

**REPAIR PARTS FOR
VE268/269 Roll Grooving Tool**



PARTS ORDERING INFORMATION

When ordering parts, the following information is necessary for the Victaulic Tool Company to promptly process the order and send the correct part(s).

1. Tool Model Number. VE268
2. Tool Serial Number.
The Serial Number (found on the side of the tool).
3. Quantity, Item Number, Part Number, Description.
Example: (1), 15, R-067-274-PNT, Switch Guard.
4. Where to send the part(s).
Company Name. Address
5. To whose attention to send the part(s).
Person's Name.
6. Purchase Order Number

Parts may be ordered from the nearest Victaulic Sales Office. Consult Victaulic Tool Company for the nearest Victaulic Sales Office.

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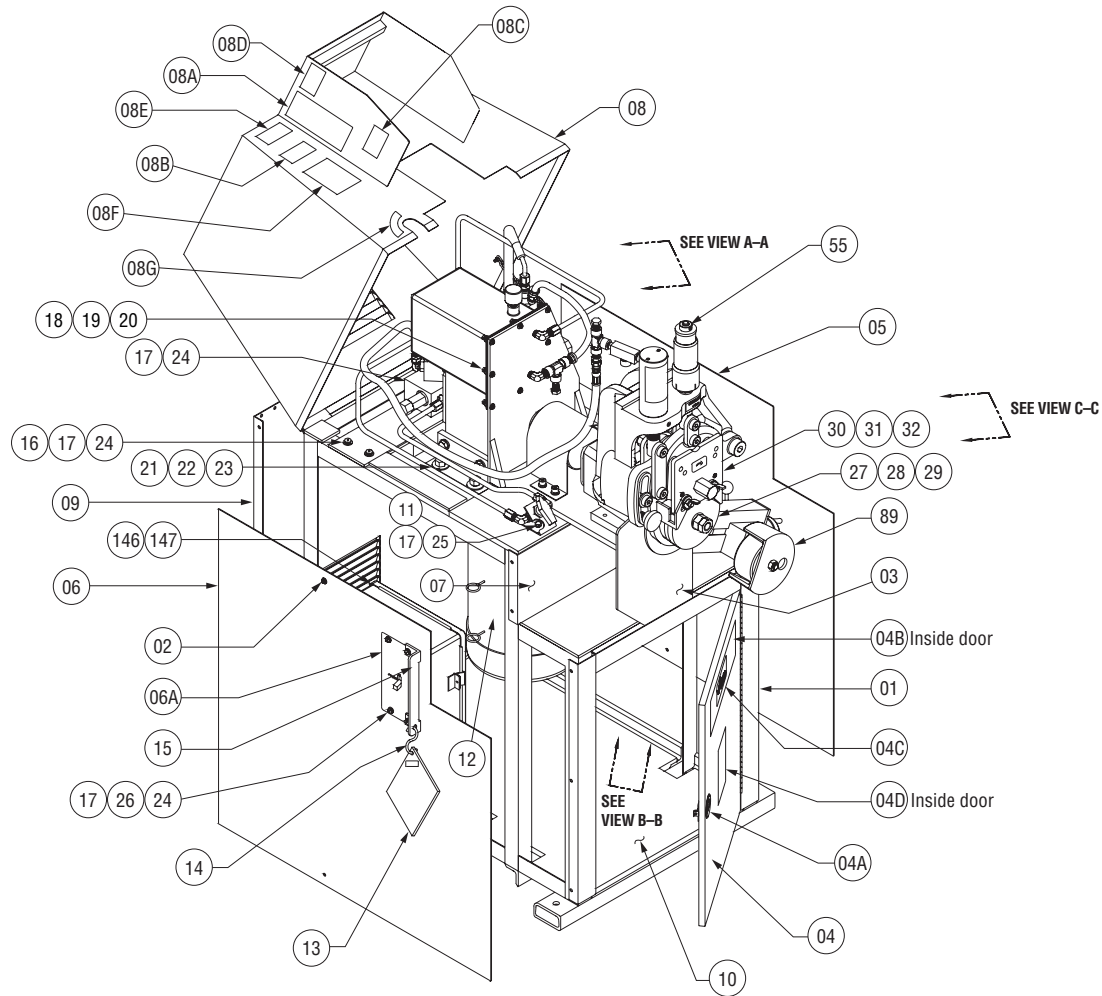
Victaulic Company of America
Phone: 1-800-PICK-VIC (1-800-742-5842)
Fax: 610-250-8817
e-mail: pickvic@victaulic.com

Victaulic Company of Canada
Phone: 905-884-7444
Fax: 905-884-9774
e-mail: viccanada@victaulic.com

Victaulic Europe
Phone: 32-9-381-1500
Fax: 32-9-380-4438
e-mail: viceuro@victaulic.be

Victaulic America Latina
Phone: 610-559-3300
Fax: 610-559-3608
e-mail: vical@victaulic.com

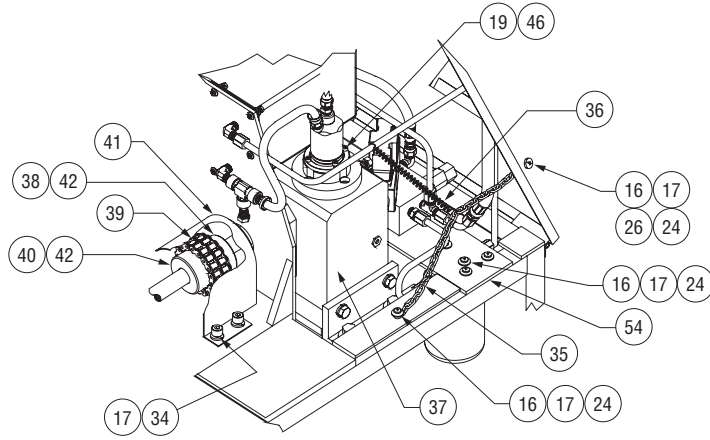
Victaulic Asia Pacific
Phone: 86-21-58855151
Fax: 86-21-58851298
e-mail: vicap@victaulic.com



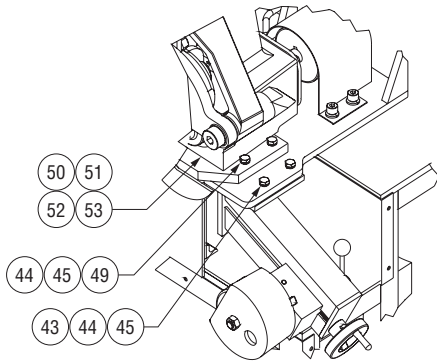
Item #	Part #	Qty.	Description
01	R-004-274-PNT	1	Frame
02	N-S30-012-014	28	#12-24 x 0.88 Hex Washer Head Self Drill Screw
03	R-006-274-PNT	1	Guard
04	R-007-274-PNT	1	Front Door **
04A	N-M07-000-001	1	Latch
04B	R-024-268-LBL	1	VE268 Operating Specifications Label
04C	R-055-260-LBL	1	Victaulic Logo Label
04D	R-090-424-LAB	1	Electrical Danger Label
05	R-008-274-PNT	1	Side Panel, RH
06	R-009-274-PNT	1	Side Panel, LH **
06A	R-025-268-LBL	1	Electrical Panel Label
07	R-010-274-PNT	1	Front Panel
08	R-011-274-PNT	1	Top Enclosure **
08A	R-009-424-LBL	1	"C" Diameter Label
08B-268	R-023-268-LBL	1	VE268 Series Label
08B-269	R-023-269-LBL	1	VE269 Series Label
08C	R-010-416-LAB	1	Standard Wall Thickness Label
08D	R-070-260-VE0	1	"C" Diameter Reference Label for Copper
08E	R-031-272-LAB	1	Instruction Warning Label
08F	R-064-268-LBL	1	Tightening Direction Label
08G	R-020-260-LBL	1	Pressure Setting Label
09	R-012-260-PNT	1	Rear Enclosure
10	R-013-274-PNT	1	Plywood Floor
11	R-020-274-PNT	1	Ball Valve Mounting Bracket
12-268	N-E01-000-025	1	3HP Motor

Item #	Part #	Qty.	Description
12-269	N-E01-000-001	1	3HP Motor (Export)
13	R-039-272-OFS	1	Guard Setting Pad Assembly
14	N-M07-000-005	1	S-Hook
15	R-067-274-PNT	1	Switch Guard
16	N-W01-040-000	8	1/4" Flat Washer, Plated
17	N-W03-040-000	24	1/4" Helical Lock Washer, Plated
18	N-S06-010-010	8	#10-24UNC x 0.63 Lg. Pan Hd. Cap Screw, Pltd.
19	N-W03-010-000	12	#10 Helical Lock Washer, Plated
20	N-N01-010-000	8	#10-24UNC Hex Nut, Plated
21	N-S01-080-204	4	1/2-13UNC x 2.25 Lg. Hex Head Cap Screw, Pltd.
22	N-W01-080-000	4	1/2" Flat Washer, Plated
23	N-N16-080-000	4	1/2-13UNC Nylok Locking Hex Nut
24	N-S06-040-012	14	1/4-20UNC x 0.75 Lg. Pan Hd. Phillips Screw, Pltd.
25	N-S01-040-008	2	1/4-20UNC x 0.50 Lg. Hex Head Cap Screw, Pltd.
26	N-N01-040-000	5	1/4-20UNC Hex Nut, Plated
27	R-902-272-L03	1	2 - 3 1/2" Lower Roll for Steel Pipe
28	R-904-272-L06	1	4 - 6" Lower Roll for Steel Pipe
29	R-908-272-L12	1	8 - 12" Lower Roll for Steel Pipe
30	R-9A0-268-U02	1	Upper Roll Cover/Guard Assembly, 3/4" - 1 1/2" Steel Pipe (Optional)
31	R-9A2-268-U06	1	Upper Roll Cover/Guard Assembly, 2" - 6" Steel Pipe
32	R-9A8-268-U12	1	Upper Roll Cover/Guard Assembly, 8" - 12" Steel Pipe
33	R-512-260-VE0	1	Lower Roll Removal Tool (not shown)

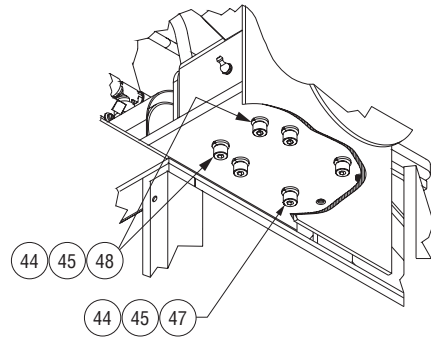
** Indicates additional items required and/or recommended when ordering.



