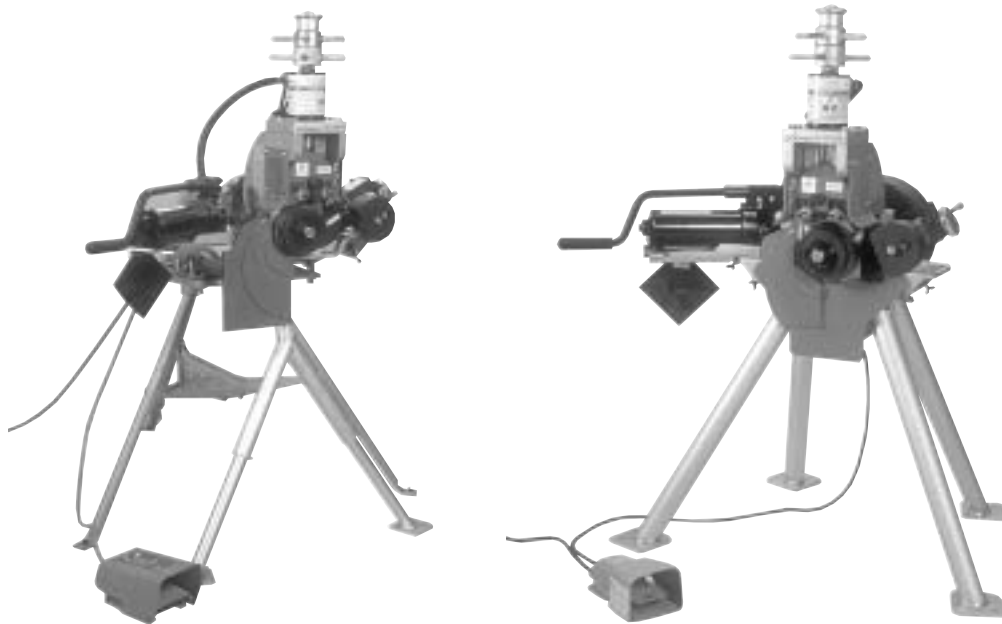


RP-416FS/416FSD

REPAIR PARTS FOR VE416FS & VE416FSD ROLL GROOVING TOOLS

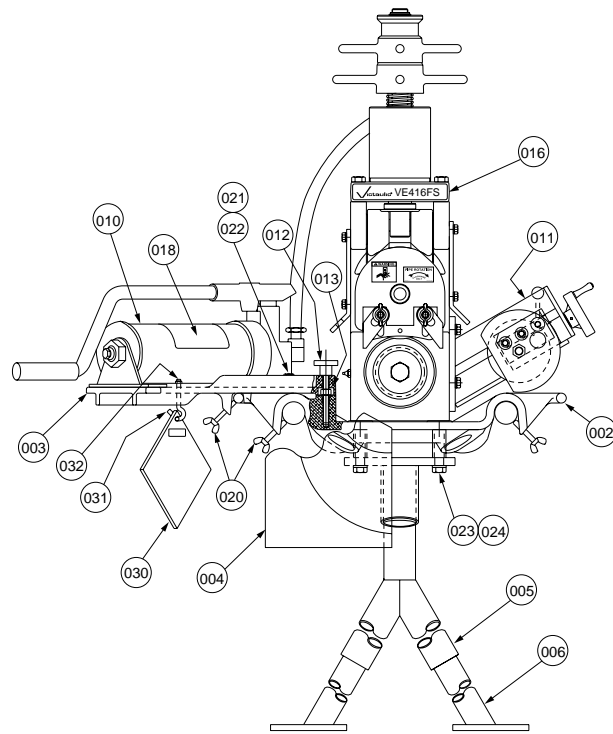
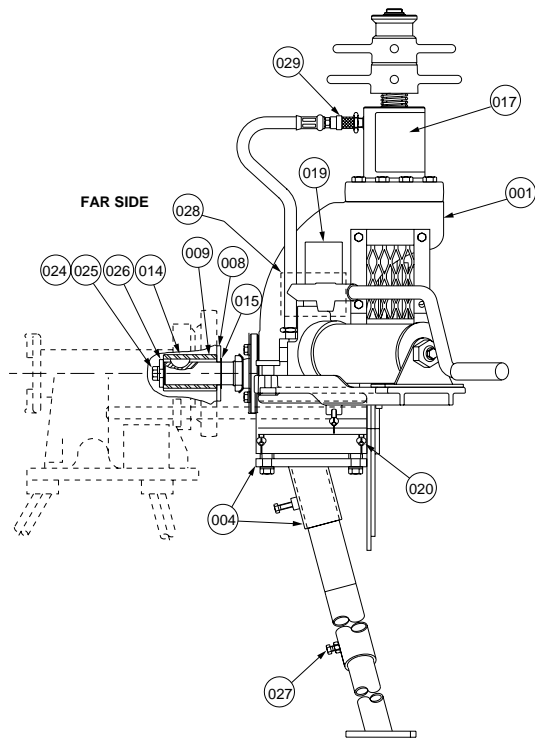


