

# RP-272FS

## REPAIR PARTS FOR VE272FS 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. VE272FS
2. Tool Serial Number.  
The Serial Number can be found on the side of the tool.
3. Quantity, Item Number, Part Number, Description.  
Example: (2), 49, R-902-272-L03, Lower Roll
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.

#### VICTAULIC<sup>®</sup> IS AN ISO 9001 CERTIFIED COMPANY

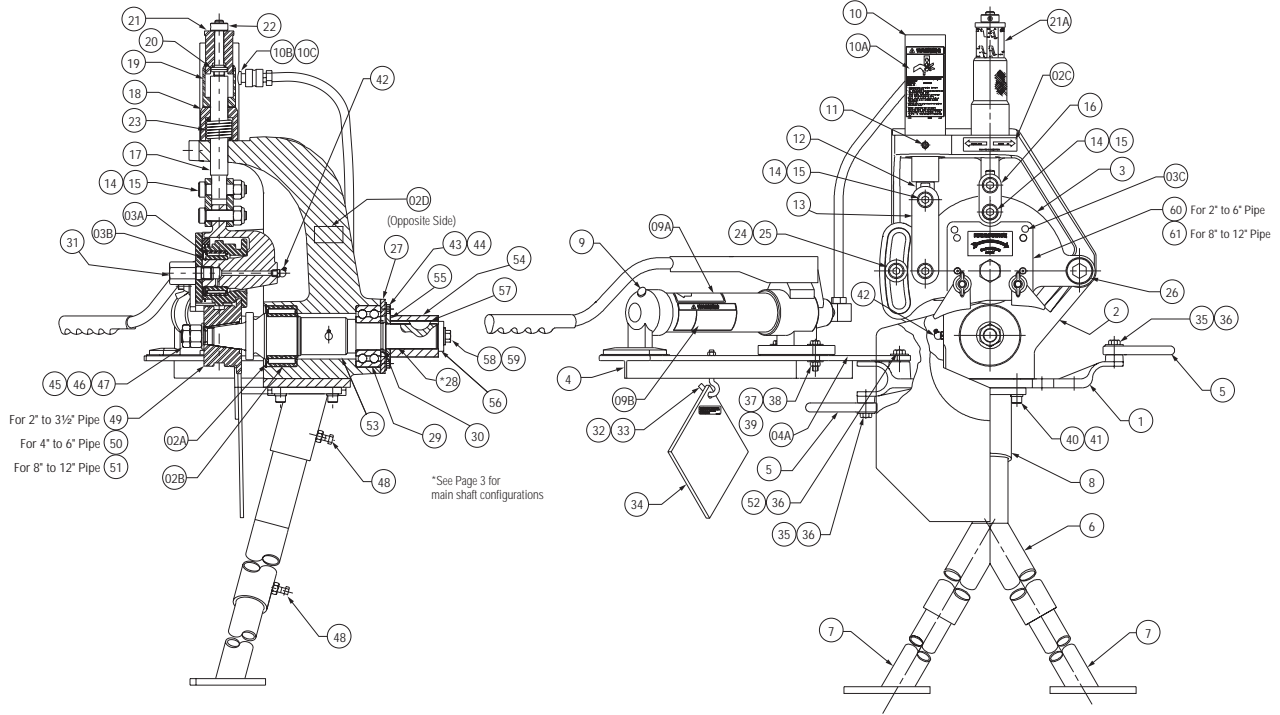
**Victaulic Company of America**  
Phone: 1-800-PICK-VIC (1-800-742-5842)  
Fax: 610-250-8817  
e-mail: pickvic@victaulic.com

**Victaulic Company of Canada**  
Phone: 416-675-5575  
Fax: 416-675-5565  
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