VIEW A-A



VIEW C-C



VIEW B-B

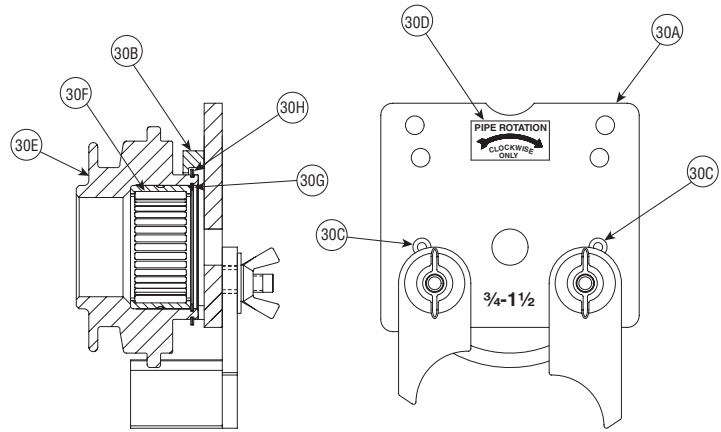
Item #	Part #	Qty.	Description
34	N-S03-040-008	4	1/4"-20UNC x 0.50" Lg. Socket Head Cap Screw, Blk. Ox.
35	N-M09-000-002	14"	Chain
36	N-M03-000-003	1	Spring
37	R-015-274-VE0	1	Gear Reducer Assembly
38	N-M10-000-021	1	Chain Coupling
39	N-M10-000-022	1	Chain
40	N-M10-000-020	1	Chain Coupling
41	R-012-414-PNT	1	Coupling Guard
42	N-K02-004-112	2	Square Key, 1/4" x 1.75 Lg.
43	N-S02-060-100	2	3/8"-16UNC x 1" Lg. Hex Head Cap Screw, Plated
44	N-W03-060-000	10	3/8" Helical Lock Washer, Plated
45	N-W01-060-000	10	3/8" Flat Washer, Plated

Item #	Part #	Qty.	Description
46	N-S03-010-008	4	#10-24UNC x 0.50 Lg. Sock. Hd. Cap Screw, Blk. Ox.
47	N-S03-060-200	4	3/8"-16UNC x 2.00 Lg. Sock. Hd. Cap Screw, Blk. Ox.
48	N-S03-060-104	2	3/8"-16UNC x 1.25 Lg. Sock. Hd. Cap Screw, Blk. Ox.
49	N-S02-060-200	2	3/8"-16UNC x 2.00 Lg. Hex Hd. Cap Screw, Grd. 8, Plated
50	R-058-274-MCH	As Req'd	Shim - .005 Thk.
51	R-059-274-MCH	As Req'd	Shim - .007 Thk.
52	R-060-274-MCH	As Req'd	Shim - .020 Thk.
53	R-061-274-MCH	As Req'd	Shim - .040 Thk.
54	R-062-274-PNT	1	Manifold Mounting Plate

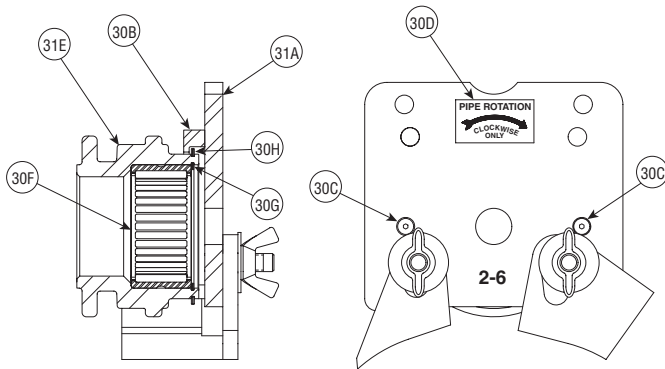
** Indicates additional items required and/or recommended when ordering.

Item #	Part #	Qty.	Description
30	R-9A0-268-U02	1	Upper Roll Cover/Guard Assembly
30A	R-500-268-WLD	1	Upper Roll Guard
30B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
30C	N-S09-008-010	2	#8-32 UNC x 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
30D	R-040-416-LAB	1	Pipe Rotation Label
30E *	R-900-268-U01	1	3/4" - 1 1/2" Upper Roll for Steel Pipe
30F	N-B02-200-001	1	Needle Bearing
35G	N-T03-000-014	1	Snap Ring
30H	N-T03-000-022	1	Snap Ring

* Not a saleable item – assembly must be ordered.



**UPPER ROLL COVER/GUARD ASSEMBLY
FOR 3/4 - 1 1/2" STEEL PIPE
(Item 30)**



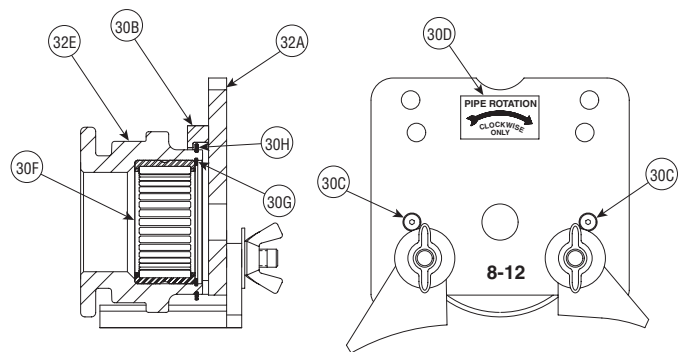
**UPPER ROLL COVER/GUARD ASSEMBLY
FOR 2 - 6" STEEL PIPE
(Item 31)**

Item #	Part #	Qty.	Description
31	R-9A2-268-U06	1	Upper Roll Cover/Guard Assembly
31A	R-510-268-WLD	1	Upper Roll Guard
30B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
30C	N-S09-008-010	2	#8-32 UNC x 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
30D	R-040-416-LAB	1	Pipe Rotation Label
31E *	R-902-272-U06	1	2" - 6" Upper Roll for Steel Pipe
30F	N-B02-200-001	1	Needle Bearing
30G	N-T03-000-014	1	Snap Ring
35H	N-T03-000-022	1	Snap Ring

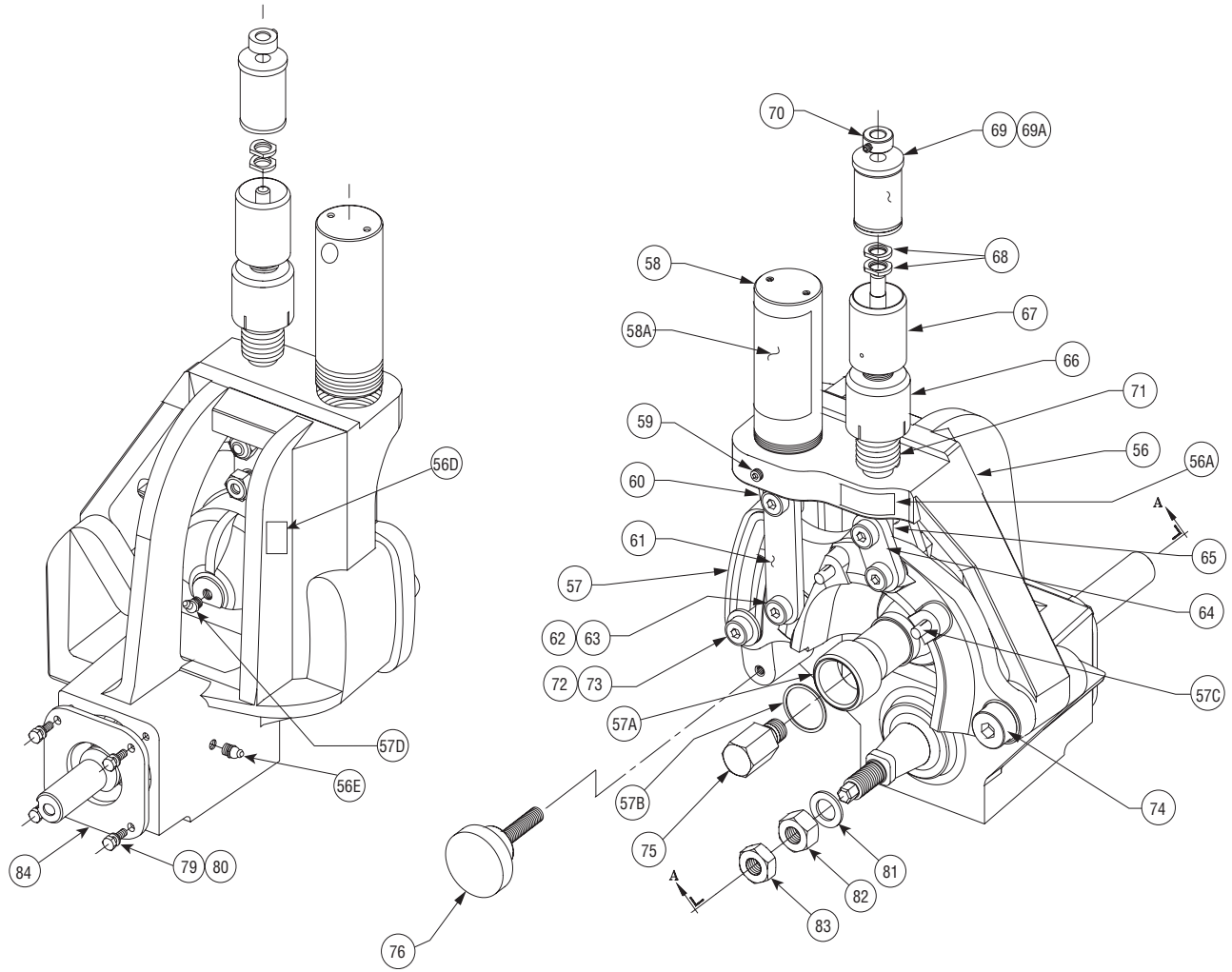
* Not a saleable item – assembly must be ordered.