PARTS ORDERING INFORMATION

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

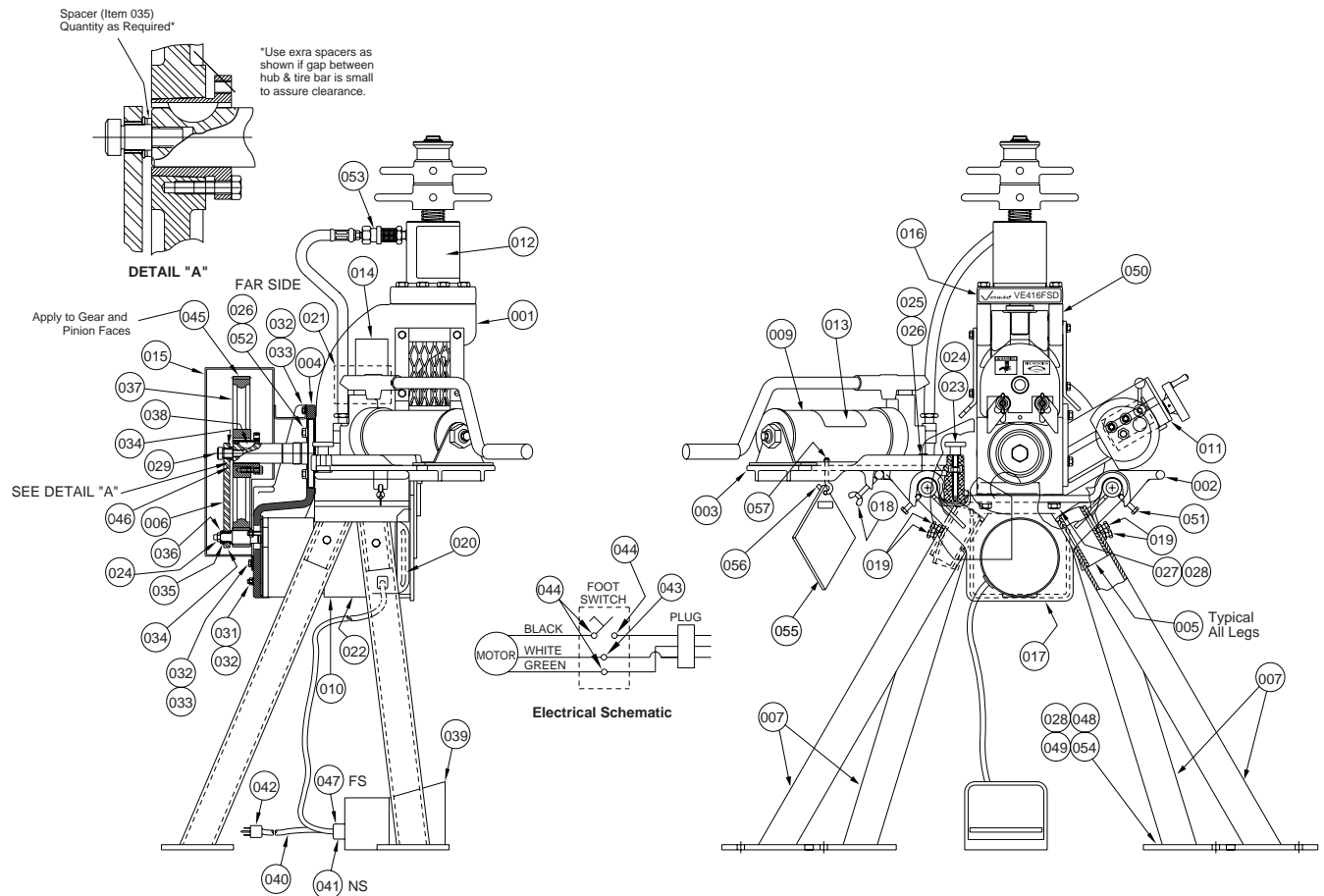
1. Tool Model Number VE416FS
2. Tool Serial Number.
The Serial Number can be found on the back of the tool.
3. Quantity, Item Number, Part Number, Description.
Example: (2), 118, R-148-416-PNT, Roll Guard
4. Where to send the part(s).
Company Name. Address
5. To whose attention to send the part(s).
Person's Name.
6. Purchase Order Number

