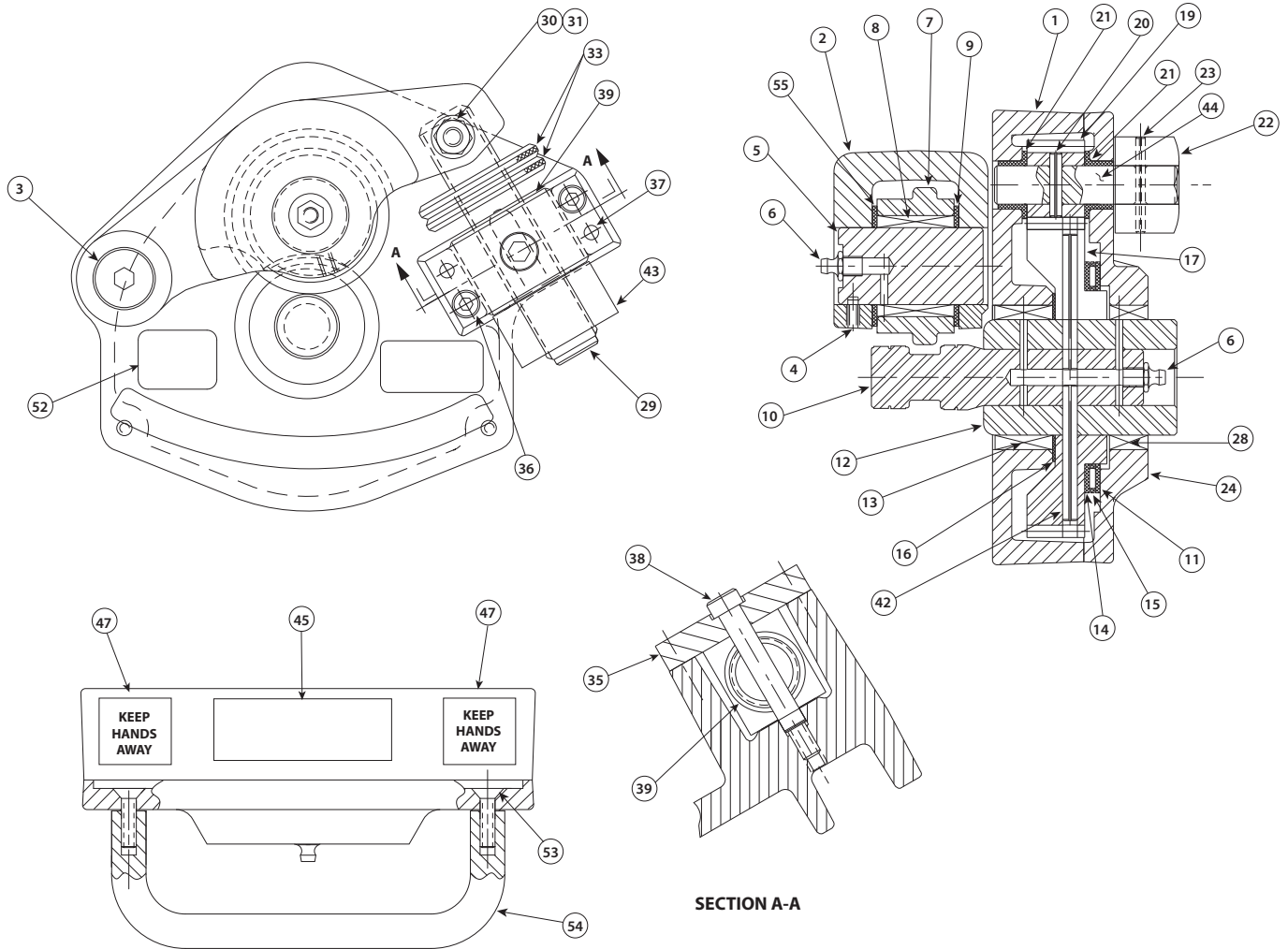
### PARTS ORDERING INFORMATION

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

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

Parts may be ordered from your nearest Victaulic Sales Office.