Item #	Part #	Qty.	Description
32	R-9A8-268-U12	1	Upper Roll Cover/Guard Assembly
32A	R-520-268-WLD	1	Upper Roll Guard
30B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
30C	N-S09-008-010	2	#8-32 UNC x 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
30D	R-040-416-LAB	1	Pipe Rotation Label
32E *	R-908-272-U12	1	8" - 12" Upper Roll for Steel Pipe
30F	N-B02-200-001	1	Needle Bearing
30G	N-T03-000-014	1	Snap Ring
30H	N-T03-000-022	1	Snap Ring

* Not a saleable item – assembly must be ordered.



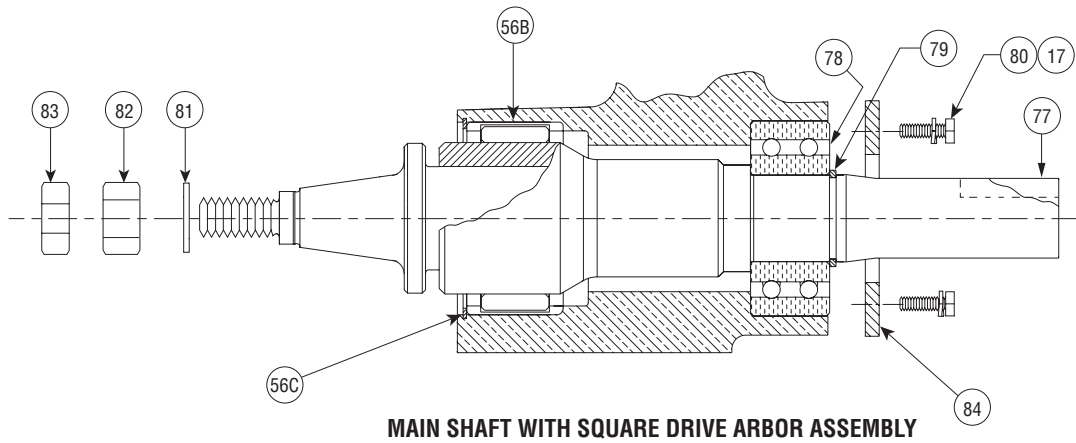
**UPPER ROLL COVER/GUARD ASSEMBLY
FOR 8 - 12" STEEL PIPE
(Item 32)**



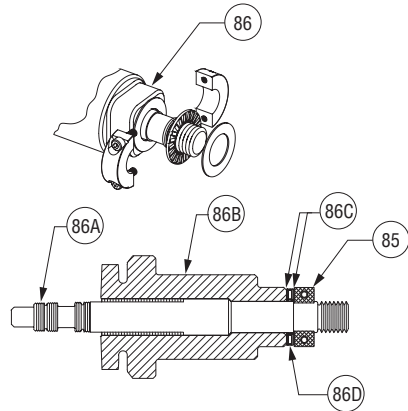
Item #	Part #	Qty.	Description
55	R-100-268-VE0	1	Tool Head Assembly
56	R-002-272-0FS	1	Body **
56A	R-034-272-LAB	1	Depth Stop Adjustment Direction Label
56B	N-B02-275-002	1	Needle Bearing
56C	N-T03-000-015	1	Snap Ring
56D	R-069-272-LAB	1	Name Plate
56E	N-M01-000-002	1	Straight Grease Fitting, 1/8" NPT
57	R-003-268-MCH	1	Arm **
57A	N-B04-156-002	1	Inner Race
57B	N-T03-000-017	1	Snap Ring
57C	N-P11-006-100	2	Groove Pin
57D	N-M01-000-001	1	65° Grease Fitting, 1/8" NPT
58	N-H01-000-008	1	Hydraulic Cylinder **
58A	R-033-274-LBL	1	Roll Warning Label
59	N-S80-060-008	1	3/8 - 16 UNC x .50 Lg. Brass Tip Set Screw
60	R-012-272-0FS	1	Cylinder Adapter
61	R-013-272-0FS	2	Link - Cylinder to Arm
62	N-S05-100-110	4	.625 x 1.63 Lg. Hex Socket Head Shoulder Screw per ANSI/ASME B18.3, Blk. Ox.

Item #	Part #	Qty.	Description
63	N-N08-080-000	4	1/2 - 13 UNC Heavy Hex Nylon Insert Locking Nut
64	R-116-268-PLT	2	Link - Depth Adjuster to Arm
65	R-017-272-0FS	1	Depth Adjuster Shaft
66	R-018-272-0FS	1	Depth Adjuster Lock
67	R-019-272-0FS	1	Depth Adjuster
68	R-020-272-0FS	2	Pipe Size Indicator Calibrator
69	R-021-272-0FS	1	Pipe Size Indicator Barrel **
69A	R-122-268-LBL	1	Pipe Size Groove Depth Label
70	N-S95-040-000	1	Collar with Set Screw
71	N-M03-000-015	1	Spring
72	R-025-272-0FS	1	Guide Washer
73	R-019-226-MCH	1	.625 x 1.00 Lg. Socket Hd. Shoulder Screw, Blk. Ox.
74	N-S05-160-014	1	1.00 x .875 Lg. Socket Hd. Shoulder Screw, Blk. Ox.
75	R-030-272-0FS	1	Upper Roll Guard Cover Screw
76	N-M04-000-004	1	Steel Hand Knob

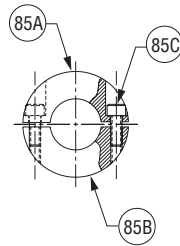
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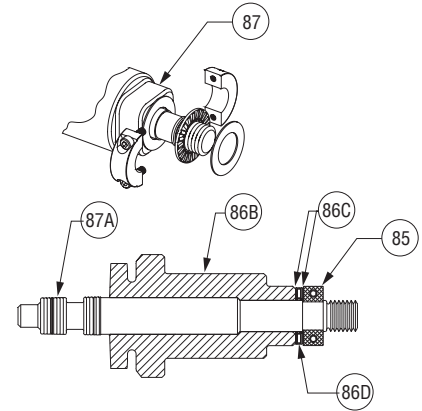
Item #	Part #	Qty.	Description
77	R-129-268-MCH	1	Main Shaft
78	N-B01-157-002	1	40mm ID x 90mm OD x 36.5mm Wide Bearing
79	N-T03-000-018	1	Snap Ring
80	N-S01-040-010	4	$\frac{1}{4}$ " - 20 UNC x .63 Lg. Hex Head Screw, Pltd.
81	N-W06-120-000	1	$\frac{3}{4}$ " ID SAE High Strength Flat Washer, Pltd.
82	N-N01-120-000	1	$\frac{3}{4}$ " - 10 UNC Hex Nut, Grade 5, Pltd.
83	N-N03-120-000	1	$\frac{3}{4}$ " - 10 UNC Hex Jam Nut, Pltd.
84	R-028-272-OFS	1	Back Cover Plate



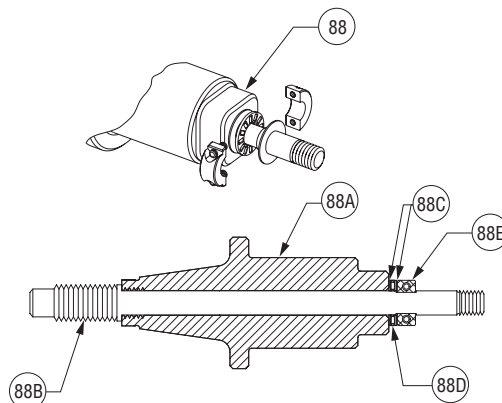
**3/4" Pipe Arbor Assembly
(Item 86)**



**Shaft Collar Assembly
(Item 85)**



**1" & 1 1/2" Pipe Arbor Assembly
(Item 87)**



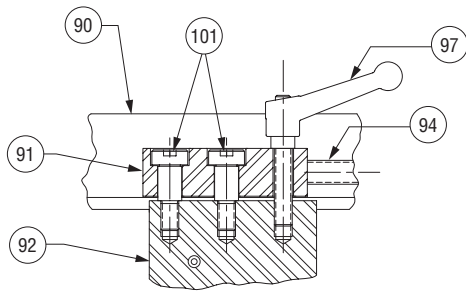
**2" - 12" Pipe Arbor Assembly with Square Drive
(Item 88)**

Item #	Part	Qty.	Description
SHAFT COLLAR ASSEMBLY			
85A	R-171-268-MCH	1	Shaft Collar – Top
85B	R-172-268-MCH	1	Shaft Collar – Bottom
85C	N-S03-006-006	2	#6–32 UNC x 3/8" Lg. SHCS, Blk. Ox.
3/4" PIPE ARBOR ASSEMBLY			
85	R-173-268-ASY	1	Shaft Collar Assembly **
86	R-9A0-268-L01	1	3/4" Arbor Assembly **
86A	R-975-268-L75	1	VE268/VE270FSD 3/4" Lower Roll
86B	R-900-268-A02	1	VE268/VE270FSD Lower Roll Adapter
86C	N-M30-000-005	2	Washer, Flat, Special, 0.031 Thk. x 0.750 Bore
86D	N-B03-750-001	1	Needle Thrust Bearing, 0.750 Bore
1" & 1 1/2" PIPE ARBOR ASSEMBLY			
85	R-173-268-ASY	1	Shaft Collar Assembly **
87	R-9A1-268-L02	1	1" & 1 1/2" Arbor Assembly **
87A	R-901-268-L02	1	VE268/270FSD 1" & 1 1/2" Lower Roll
86B	R-900-268-A02	1	VE268/270FSD Lower Roll Adapter
86C	N-M30-000-005	2	Washer, Flat, Special, 0.031 Thk. x 0.750 Bore
86D	N-B03-750-001	1	Needle Thrust Bearing, 0.750 Bore