Parts may be ordered from the nearest Victaulic Distributor, or contact a Victaulic Sales Office. Consult the back page of this manual for the nearest Victaulic Sales Office.



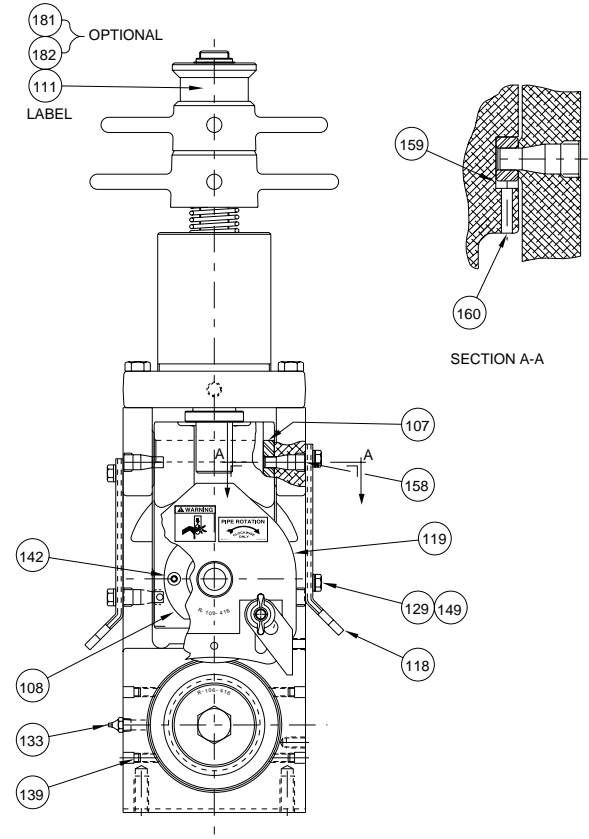
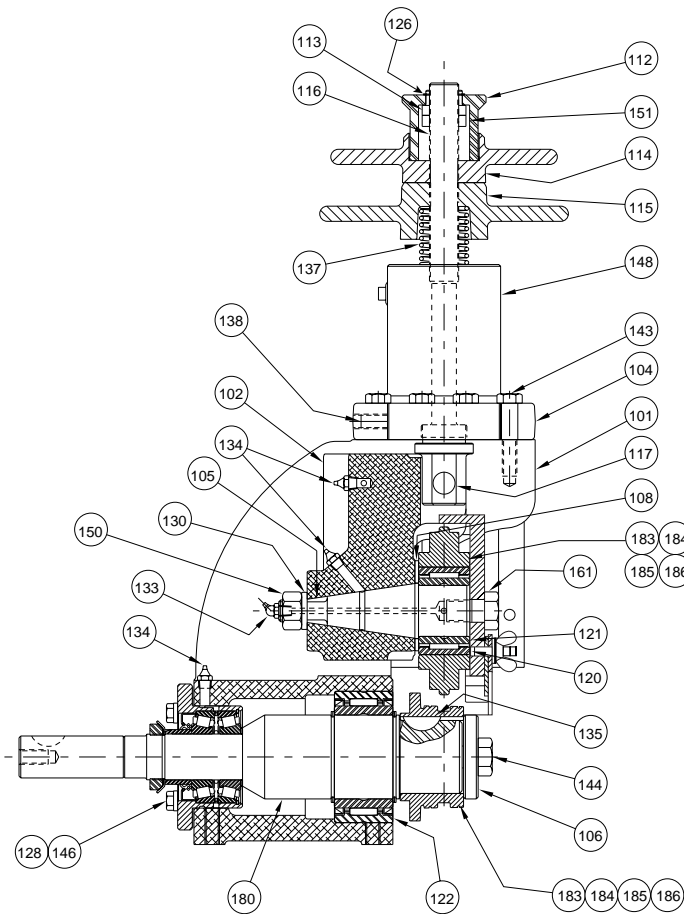
VE416FS MAIN ASSEMBLY TOOL			
Item #	Part #	Qty.	Description
001	R-100-416-VE0	1	VE-416 Tool Head Assembly
002	R-001-416-MAC	1	416FS/416FSD Table
003	R-002-416-MAC	1	416FS/416FSD Pump Support
004	R-028-416-WLD	1	416FS Guard/Mounting Weldment
005	R-006-272-OFS	1	416FS "Y" Upper Leg Support
006	R-007-272-OFS	2	416FS Leg
008	R-007-416-PLT	1	416FS Drive Lug Flange
009	R-008-416-PLT	1	416FS Drive Lug
010	R-201-261-OFS	1	416FS Pump and Hose Assembly
011	R-400-416-VE0	1	VE416 Stabilizer Assembly
012	N-M04-000-004	1	Steel Hand Knob
013	N-N05-060-000	1	3/8 - 16 UNC Elastic Locknut, Thin
014	N-K01-121-000	1	Woodruff Key
015	N-T54-000-143	1	Retaining Ring
016	R-016-416-LAB	1	VE416FS Identification Label
017	R-009-416-LAB	1	VE416FS Instruction Label
018	R-062-260-OFS	1	Hydraulic Hand Pump Label
019	R-009-424-VE0	1	"C" Diameter Label