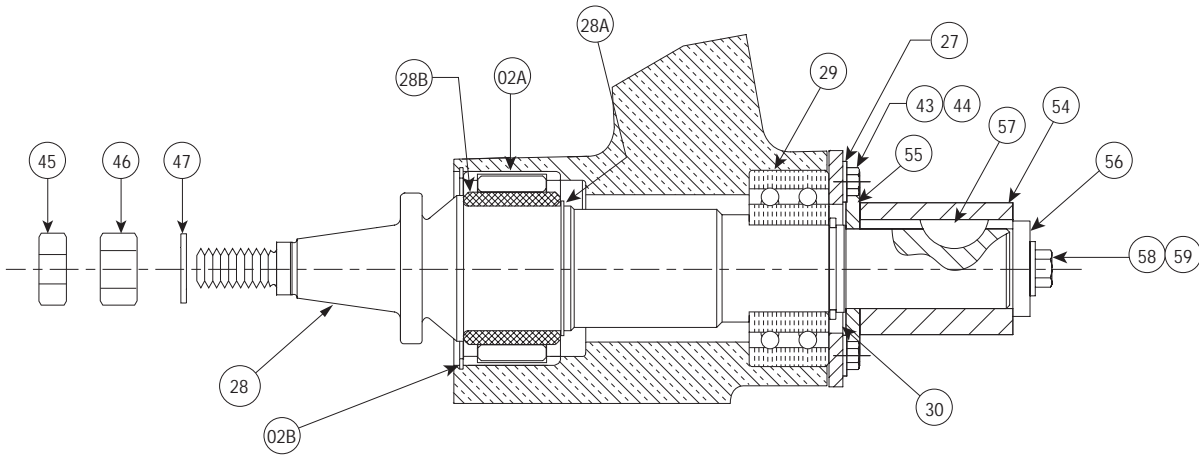
**Victaulic Asia Pacific**  
Phone: 65-6235-3035  
Fax: 65-6235-0535  
e-mail: vicap@victaulic.com



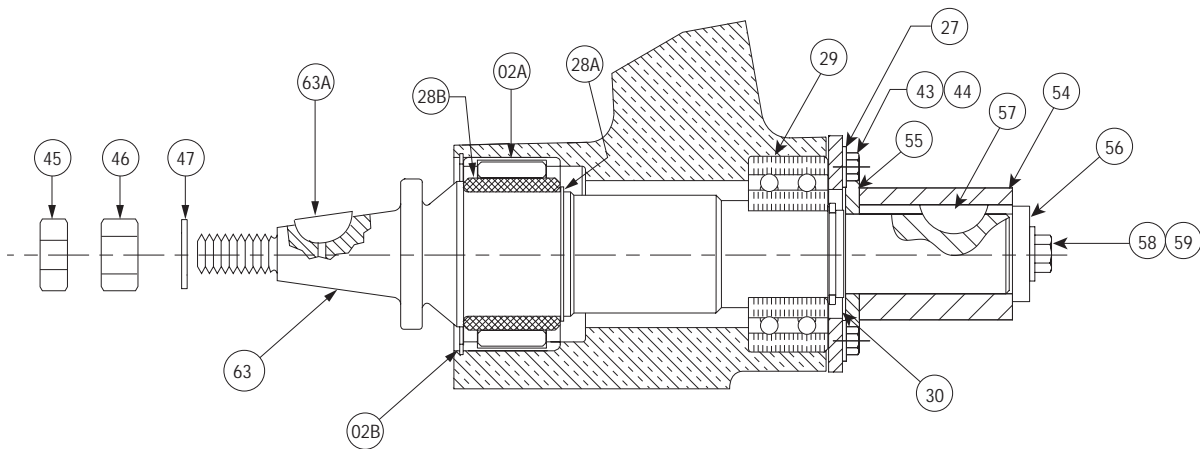
Item #	Part #	Qty.	Description
01	R-001-272-OFS	1	Base
02	R-002-272-OFS	1	Body **
02A	N-B02-275-002	1	Needle Bearing
02B	N-T03-000-015	1	Snap Ring
02C	R-034-272-LAB	1	Depth Stop Adjustment Direction Label
02D	R-069-272-LAB	1	Name Plate
03	R-003-268-MCH	1	Arm **
03A	N-B04-156-002	1	Inner Race
03B	N-T03-000-017	1	Snap Ring
03C	N-P11-006-100	2	Groove Pin
04	R-004-272-ASC	1	Pump Bracket **
04A	R-009-424-LBL	1	"C" Diameter Label for Standard Pipe
05	R-005-272-ASC	2	Base Handle
06	R-006-272-OFS	1	"Y" Upper Leg Support
07	R-007-272-OFS	2	Leg
08	R-008-272-OFS	1	Leg Base with Guard
09	R-201-261-OFS	1	Hydraulic Hand Pump **
09A	R-062-260-OFS	1	Hydraulic Hand Pump Label
09B	R-031-272-LAB	1	Instructions Warning Label
10	N-H01-000-008	1	Hydraulic Cylinder **
10A	R-033-272-LAB	1	Pinch Points Warning Label
10B	N-H50-000-018	1	Ram Half Coupler
10C	N-H50-000-015	1	Dust Cap
11	N-S80-060-008	1	3/8-16 UNC x .50 Lg. Brass Tip Set Screw
12	R-012-272-OFS	1	Cylinder Adapter
13	R-013-272-OFS	2	Link - Cylinder to Arm
14	N-S05-100-110	4	0.625 x 1.625 Lg. Hex Socket Hd. Shoulder Screw per ANSI/ASME B18.3, Blk. Ox.
15	N-N16-080-000	4	1/2-13 UNC Heavy Hex Nylon Insert Lock Nut, Pltd.
16	R-116-268-PLT	2	Link - Depth Adjuster to Arm
17	R-017-272-OFS	1	Depth Adjuster Shaft
18	R-018-272-OFS	1	Depth Adjuster Lock
19	R-019-272-OFS	1	Depth Adjuster
20	R-020-272-OFS	2	Pipe Size Indicator Calibrator
21	R-021-272-OFS	1	Pipe Size Indicator Barrel **
21A	R-122-268-LBL	1	Pipe Size Groove Depth Label
22	N-S95-040-000	1	Collar with Set Screw
23	N-M03-000-015	1	Spring
24	R-025-272-OFS	1	Guide Washer
25	R-019-226-MCH	1	0.625 x 1.000 Lg. Hex Socket Hd. Shoulder Screw, Blk. Ox.