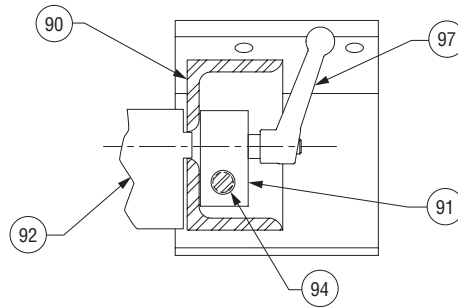
Item #	Part	Qty.	Description
2" - 12" PIPE ARBOR ASSEMBLY WITH SQUARE DRIVE			
88	R-190-268-VE0	1	VE268/VE270FSD 2" - 12" Arbor Assembly ***
88A	R-195-268-MCH	1	VE268/VE270FSD Arbor 2" - 12" Pipe
88B	R-192-268-MCH	1	VE268/VE270FSD Taper Roll Retaining Stud
88C	N-B05-050-001	2	Washer, Flat, Special, 0.031 Thk. x 0.500 Bore
88D	N-B03-050-001	1	Needle Thrust Bearing 0.500 Bore
88E	N-M13-000-002	1	Split Shaft Collar

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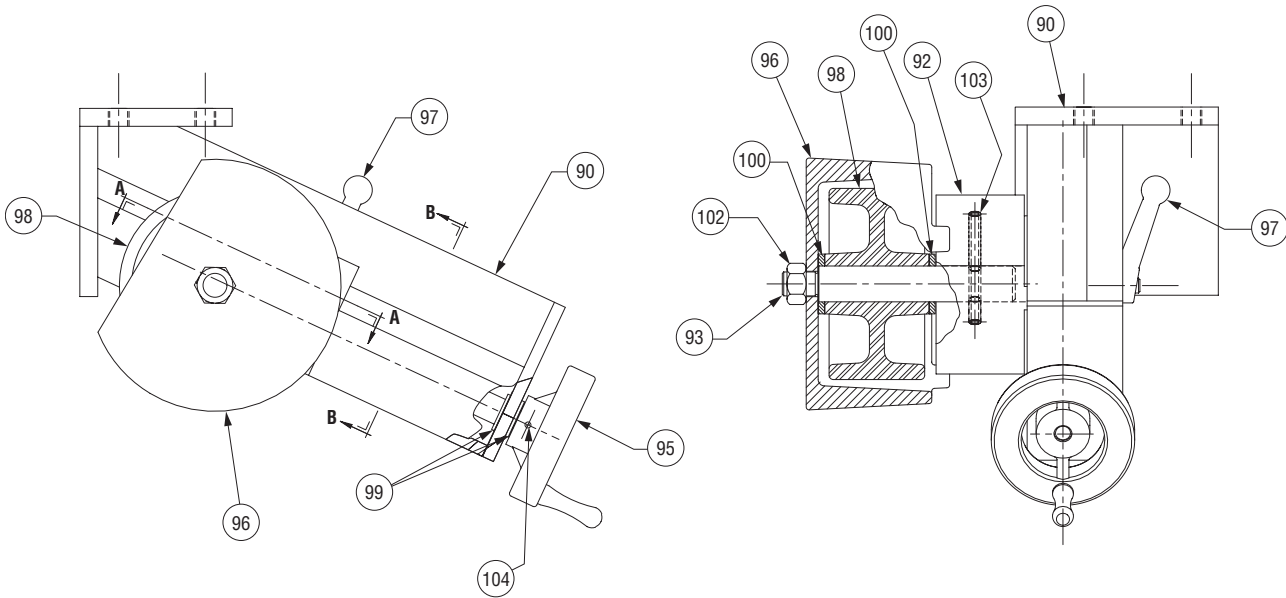
*** Indicates optional part number. R-195-268-KIT includes Item 88 plus 2" – 3", 4" – 6" and 8" – 12" lower rolls.



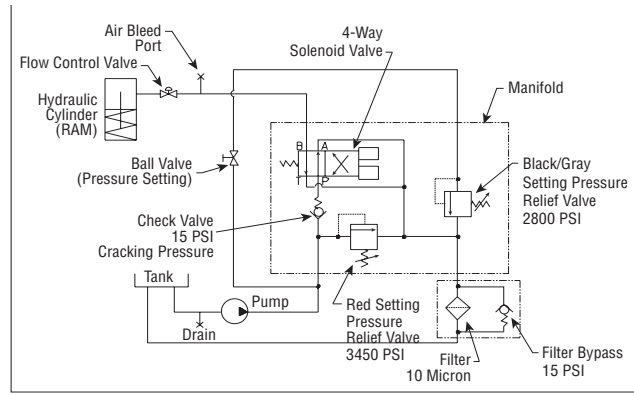
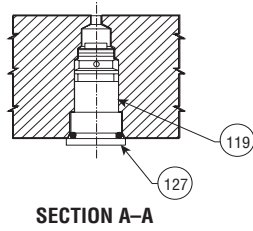
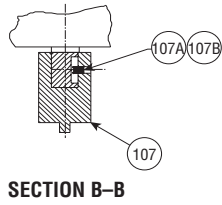
SECTION A-A



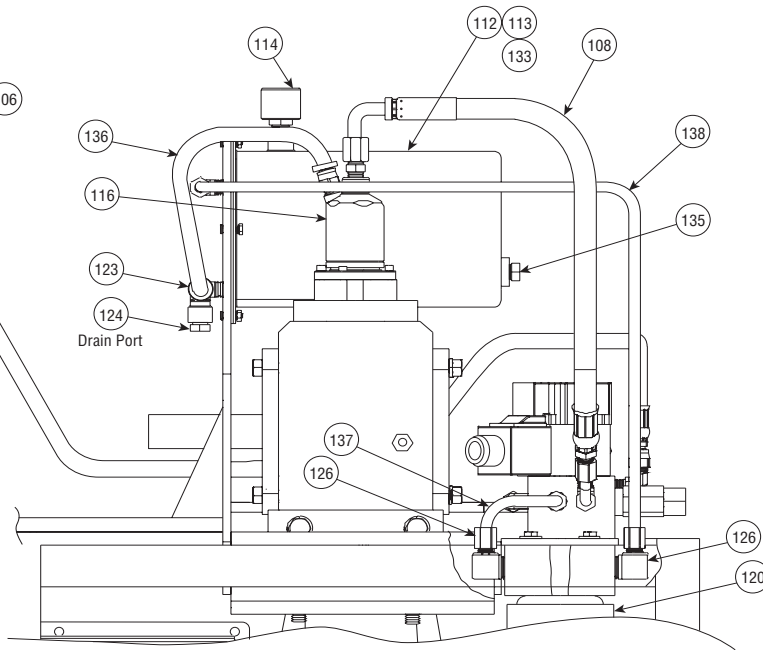
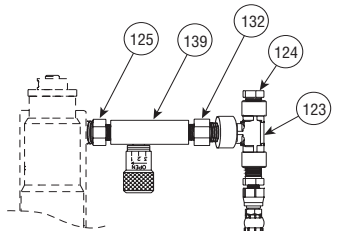
SECTION B-B



Item #	Part #	Qty.	Description
89	R-400-274-VE0	1	Stabilizer Assembly
90	R-401-272-0FS	1	Stabilizer Body
91	R-402-416-PLT	1	Stabilizer Guide Nut
92	R-403-416-PLT	1	Stabilizer Guide
93	R-404-416-MAC	1	Stabilizer Wheel Shaft
94	R-405-272-0FS	1	Stabilizer Adjustment Screw
95	R-406-416-MAC	1	Stabilizer Handwheel
96	R-407-416-PNT	1	Stabilizer Wheel Guard
97	N-M04-000-004	1	Stabilizer Locking Handle Assembly
98	N-M05-000-004	1	4" x 2" Polyurethane Wheel
99	N-B05-037-002	2	Thrust Washer
100	N-B05-075-004	2	Thrust Washer
101	N-S05-080-012	2	1/2" Dia. x 0.75 Lg. Socket Head Shoulder Bolt, Blk. Ox.
102	N-N02-080-000	1	1/2 - 20UNF Hex Nut, Pltd.
103	N-P01-004-208	1	Roll Pin, 1/4" x 2.5" Lg.
104	N-P01-002-102	1	Roll Pin, 1/8" x 1.125" Lg.