VE416FS MAIN ASSEMBLY TOOL			
Item #	Part #	Qty.	Description
020	R-010-260-OFS	5	Wing Set Screw
021	N-S01-060-012	2	3/8 - 16 UNC x .75 Long Hex Head Cap Screw, Pltd.
022	N-W03-060-000	2	3/8 Lockwasher , Pltd.
023	N-S01-800-400	4	1/2 - 13 UNC x 4.0 Long Hex Head Cap Screw, Pltd.
024	N-W03-080-000	5	1/2 Lockwasher, Pltd.
025	N-S01-080-104	1	1/2 - 13 UNC x 1.25 Long Hex Head Cap Screw, Pltd.
026	R-026-416-PLT	1	Drive Lug Retainer
027	N-S01-050-012	2	3/8 - 18 UNC x 0.75 Lg. Grade 5 Hex Hd. Cap Screw, Pltd.
028	R-010-416-LAB	1	Standard Pipe Wall Thickness Label
029	N-H50-000-018	1	Female Connection
030	R-039-272-OFS	1	Guard Setting Pad Assembly
031	N-S40-040-000	1	Hook Bolt 1/4 - 20 x 2.63 Lg.
032	N-N01-040-000	1	1/4 - 20 UNC Hex Nut, Pltd.



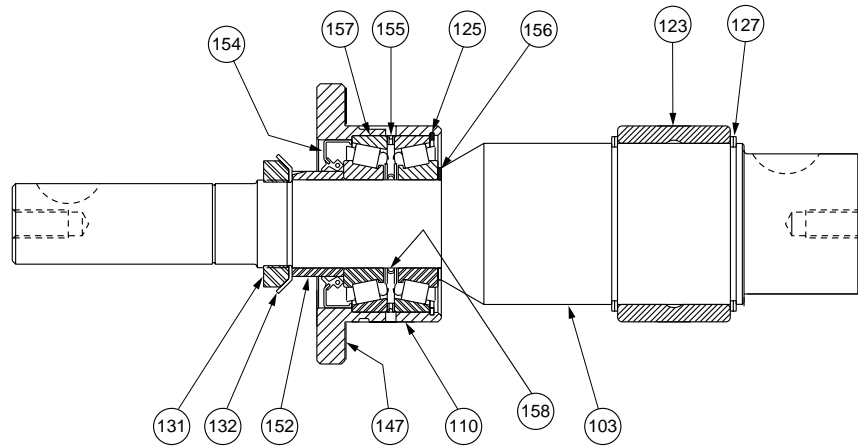
VE416FSD Main Assembly Tool			
Item #	Part #	Qty.	Description
001	R-100-416-VE0	1	VE416 Tool Head Assembly
002	R-001-416-MAC	1	416FS/416FSD Table
003	R-002-416-MAC	1	416FS/416FSD Pump Support
004	R-012-417-MAC	1	VE416FSD Motor Mounting Bracket
005	R-003-416-PLT	4	416FS/416FSD Upper Leg
006	R-014-417-PLT	1	416FSD Tie Bar
007	R-013-417-PLT	4	416FSD Lower Leg
009	R-201-261-0FS	1	VE416FS/VE416FSD Pump and Hose Assembly
010	R-019-417-MAC	1	416FSD Gear Motor
011	R-400-416-VE0	1	VE416 Stabilizer Assembly
012	R-009-416-LAB	1	VE416FS/VE416FSD Instruction Label
013	R-062-260-0FS	1	Hydraulic Hand Pump Label
014	R-009-424-VE0	1	"C" Diameter Label
015	R-015-417-PNT	1	VE416FSD Gear Guard
016	R-021-417-LAB	1	VE416FSD Identification Label
017	R-023-417-PNT	1	416FSD Motor Guard
018	R-010-260-0FS	1	Wing Set Screw
019	N-S02-050-012	4	5/16 - 18 UNC x .75 Lng. Hex Hd. Cap Screw, Pltd.
020	R-020-417-FSD	1	VE416FSD Gear Motor Filter