\* Quantity given in **Qty.** column indicates total number of pieces required per tool

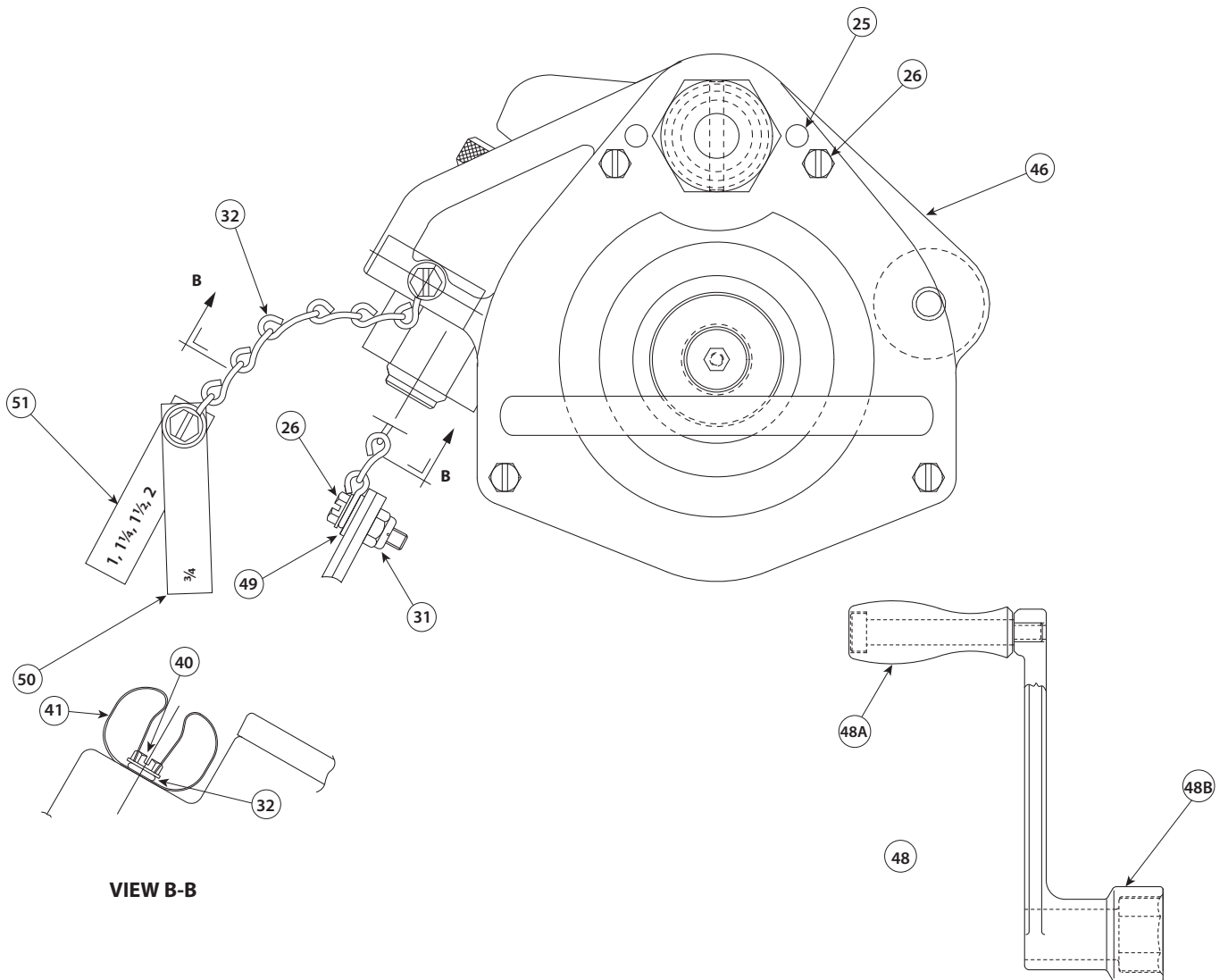


SECTION A-A

Item #	Part #	Qty.	Description
1	R014012MCH	1	Gear Housing, Machining
2	R0020120FS	1	Arm, Machining
3	NS05080012	1	Shoulder Screw, Hex Socket Head 1/2 x 3/4
4	NS90010006	1	Set Screw, Hex Socket Head Half Dog Point #10-24 x 3/8
5	R0080260FS	1	Upper Shaft
6	NM01000007	2	Lubrication Fitting, 1/4-28 Straight
7	R900012UA2	1	Upper Roll Assembly
8	NB02100008	1	Bearing, Needle Roller *
9	NB05100002	1	Thrust Washer
10	R901012L02	1	Lower Roll
11	NB05225001	1	Thrust Washer
12	R902012A02	1	Lower Roll Adapter
13	NB02150006	1	Bearing, Needle Roller
14	NB05225002	1	Thrust Washer
15	NB03225001	1	Bearing, Thrust Needle Roller
16	NB05150002	1	Thrust Washer