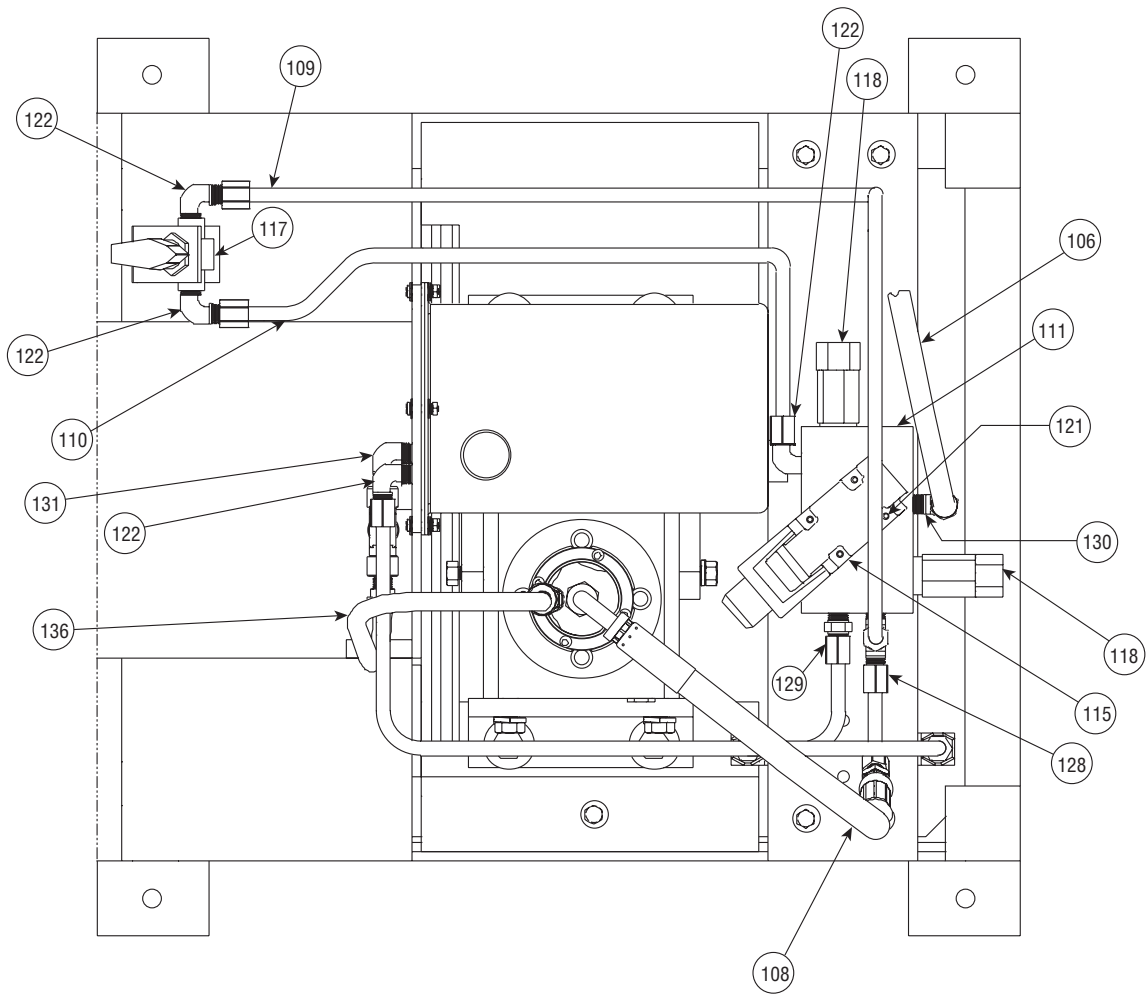
HYDRAULIC SCHEMATIC



- NOTES:**
 1. Item 115 on 220/440 Volt 3 phase tool to be Vickers #DG4V-3-2A-W-B-10 or Rexroth #4WE6-D51/W120-60 ND.

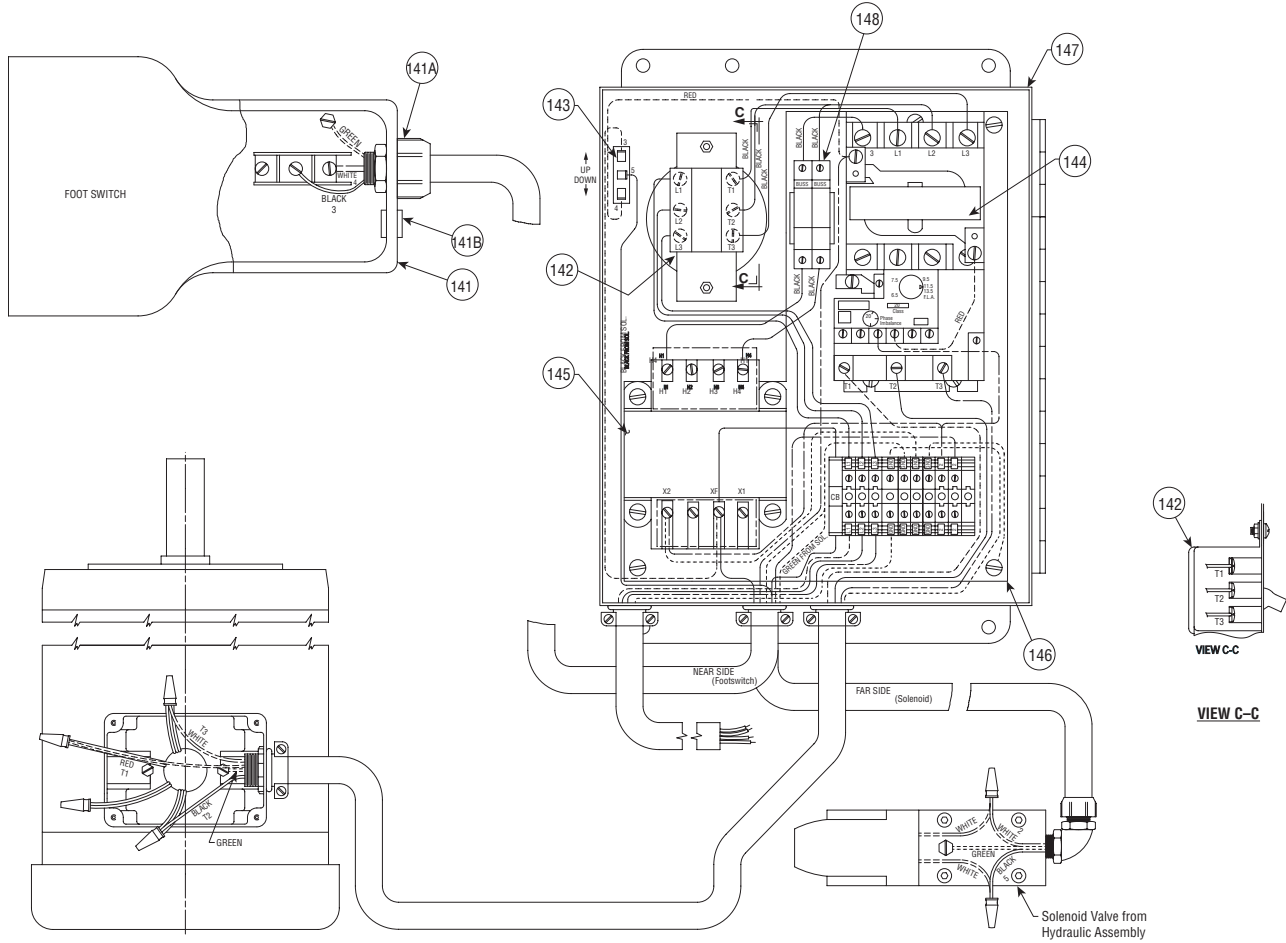
Item #	Part #	Qty.	Description
105	R-200-274-VE0	1	Hydraulic Assembly
106	R-201-274-VE0	1	Hose Assembly, Manifold-Cylinder
107 **	R-003-274-MCH	1	Pump Drive Coupling
107A	N-S90-040-008	1	1/4"-20UNC x 1/2" Lg. Dog Point Set Screw
107B	-	As Req'd	Loctite #271
108	R-205-274-VE0	1	Hose Assembly, Pump-Manifold
109	R-206-274-VE0	1	Tubing Detail, Manifold-Ball Valve
110	R-207-274-VE0	1	Tubing Detail, Ball Valve-Manifold
111	R-209-274-MCH	1	Manifold
112	R-201-260-PNT	1	Tank
113	-	6 qt.	Hydraulic Oil
114	N-H07-000-001	1	Breather
115	N-H04-000-004	1	See Note #1
116	N-H01-000-001	1	Pump
117	N-H04-000-007	1	Ball Valve
118	N-H04-000-030	2	Relief Valve
119	N-H04-000-003	1	Check Valve
120	N-H08-000-002	1	Return Line Filter
121	N-S03-010-200	4	#10-24UNC x 2" Lg. Socket Head Cap Screw, Blk. Ox.

** Indicates additional items required and/or recommended when ordering.



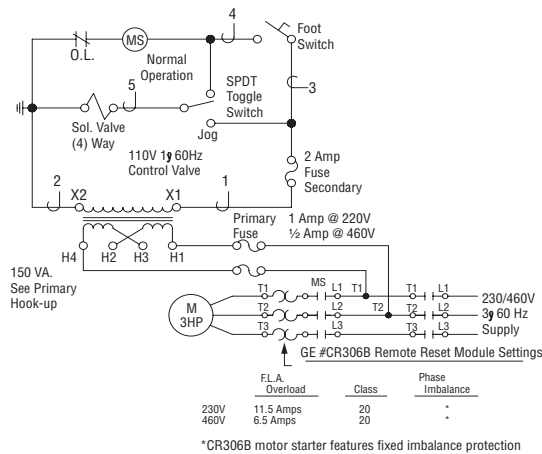
Item #	Part #	Qty.	Description
122	N-H12-006-002	4	90° Elbow
123	N-H14-004-001	2	1/4" Female Branch Tee
124	N-H16-004-001	2	1/4" Hex Head Plug
125	N-H11-006-006	1	Red. Hex Nipple
126	N-H12-006-003	2	90° Elbow
127	N-H16-010-001	1	Plug
128	N-H14-006-002	1	Male Run Tee
129	N-H11-006-001	1	Connector
130	N-H12-004-002	1	90° Elbow
131	N-H12-004-011	1	Male Elbow
132	N-H11-004-010	1	Red. Hex Nipple
133	R-232-274-GSK	1	Hydraulic Reservoir Gasket
134	-	As Req'd	Ribbon Dope
135	N-H16-006-001	1	Hex Head Plug
136	R-238-274-VE0	1	Hose Assembly, Tank - Pump Inlet
137	R-239-274-VE0	1	Tubing Detail, Manifold-Filter
138	R-240-274-VE0	1	Tubing Detail, Filter-Tank
139	N-H04-000-012	1	Flow Control Valve

VE268 - CURRENT ELECTRICAL ASSEMBLY

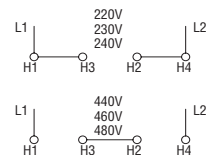


Item #	Part #	Qty.	Description
140	R-300-274-VE0	1	VE268 Electrical Assembly
141	N-E03-000-002	1	Footswitch
141A	N-E06-000-001	1	Connector
141B	-	1	Plug, 1/2"
142	N-E02-000-028	1	Switch
143	N-E02-000-008	1	Switch
144	N-E11-000-002	1	Magnetic Starter
145	N-E10-000-001	1	Transformer
146	R-336-274-MCH	1	Main Enclosure Panel
147	R-338-274-VE0	Ref.	Electrical Box
148	-	1	Fuse, Primary, Low Peak