021	R-010-416-LAB	1	Standard Pipe Wall Thickness Label
022	R-022-417-LAB	1	416FSD Gear Motor Label
023	N-M04-000-004	1	Steel Hand Knob
024	N-N05-060-000	2	3/8 - 16 UNC Locknut, Pltd.
025	N-S01-060-012	2	3/8 - 16 UNC x .75 Lng Hex Hd. Cap Screw, Pltd.
026	N-W03-060-000	6	3/8 Lockwasher, Pltd.
027	N-S01-080-112	4	1/2 - 13 UNC x 1.75 Lng Hex Hd Cap Screw, Pltd.
028	N-W03-080-000	8	1/2 Lockwasher, Pltd.
029	N-S05-100-012	1	0.625 x .75 Long Shoulder Bolt, Blk. Ox.
031	N-N02-040-000	4	1/4 - 28 UNF Hex Nut, Pltd.

VE416FSD Main Assembly Tool			
Item #	Part #	Qty.	Description
032	N-W03-040-000	8	1/4 Lockwasher, Pltd.
033	N-S01-040-010	4	1/4 - 20 UNC x .63 Lg. Hex Head Cap Screw, Pltd.
034	N-B21-062-001	2	Flange Bushing
035	N-B22-062-001	1	Thrust Bushing
036	N-B40-048-001	1	Tongued Washer
037	R-037-417-MAC	1	VE416FSD Roll Groover Spur Gear
038	N-K01-121-000	1	Key
039	N-E03-000-002	1	Footswitch
040	N-E04-000-001	1	Line Cord x 20 Ft. Long
041	N-E06-000-007	1	Connector
042	N-E08-000-003	1	Plug
043	N-E07-000-001	1	Wire Nut
044	N-E05-000-001	4	Wire Terminal
045	N-M02-000-005	as req'd	Lubriplate Gear Shield Heavy (Spray)
046	N-M38-000-001	1	Bushing
047	N-E06-000-035	1	Connector
048	N-N01-080-000	4	1/2 - 13 Standard Hex Nut, Pltd.
049	N-W06-080-000	4	1/2 SAE Flatwasher, Pltd.
050	R-070-260-VE0	1	Copper Groove Label
051	N-S01-050-108	4	5/16 - 18 UNC x 1.50 Long Hex Hd. Cap Screw, Pltd.
052	N-S01-060-104	4	3/8 - 16 UNC x 1.25 Long Hex Hd. Cap Screw, Pltd.
053	N-H50-000-018	1	Female Connection
054	N-S01-080-204	4	1/2 - 13 UNC x 2.25 Lg. Hex Hd. Cap Screw Grd. 5, Pltd.
055	R-039-272-0FS	1	Guard Setting Pad Assembly
056	N-S40-040-000	1	Hook Bolt 1/4 - 20 x 2.63 Lg.
057	N-N01-040-000	1	1/4 - 20 UNC Hex Nut, Pltd.