Item #	Part #	Qty.	Description
17	R017012MCH	1	Gear
19	R015012MCH	1	Pinion
20	NP80000010	1	Pin, Slotted Spring 5/32 x 3/4
21	NB21050003	2	Bearing, Flanged
22	R0180260FS	1	Drive Nut
23	NP01002104	1	Pin, Slotted Spring 1/8 x 1 1/4
24	R012012MCH	1	Gear Cover Plate, Machining
25	NP02004012	2	Dowel Pin, 1/4 x 3/4
26	NS22010012	5	Machine Screw, Hex Washer Slotted Head #10-24 x 3/4
28	NB02150005	1	Bearing, Needle Roller
29	R0100260FS	1	Feed Screw
30	NS05040104	1	Shoulder Screw, Hex Socket Head 1/4 x 1 1/4
31	NN15010000	2	Locknut, Hex #10-24

\* Included with Item 7



VIEW B-B

Item #	Part #	Qty.	Description
32	NM09000005	1	Chain, No. 12 Single Jack
33	R0200260FS	2	Narrow Depth Stop Collar
35	R0130260FS	1	Front Plate
36	NS03010008	2	Cap Screw, Hex Socket Head #10-24 x 1/2
37	NP02003012	2	Dowel Pin, 3/16 x 3/4
38	NS05050112	1	Shoulder Screw, Hex Socket Head 5/16 x 1 3/4
39	R0120260FS	1	Trunnion
40	NS22010006	1	Machine Screw, Hex Washer Slotted Head #10-24 x 3/8
41	NT08000003	1	Spring Clip
42	NP01003112	2	Pin, Slotted Spring 3/16 x 1 3/4
43	R0110260FS	1	Feed Nut
44	R016012MCH	1	Pinion Shaft
45	RLAB000010	1	Warning Label †
46	RLAB000009	1	"C" Diameter Reference Label †

Item #	Part #	Qty.	Description
47	R027226LBL	2	Keep Hands Away Label †
48	R3000260FS	1	Crank Assembly
48A	NM04000016	1	Revolving Handle
48B	R3010260FS	1	Crank Arm
49	NW01010000	1	Washer, #10
50	R0800120FS	1	Gauge for 3/4" Steel Pipe ‡
51	R0810120FS	1	Gauge for 1", 1 1/4", 1 1/2", and 2" Steel Pipe ‡
52	R018012MCH	1	Serial Number Tag †
53	NS09011010	2	Cap Screw, Hex Socket Countersunk Head #10-32 x 5/8
54	NM04000001	1	Handle
55	NB05175004	1	Thrust Washer

† Refer to the following page for images of product labels

‡ Included as part of the Gauge Assembly (Part Number R0820120FS)

VE12 Roll Grooving Tool

IMAGES OF THE LABELS ON THIS PAGE ARE NOT TO SCALE.

RLAB000010

<b>⚠ WARNING</b>	
<p>Failure to follow instructions can result in serious personal injury, property damage, and product damage.</p> <ul style="list-style-type: none"> <li>• Before operating or servicing this tool, read and understand the operating and maintenance instructions manual and all labels located on this tool.</li> <li>• <b>THIS IS A MANUALLY DRIVEN TOOL. DO NOT ATTEMPT TO OPERATE THIS TOOL WITH A POWER DRIVE.</b></li> <li>• A quarter turn of the depth stop collar will change the groove diameter 0.017 inch/0.4 mm.</li> </ul>	
3831 Rev. C	RLAB000010

R027226LBL

**KEEP  
HANDS  
AWAY**

5183 Rev. B      R027226LBL

RLAB000009

SIZE	MAX. SCH.	O.D.		5166 Rev. C    ⌀ "C"    RLAB000009	
		MAXIMUM	MINIMUM	MAXIMUM	MINIMUM
¾ [26.9]	10	1.060 [26.9]	1.040 [26.4]	0.938 [23.8]	0.923 [23.4]
1 [33.7]	40	1.328 [33.7]	1.302 [33.1]	1.190 [30.2]	1.175 [29.9]
1¼ [42.4]	40	1.676 [42.6]	1.644 [41.8]	1.535 [39.0]	1.520 [38.6]
1½ [48.3]	40	1.919 [48.7]	1.881 [47.8]	1.775 [45.1]	1.760 [44.7]
2 [60.3]	40	2.399 [60.9]	2.351 [59.7]	2.250 [57.2]	2.235 [56.8]

R018012MCH

**VE12S**

Manufactured in Canada

**S/N**

6276 Rev. A      R018012MCH