Item #	Part #	Qty.	Description
26	N-S05-160-014	1	1.000 x 0.875 Lg. Hex Socket Hd. Shoulder Screw per ANSI/ASME B18.3, Blk. Ox.
27	R-028-272-OFS	1	Back Cover Plate
28	R-040-272-MCH	1	Main Shaft
29	N-B01-157-002	1	40 mm I.D X 90 mm O.D. Bearing
30	N-T03-000-018	1	Snap Ring
31	R-030-272-OFS	1	Upper Roll Guard Cover Screw
32	N-S40-040-000	1	1/4" X 2.62 Lg. Hook Bolt with 1/4-20 UNC Nut, Pltd.
33	N-N01-040-000	1	1/4-20 UNC Hex Nut, Pltd.
34	R-039-272-OFS	1	Guard Setting Pad Assembly
35	N-S01-060-100	4	3/8-16 UNC x 1.00 Lg. Hex Hd. Screw, Pltd.
36	N-W01-060-000	6	3/8" Flat Washer, Pltd.
37	N-S01-050-108	2	5/16-18 UNC x 1.50 Lg. Hex Hd. Screw, Pltd.
38	N-W01-050-000	4	5/16" Flat Washer, Pltd.
39	N-N01-050-000	2	5/16-18 UNC Hex Nut, Pltd.
40	N-S03-060-108	4	3/8-16 UNC x 1.50 Lg. Skt. Hd. Cap Screw, Blk. Ox.
41	N-W03-060-000	4	3/8" Lock Washer, Pltd.
42	N-M01-000-001	2	65° Grease Fitting, 1/8" NPT
43	N-S01-040-010	4	1/4-20 UNC x 0.62 Lg. Hex Hd. Screw, Pltd.
44	N-W03-040-000	4	1/4" Lock Washer, Pltd.
45	N-W06-120-001	1	3/4" SAE High Strength Flat Washer, Pltd.
46	N-N01-120-000	1	3/4-10 UNC Hex Nut Grade 5, Pltd.
47	N-N03-120-000	1	3/4-10 UNC Hex Jam Nut, Pltd.
48	N-S01-050-012	3	5/16-18 UNC x .75 Lg. Hex Hd. Cap Screw, Grd. 5, Pltd.
49	R-902-272-L03	1	Lower Roll for 2" - 3 1/2" Steel Pipe
50	R-904-272-L06	1	Lower Roll for 4" - 6" Steel Pipe
51	R-908-272-L12	1	Lower Roll for 8" - 12" Steel Pipe
52	N-S01-060-014	2	3/8-16 UNC x .88 Lg. Hex Hd. Screw, Pltd.
53	N-M02-000-001	-	Lubriplate Grease (as required)
54	R-072-272-PLT	1	Drive Lug
55	R-007-416-PLT	1	Drive Lug Flange
56	R-026-416-PLT	1	Drive Lug Retainer
57	N-K01-121-000	1	Woodruff Key, #1210
58	N-S01-080-104	1	1/2-13 UNC X 1.25 Lg. Hex Head Screw, Pltd.
59	N-W03-080-000	1	1/2" Lock Washer, Pltd.
60	R-9A2-268-U06	1	Upper Roll Cover/Guard Assy. for 2" - 6" Steel Pipe
61	R-9A8-268-U12	1	Upper Roll Cover/Guard Assy. for 8" - 12" Steel Pipe
62	R-512-260-VE0	1	Lower Roll Removal Tool (Not Shown)