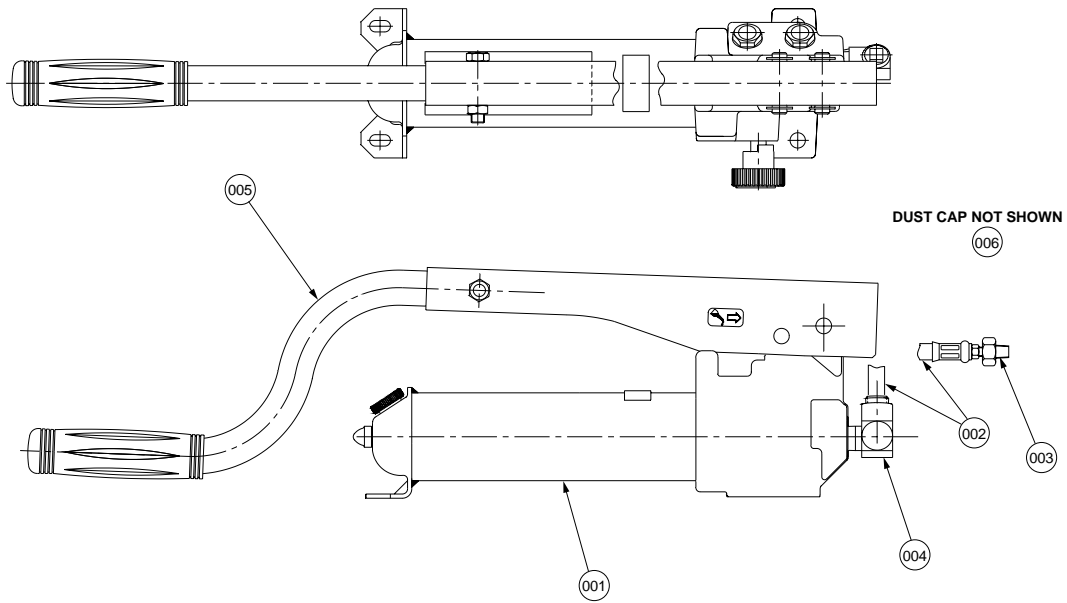


VE416FS/VE416FSD Head Assembly			
Item #	Part #	Qty.	Description
101	R-101-416-MAC	1	Tool Head Housing
102	R-102-416-MAC	1	Slide
104	R-104-416-MAC	1	Cylinder Mounting Block
105	R-105-416-MAC	1	Upper Shaft
106	R-106-416-MAC	1	Lower Roll Washer
107	R-107-416-MAC	2	Gib
108	R-108-416-MAC	1	Upper Roll Thrust Washer
111	R-111-416-VE0	1	Pipe Size Indicator Label
112	R-112-416-PLT	1	Depth Adjuster Barrel
113	R-113-416-PLT	1	Depth Calibration Nut
114	R-114-416-PLT	1	Depth Adjuster
115	R-115-416-PLT	1	Depth Adjuster Lock
116	R-116-416-VE0	1	Cylinder Ram
117	R-117-416-MAC	1	Ram to Slide Pin
118	R-148-416-PNT	2	Roll Guard
119	R-035-416-OFS	1	4 - 16" Roll Guard Assembly
120	N-B02-250-001	Ref.	Roller Bearing (Supplied with Upper Roll)
121	N-B04-175-001	1	Bearing Race
122	N-B02-350-001	1	Roller Bearing
126	N-T52-000-125	1	Retaining Ring
128	N-W03-060-000	4	3/8 Lockwasher, Pltd.
129	N-W03-050-000	6	3/16 Lockwasher, Pltd.
130	N-W03-120-000	1	3/4 Lockwasher, Pltd.
133	N-M01-000-001	2	Lubrication Fitting
134	N-M01-000-002	3	Lubrication Fitting
135	N-K01-080-900	1	Woodruff Key