ELECTRICAL SCHEMATIC



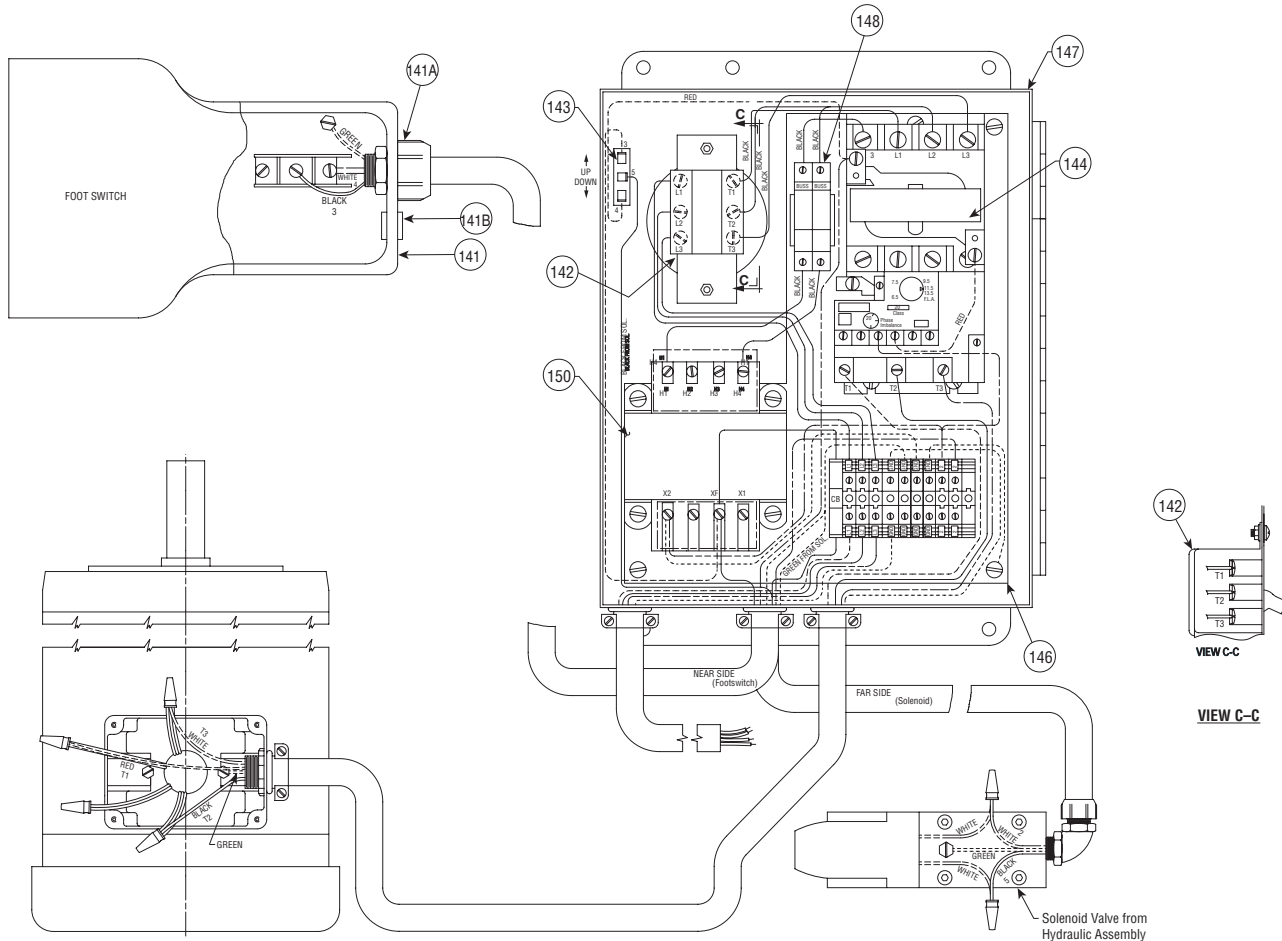
INCOMING POWER REQUIREMENTS
 230 or 460 Volt 3 Phase 60 Hz
 8.8 Amp Full Load @ 230 Volts
 4.4 Amp Full Load @ 460 Volts
 Incoming power must be short circuit protected by breaker or fuse.



TRANSFORMER CONNECTIONS

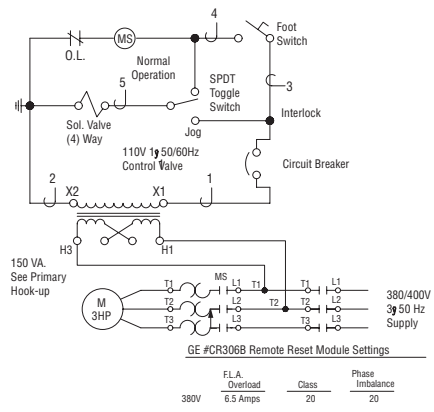
*CR306B motor starter features fixed imbalance protection

VE269 - CURRENT ELECTRICAL ASSEMBLY



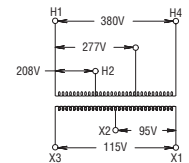
Item #	Part #	Qty.	Description
141	N-E03-000-002	1	Footswitch
141A	N-E06-000-001	1	Connector
141B	-	1	Plug, 1/2"
142	N-E02-000-028	1	Switch
143	N-E02-000-008	1	Switch
144	N-E11-000-002	1	Magnetic Starter
146	R-336-274-MCH	1	Main Enclosure Panel
147	R-338-274-VE0	Ref.	Electrical Box
148	-	1	Fuse, Primary, Low Peak
149	R-300-269-VE0	1	VE269 Electrical Assembly
150	N-E10-000-002	1	Shielded Transformer

ELECTRICAL SCHEMATIC

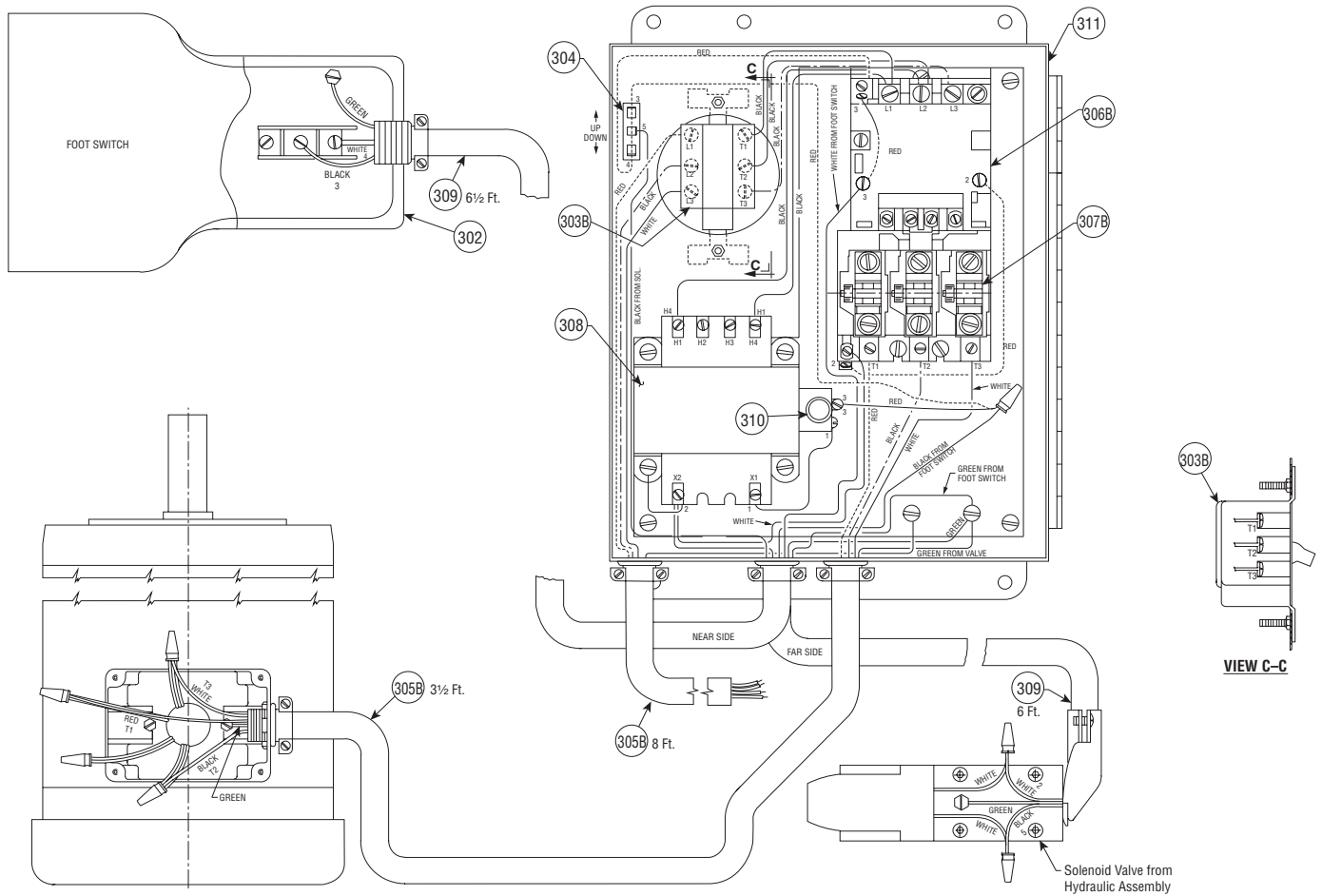


INCOMING POWER REQUIREMENTS
 380 Volt 3 Phase 50 Hz
 6.5 Amp Full Load @ 380 Volts
 5.7 Amp (1.15 S.F) 380V @ 50 Hz
 Incoming power must be short circuit protected by breaker or fuse.