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



MAIN SHAFT WITH SQUARE DRIVE



MAIN SHAFT WITH WOODRUFF KEY \*\*\*

Item #	Part #	Qty.	Description
28	R-040-272-MCH	1	Main Shaft with Square Drive ** ****
28A	N-T03-000-016	1	Snap Ring
28B	N-B04-225-002	1	Inner Race

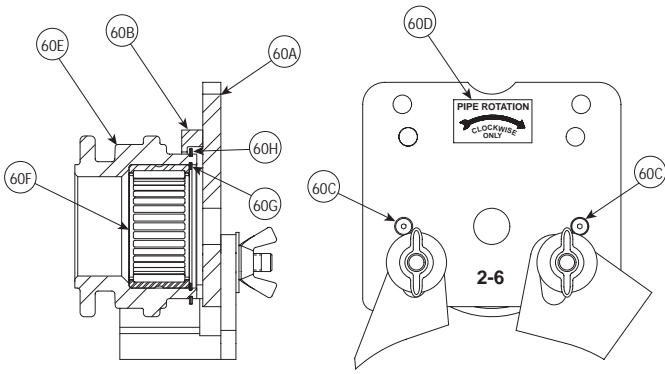
\*\*\*\* Indicates optional part number. R-040-272-KIT includes Item 28 plus 2" - 3", 4" - 6" and 8" - 12" lower rolls.

Item #	Part #	Qty.	Description
63	R-029-272-0FS	1	Main Shaft with Woodruff Key ** ****
63A	N-K01-060-900	1	#609 Woodruff Key
28A	N-T03-000-016	1	Snap Ring
28B	N-B04-225-002	1	Inner Race

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

\*\*\* Discontinued item. Shown only to clarify tool configuration.

\*\*\*\* When upgrading to square drive shaft, lower roll with square drive feature must be used.



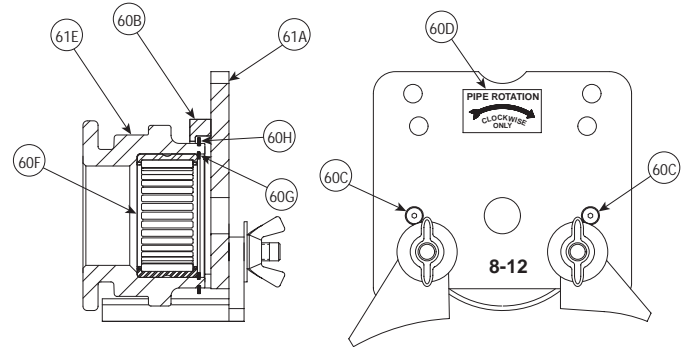
Item #	Part #	Qty.	Description
60	R-9A2-272-U06	1	2" - 6" Upper Roll Cover/Guard Assembly
60A	R-510-268-WLD	1	Upper Roll Guard
60B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
60C	N-S09-008-010	2	#8-32 UNC X 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
60D	R-040-416-LAB	1	Pipe Rotation Label
60E *	R-902-272-U06	1	2" - 6" Upper Roll for Steel Pipe
60F	N-B02-200-001	1	Needle Bearing
60G	N-T03-000-014	1	Snap Ring
60H	N-T03-000-022	1	Snap Ring

\*Not a saleable item – assembly must be ordered.

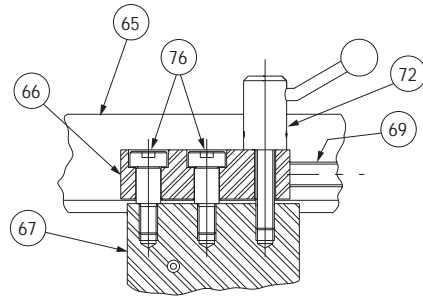
**UPPER ROLL COVER/GUARD ASSEMBLY  
FOR 2 - 6" STEEL PIPE  
(Item 60)**

Item #	Part #	Qty.	Description
61	R-9A8-272-U12	1	8" - 12" Upper Roll Cover/Guard Assembly
61A	R-520-268-WLD	1	Upper Roll Guard
60B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
60C	N-S09-008-010	2	#8-32 UNC X 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
60D	R-040-416-LAB	1	Pipe Rotation Label
61E *	R-908-272-U12	1	8" - 12" Upper Roll for Steel Pipe
60F	N-B02-200-001	1	Needle Bearing
60G	N-T03-000-014	1	Snap Ring
60H	N-T03-000-022	1	Snap Ring