TRANSFORMER CONNECTIONS

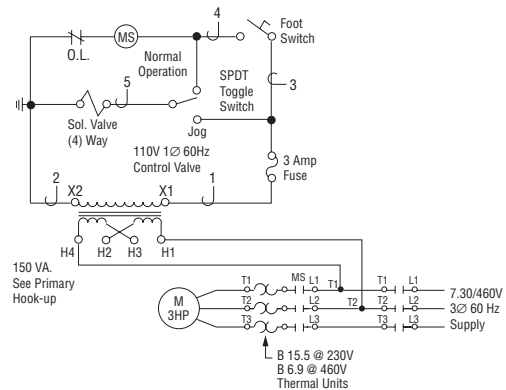


VE268 - PREVIOUS ELECTRICAL ASSEMBLY

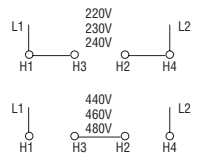


Item #	Part #	Qty.	Description
302	N-E03-000-002	1	Footswitch
303B	N-E02-000-028	1	Switch
304	N-E02-000-008	1	Switch
305B	-	11 1/2 ft.	Line Cord
306B	N-E11-000-002	1	Magnetic Starter
307B	N-E11-000-011	3	Heater
308	N-E10-000-005	1	Transformer
309	-	12 1/2 ft.	Line Cord, #16/3 Type 50 Neoprene
310	N-E13-000-014	1	Fuse Buss
311	R-338-274-VE0	Ref.	Electrical Box (See Main Assembly)

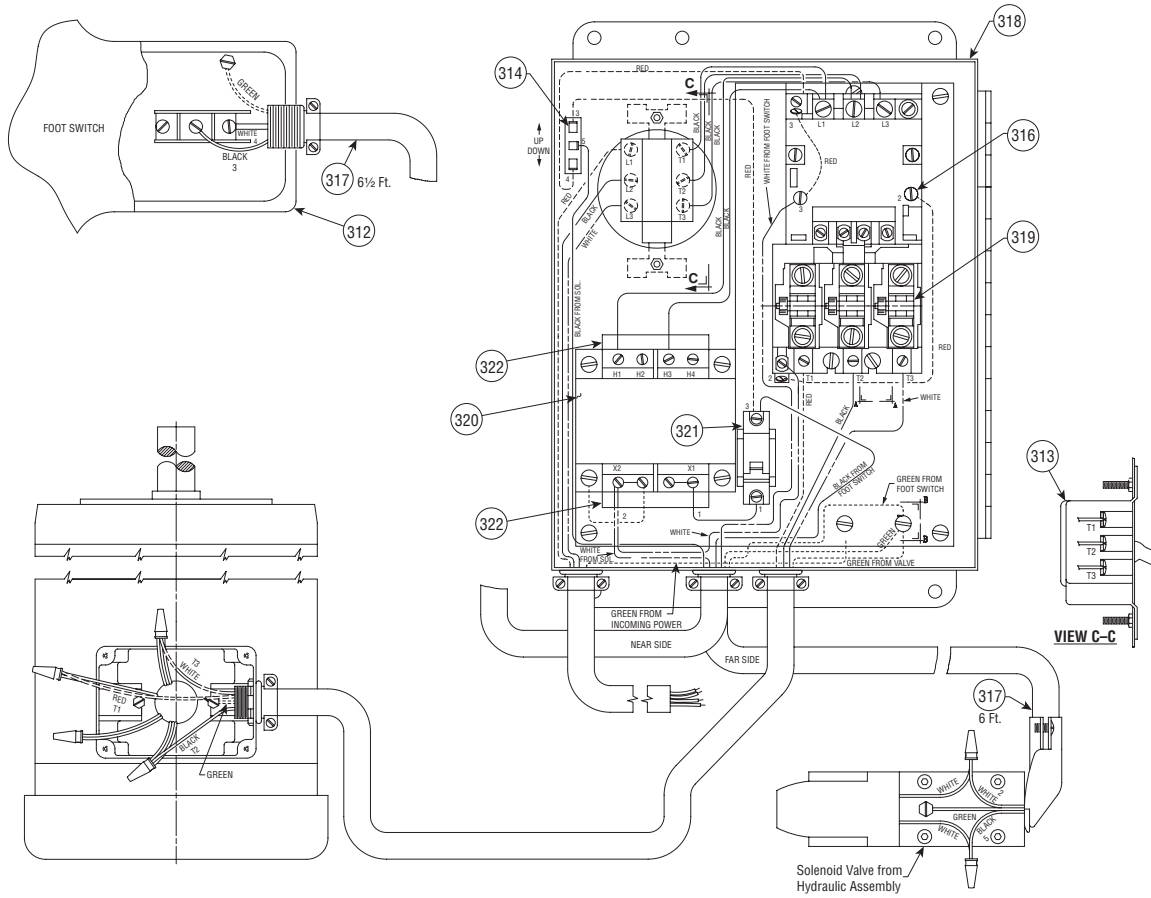
ELECTRICAL SCHEMATIC



INCOMING POWER REQUIREMENTS
 230 or 460 Volt 3 Phase 60 Hz
 8.8 Amp Full Load @ 230 Volts
 4.4 Amp Full Load @ 460 Volts
 Incoming power must be short circuit protected by breaker or fuse.

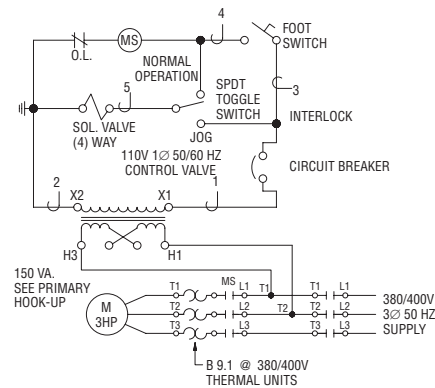


VE269 PREVIOUS ELECTRICAL ASSEMBLY

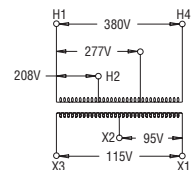


Item #	Part #	Qty.	Description
312	N-E03-000-002	1	Footswitch
313	N-E02-000-028	1	Switch
314	N-E02-000-008	1	Switch
315	R-090-424-LAB	1	Electrical Danger Label (Not Shown)
316	N-E11-000-002	1	Magnetic Starter
317	-	12 1/2 ft.	Line Cord, #16/3 Type 50 Neoprene
318	R-338-274-VE0	Ref.	Electrical Box
319	N-E11-000-007	3	Heater
320	N-E10-000-007	1	Transformer
321	N-E15-000-005	1	Circuit Breaker
322	N-E90-000-013	1	Transformer Guard

ELECTRIC SCHEMATIC



INCOMING POWER REQUIREMENTS
 380 Volt 3 Phase 50 Hz
 5.1 Amp Full Load @ 380 Volts
 5.7 Amp (1.15 S.F.) 380 Volt @ 50 Hz
 Incoming power must be short circuit protected by breaker or fuse.

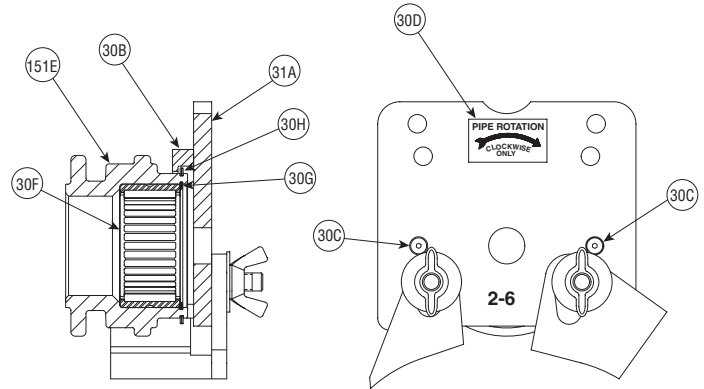


TRANSFORMER CONNECTIONS

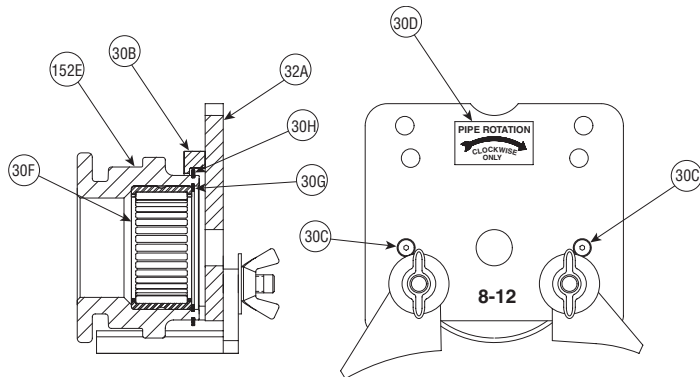
ADDITIONAL ROLL SETS

Item #	Part #	Qty.	Description
151	R-XA2-268-U06	1	Upper Roll Cover/Guard Assembly
31A	R-510-268-WLD	1	Upper Roll Guard
30B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
30C	N-S09-008-010	2	#8-32 UNC x 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
30D	R-040-416-LAB	1	Pipe Rotation Label
151E *	R-X02-272-U06	1	2" - 6" Upper Roll for Stainless Steel Pipe
30F	N-B02-200-001	1	Needle Bearing
30G	N-T03-000-014	1	Snap Ring
30H	N-T03-000-022	1	Snap Ring
159J	R-X02-272-L03	1	2 - 3 1/2" Lower Roll for Stainless Steel Pipe (not shown)
159K	R-X04-272-L06	1	4 - 6" Lower Roll for Stainless Steel Pipe (not shown)

* Not a saleable item – assembly must be ordered.



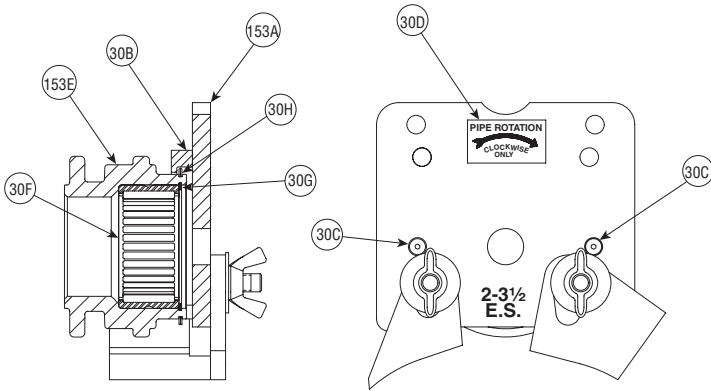
**UPPER ROLL COVER/GUARD ASSEMBLY
FOR 2 - 6" SCHEDULE 5S/10S
STAINLESS STEEL PIPE
(Item 151)**



**UPPER ROLL COVER/GUARD ASSEMBLY
FOR 8 - 12" SCHEDULE 5S/10S
STAINLESS STEEL PIPE
(Item 152)**

Item #	Part #	Qty.	Description
152	R-XA8-268-U12	1	Upper Roll Cover/Guard Assembly
32A	R-520-268-WLD	1	Upper Roll Guard
30B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
30C	N-S09-008-010	2	#8-32 UNC x 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
30D	R-040-416-LAB	1	Pipe Rotation Label
152E *	R-X08-272-U12	1	8" - 12" Upper Roll for Stainless Steel Pipe
30F	N-B02-200-001	1	Needle Bearing
30G	N-T03-000-014	1	Snap Ring
30H	N-T03-000-022	1	Snap Ring
160J	R-X08-272-L12	1	8 - 12" Lower Roll for Stainless Steel Pipe (not shown)

* Not a saleable item – assembly must be ordered.