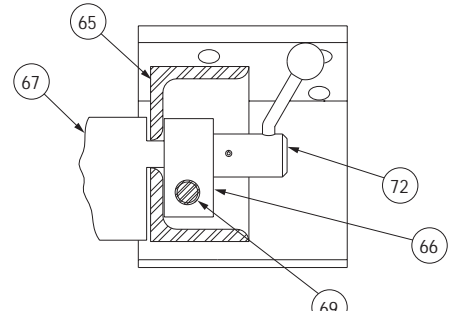
\*Not a saleable item – assembly must be ordered.



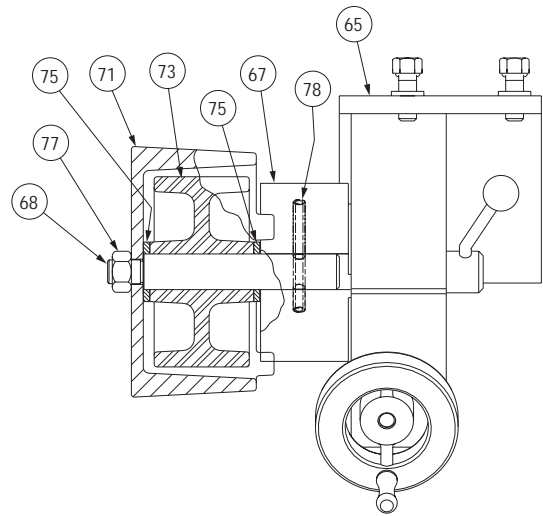
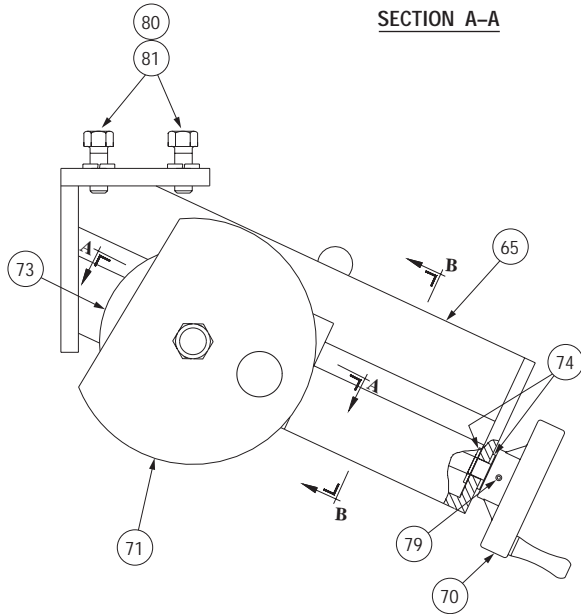
**UPPER ROLL COVER/GUARD ASSEMBLY  
FOR 8 - 12" STEEL PIPE  
(Item 61)**



SECTION A-A



SECTION B-B

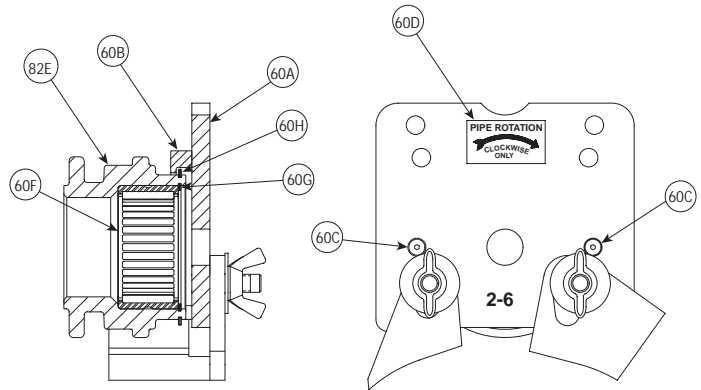


Item #	Part #	Qty.	Description
64	R-400-272-0FS	-	Stablizer Assembly (Optional)
65	R-401-272-0FS	1	Stabilizer Body
66	R-402-416-PLT	1	Stabilizer Guide Nut
67	R-403-416-PLT	1	Stabilizer Guide
68	R-404-416-PLT	1	Stabilizer Wheel Shaft
69	R-405-272-0FS	1	Stabilizer Adjusteel Screw
70	R-406-416-MAC	1	Stabilizer Handwheel
71	R-407-416-PNT	1	Stabilizer Wheel Guard
72	R-450-416-ASY	1	Locking Handle Assembly
73	N-M05-000-004	1	4" x 2" Polyurethane Wheel
74	N-B05-037-002	2	Thrust Washer
75	N-B05-075-004	2	Thrust Washer
76	N-S05-080-012	2	Socket Head Shoulder Bolt, 1/2" x 0.75 Long, Blk. Ox.
77	N-N02-080-000	1	Hex Nut, 1/2 - 20 UNF, Pltd.
78	N-P01-004-208	1	Roll Pin, 1/4" x 2.50 Long
79	N-P01-002-102	1	Roll Pin, 1/8" x 1.125 Long
80	N-S02-060-100	4	3/8 - 16 UNC Lg. Hex Head Cap Screw, Pltd.
81	N-W03-060-000	4	3/8" Lock Washer, Pltd.

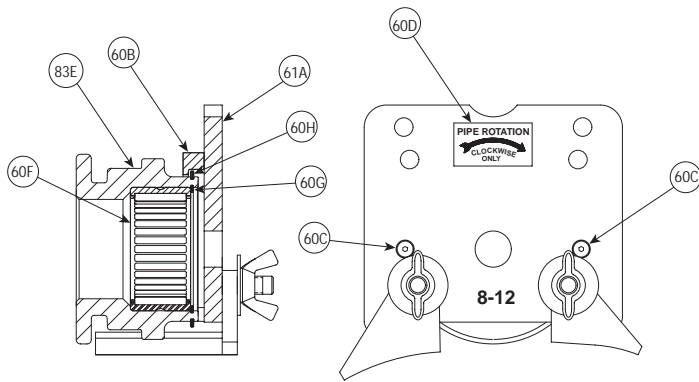
# ADDITIONAL ROLL SETS

Item #	Part #	Qty.	Description
82	R-XA2-268-U06	1	Upper Roll Cover/Guard Assembly
60A	R-510-268-WLD	1	Upper Roll Guard
60B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
60C	N-S09-008-010	2	#8-32 UNC X 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
60D	R-040-416-LAB	1	Pipe Rotation Label
82E *	R-X02-272-U06	1	2" - 6" Upper Roll for Stainless Steel Pipe
60F	N-B02-200-001	1	Needle Bearing
60G	N-T03-000-014	1	Snap Ring
60H	N-T03-000-022	1	Snap Ring
82J	R-X02-272-L03	1	2 - 3 1/2" Lower Roll for Stainless Steel Pipe (not shown)
82K	R-X04-272-L06	1	4 - 6" Lower Roll for Stainless Steel Pipe (not shown)

\*Not a saleable item – assembly must be ordered.



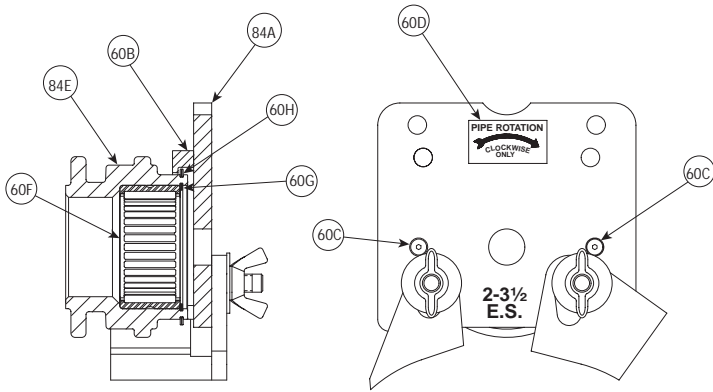
**UPPER ROLL COVER/GUARD ASSEMBLY  
FOR 2 - 6" SCHEDULE 5S/10S  
STAINLESS STEEL PIPE  
(Item 82)**