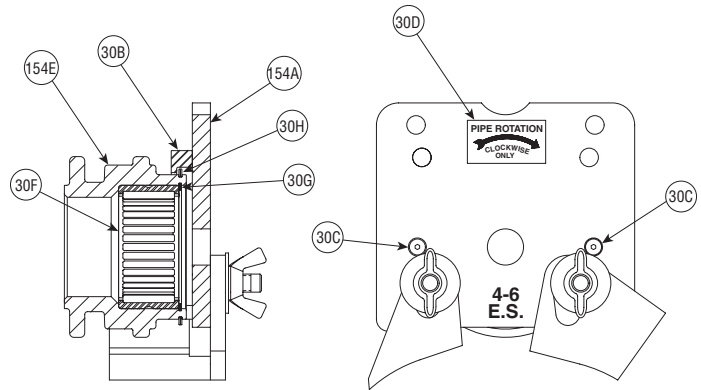
Item #	Part #	Qty.	Description
153	R-ZA2-268-U03	1	Upper Roll Cover/Guard Assembly
153A	R-Z00-268-WLD	1	Upper Roll Guard
30B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
30C	N-S09-008-010	2	#8-32 UNC x 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
30D	R-040-416-LAB	1	Pipe Rotation Label
153E *	R-Z02-272-U03	1	2" - 3 1/2" Upper Roll for EndSeal® Pipe
30F	N-B02-200-001	1	Needle Bearing
30G	N-T03-000-014	1	Snap Ring
30H	N-T03-000-022	1	Snap Ring
153J	R-Z02-272-L03	1	2" - 3 1/2" Lower Roll for EndSeal Pipe (Not Shown)

* Not a saleable item – assembly must be ordered.

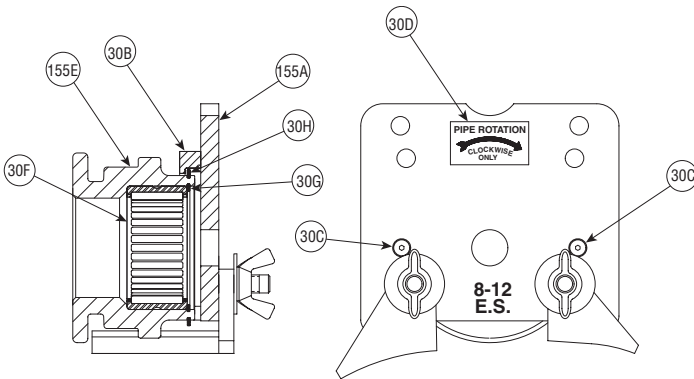
UPPER ROLL COVER/GUARD ASSEMBLY FOR 2 - 3 1/2" ENDSEAL PIPE (Item 153)

Item #	Part #	Qty.	Description
154	R-ZA4-268-U06	1	Upper Roll Cover/Guard Assembly
154A	R-Z10-268-WLD	1	Upper Roll Guard
30B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
30C	N-S09-008-010	2	#8-32 UNC x 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
30D	R-040-416-LAB	1	Pipe Rotation Label
154E *	R-Z04-272-U06	1	4" - 6" Upper Roll for EndSeal Pipe
30F	N-B02-200-001	1	Needle Bearing
30G	N-T03-000-014	1	Snap Ring
30H	N-T03-000-022	1	Snap Ring
154J	R-Z04-272-L06	1	4" - 6" Lower Roll for EndSeal Pipe (Not Shown)

* Not a saleable item – assembly must be ordered.



UPPER ROLL COVER/GUARD ASSEMBLY FOR 4 - 6" ENDSEAL PIPE (Item 154)



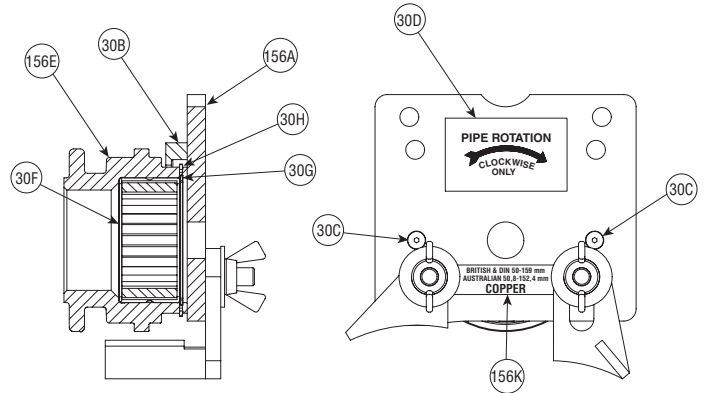
UPPER ROLL COVER/GUARD ASSEMBLY FOR 8 - 12" ENDSEAL PIPE (Item 155)

Item #	Part #	Qty.	Description
155	R-ZA8-268-U12	1	Upper Roll Cover/Guard Assembly
155A	R-Z20-268-WLD	1	Upper Roll Guard
30B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
30C	N-S09-008-010	2	#8-32 UNC x 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
30D	R-040-416-LAB	1	Pipe Rotation Label
155E *	R-Z08-272-U12	1	8" - 12" Upper Roll for EndSeal Pipe
30F	N-B02-200-001	1	Needle Bearing
30G	N-T03-000-014	1	Snap Ring
30H	N-T03-000-022	1	Snap Ring
155J	R-Z08-272-L12	1	8" - 12" Lower Roll for EndSeal Pipe (Not Shown)

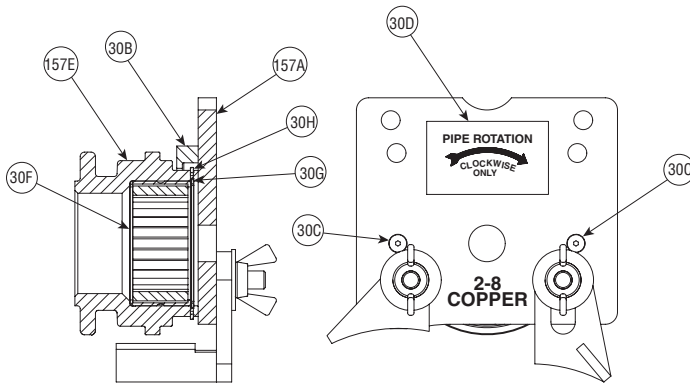
* Not a saleable item – assembly must be ordered.

Item #	Part #	Qty.	Description
156	R-RE1-268-U06	1	Upper Roll Cover/Guard Assembly
156A	R-R00-268-WLD	1	Upper Roll Guard
30B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
30C	N-S09-008-010	2	#8-32 UNC x 7/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
30D	R-040-416-LAB	1	Pipe Rotation Label
156E *	R-RE1-272-U06	1	Upper Roll for Copper Pipe
30F	N-B02-200-001	1	Needle Bearing
30G	N-T03-000-014	1	Snap Ring
30H	N-T03-000-022	1	Snap Ring
156J	R-RE1-272-L06	1	Lower Roll for Copper Pipe (Not Shown)
156K	R-157-272-LBL	1	Roll Guard Cover Label (Export)

* Not a saleable item – assembly must be ordered.



**UPPER ROLL COVER/GUARD ASSEMBLY
FOR 50,8-152,4 mm AUSTRALIAN,
50-159 mm BRITISH/DIN
COPPER PIPE
(Item 156)**



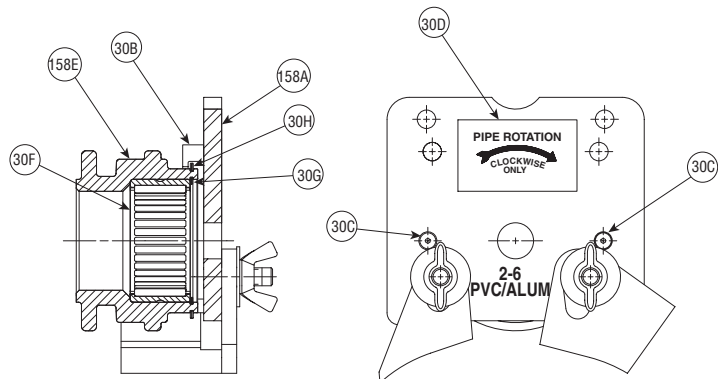
**UPPER ROLL COVER/GUARD ASSEMBLY
FOR 2 - 8" COPPER PIPE
(Item 157)**

Item #	Part #	Qty.	Description
157	R-RA2-268-U08	1	Upper Roll Cover/Guard Assembly
157A	R-R00-268-WLD	1	Upper Roll Guard
30B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
30C	N-S09-008-010	2	#8-32 UNC x 7/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
30D	R-040-416-LAB	1	Pipe Rotation Label
157E *	R-R02-272-U08	1	2" - 8" Upper Roll for Copper Pipe
30F	N-B02-200-001	1	Needle Bearing
30G	N-T03-000-014	1	Snap Ring
30H	N-T03-000-022	1	Snap Ring
157J	R-R02-272-L06	1	2 - 6" Lower Roll for Copper Pipe (Not Shown)
157K	R-R08-272-L08	1	8" Lower Roll for Copper Pipe (Not Shown)

* Not a saleable item – assembly must be ordered.

Item #	Part #	Qty.	Description
158	R-PA2-268-U06	1	Upper Roll Cover/Guard Assembly
158A	R-530-268-WLD	1	Upper Roll Guard
30B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
30C	N-S09-008-010	2	#8-32 UNC x 7/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
30D	R-040-416-LAB	1	Pipe Rotation Label
158E *	R-P02-272-U06	1	2" - 6" Upper Roll for Plastic Pipe
30F	N-B02-200-001	1	Needle Bearing
30G	N-T03-000-014	1	Snap Ring
30H	N-T03-000-022	1	Snap Ring

* Not a saleable item – assembly must be ordered.



**UPPER ROLL COVER/GUARD ASSEMBLY
FOR 2 - 6" PLASTIC PIPE
(Item 158)**



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