**UPPER ROLL COVER/GUARD ASSEMBLY  
FOR 8 - 12" SCHEDULE 5S/10S  
STAINLESS STEEL PIPE  
(Item 83)**

Item #	Part #	Qty.	Description
83	R-XA8-268-U12	1	Upper Roll Cover/Guard Assembly
61A	R-520-268-WLD	1	Upper Roll Guard
60B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
60C	N-S09-008-010	2	#8-32 UNC X 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
60D	R-040-416-LAB	1	Pipe Rotation Label
83E *	R-X08-272-U12	1	8" - 12" Upper Roll for Stainless Steel Pipe
60F	N-B02-200-001	1	Needle Bearing
60G	N-T03-000-014	1	Snap Ring
60H	N-T03-000-022	1	Snap Ring
83J	R-X08-272-L12	1	8 - 12" Lower Roll for Stainless Steel Pipe (not shown)

\*Not a saleable item – assembly must be ordered.



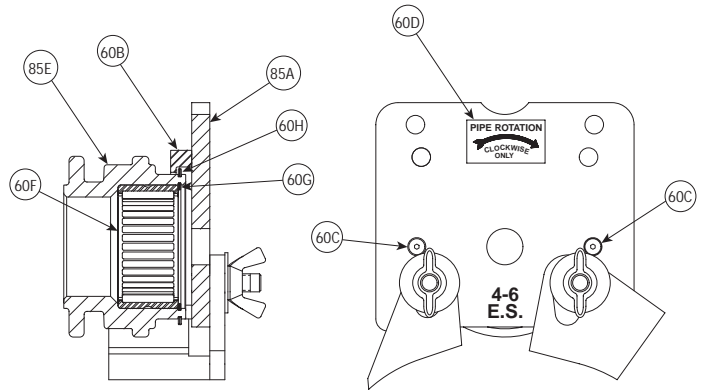
Item #	Part #	Qty.	Description
84	R-ZA2-268-U03	1	Upper Roll Cover/Guard Assembly
84A	R-Z00-268-WLD	1	Upper Roll Guard
60B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
60C	N-S09-008-010	2	#8-32 UNC X 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
60D	R-040-416-LAB	1	Pipe Rotation Label
84E *	R-Z02-272-U03	1	2" - 3 1/2" Upper Roll for EndSeal® Pipe
60F	N-B02-200-001	1	Needle Bearing
60G	N-T03-000-014	1	Snap Ring
60H	N-T03-000-022	1	Snap Ring
84J	R-Z02-272-L03	1	2" - 3 1/2" Lower Roll for EndSeal Pipe (Not Shown)

\*Not a saleable item – assembly must be ordered.

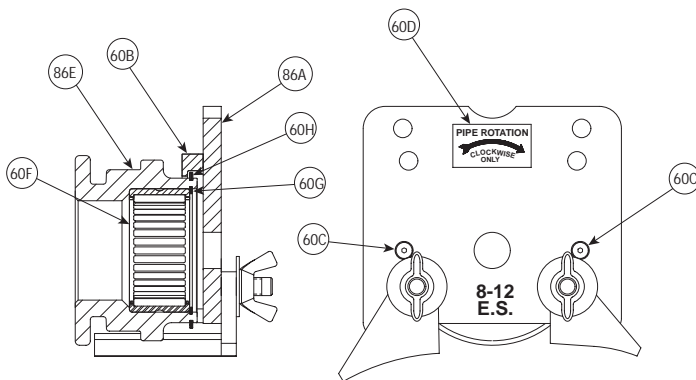
**UPPER ROLL COVER/GUARD ASSEMBLY  
FOR 2 - 3 1/2" ENDSEAL PIPE  
(Item 84)**

Item #	Part #	Qty.	Description
85	R-ZA4-268-U06	1	Upper Roll Cover/Guard Assembly
85A	R-Z10-268-WLD	1	Upper Roll Guard
60B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
60C	N-S09-008-010	2	#8-32 UNC X 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
60D	R-040-416-LAB	1	Pipe Rotation Label
85E *	R-Z04-272-U06	1	4" - 6" Upper Roll for EndSeal Pipe
60F	N-B02-200-001	1	Needle Bearing
60G	N-T03-000-014	1	Snap Ring
60H	N-T03-000-022	1	Snap Ring
85J	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 85)**



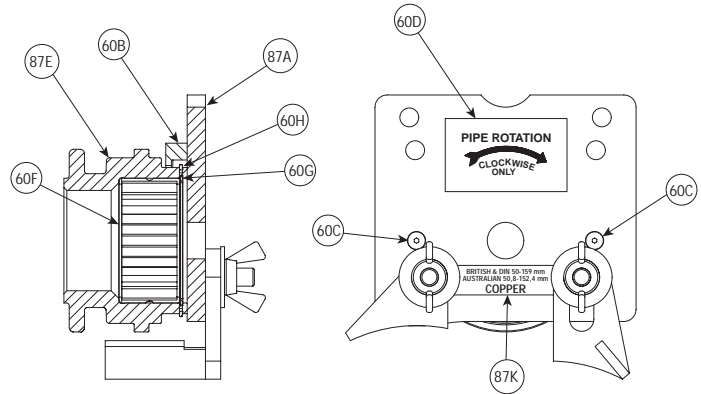
**UPPER ROLL COVER/GUARD ASSEMBLY  
FOR 8 - 12" ENDSEAL PIPE  
(Item 86)**

Item #	Part #	Qty.	Description
86	R-ZA8-268-U12	1	Upper Roll Cover/Guard Assembly
86A	R-Z20-268-WLD	1	Upper Roll Guard
60B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
60C	N-S09-008-010	2	#8-32 UNC X 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
60D	R-040-416-LAB	1	Pipe Rotation Label
86E *	R-Z08-272-U12	1	8" - 12" Upper Roll for EndSeal Pipe
60F	N-B02-200-001	1	Needle Bearing
60G	N-T03-000-014	1	Snap Ring
60H	N-T03-000-022	1	Snap Ring
86J	R-Z08-272-L12	1	8" - 12" Lower Roll for EndSeal Pipe (Not Shown)

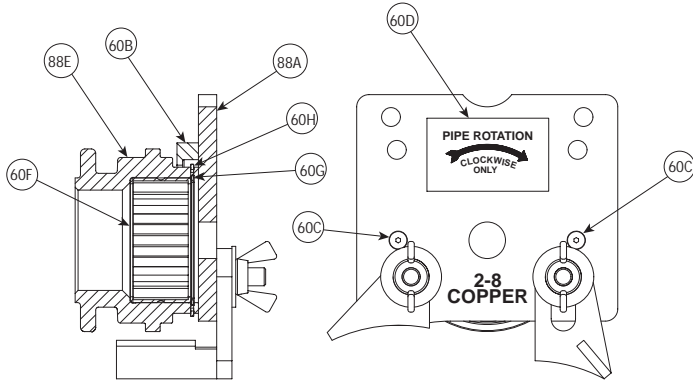
\*Not a saleable item – assembly must be ordered.

Item #	Part #	Qty.	Description
87	R-RE1-268-U06	1	Upper Roll Cover/Guard Assembly
87A	R-R00-268-WLD	1	Upper Roll Guard
60B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
60C	N-S09-008-010	2	#8-32 UNC X 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
60D	R-040-416-LAB	1	Pipe Rotation Label
87E *	R-RE1-272-U06	1	Upper Roll for Copper Pipe
60F	N-B02-200-001	1	Needle Bearing
60G	N-T03-000-014	1	Snap Ring
60H	N-T03-000-022	1	Snap Ring
87J	R-RE1-272-L06	1	Lower Roll for Copper Pipe (Not Shown)
87K	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 87)**



**UPPER ROLL COVER/GUARD ASSEMBLY  
FOR 2 - 8" COPPER PIPE  
(Item 88)**

Item #	Part #	Qty.	Description
88	R-RA2-268-U08	1	Upper Roll Cover/Guard Assembly
88A	R-R00-268-WLD	1	Upper Roll Guard
60B	R-102-272-0FS	1	Upper Roll Guard Cover Ring
60C	N-S09-008-010	2	#8-32 UNC X 5/8" Lg. Flat Hd. Hex Socket Cap Screw, Blk. Ox.
60D	R-040-416-LAB	1	Pipe Rotation Label
88E *	R-R02-272-U08	1	2" - 8" Upper Roll for Copper Pipe
60F	N-B02-200-001	1	Needle Bearing
60G	N-T03-000-014	1	Snap Ring
60H	N-T03-000-022	1	Snap Ring
88J	R-R02-272-L06	1	2 - 6" Lower Roll for Copper Pipe (Not Shown)
88K	R-R08-272-L08	1	8" Lower Roll for Copper Pipe (Not Shown)

\*Not a saleable item – assembly must be ordered.

**Victaulic® Factory Representatives and Distributor Stocks Worldwide**

Victaulic reserves the right to change product specifications, designs and standard equipment without notice and without obligation.