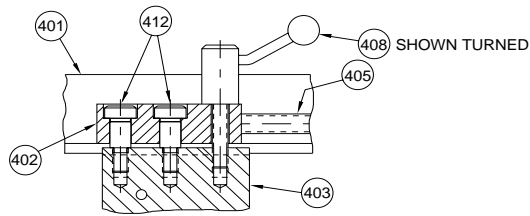
VE416FS/VE416FSD Head Assembly			
Item #	Part #	Qty.	Description
137	N-M03-000-001	1	Compression Spring
138	N-S80-080-100	1	1/2 - 13 UNC x 1.00 Lg. Brass Tip Set Screw
139	N-S81-050-012	4	5/16 - 18 UNC x .75 Lg. Cup Point Set Screw
142	N-S09-010-008	2	10 - 24 UNC x .50 Lg. Flat Head Socket Cap Screw, Blk. Ox.
143	N-S01-080-204	8	1/2 - 13 UNC x 2.25 Lg. Hex Hd. Cap Screw Grd. 5, Pltd.
144	N-S02-120-104	1	3/4 - 10 UNC x 1.25 Lg. Hex Hd. Cap Screw Grd. 8, Pltd.
145	N-M02-000-001	as req'd	Lubriplate
146	N-S01-060-104	4	3/8 - 16 UNC x 1.25 Lg. Hex Head Cap Screw, Pltd.
148	R-162-416-VE0	1	Cylinder
149	N-S01-050-012	6	5/16 - 18 UNC x .75 Lg. Hex Head Cap Screw, Pltd.
150	N-N01-120-000	1	3/4 - 10 UNC Hex Nut, Pltd.
151	R-151-416-PLT	1	Depth Calibration Locknut
158	R-158-416-MAC	4	Gib Screw
159	R-159-416-MAC	2	Gib Wear Plate
160	N-P01-003-100	4	Ø.187 x 1.00 Long Roll Pin
161	R-030-272-OFS	1	Upper Roll Guard Cover Screw
180	R-180-416-VE0	1	Main Shaft Assembly
181	R-181-416-LAB	1	JIS & British Pipe Size Indicator Label
182	R-182-416-LAB	1	DIN Pipe Size Indicator Label
183	R-902-416-003	1	2" - 3 1/2" Std. Roll Set
184	R-904-416-006	1	4" - 6" Std. Roll Set
185	R-908-416-012	1	8" - 12" Std. Roll Set
186	R-914-416-016	1	14" - 16" Std. Roll Set



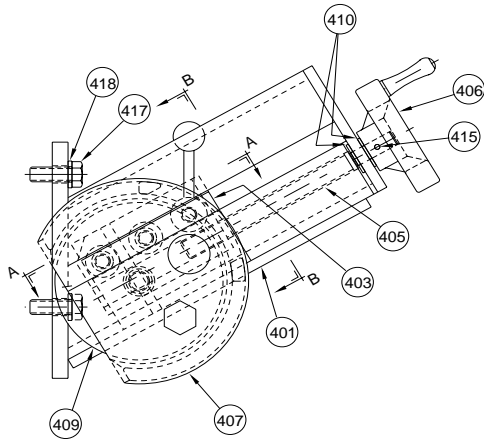
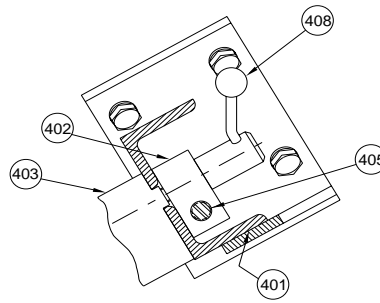
VE416FS/VE416FSD Main Shaft Assembly			
Item #	Part #	Qty.	Description
103	R-103-416-MAC	1	Main Shaft
110	R-110-416-MAC	1	Rear Bearing Housing
123	N-B04-287-001	1	Bearing Race
125	N-T53-000-314	1	Retaining Ring
127	N-T56-000-287	2	Retaining Ring
131	N-B63-000-008	1	Locknut
132	N-B61-000-108	1	Lockwasher
147	N-B70-000-001	1	Shim Kit - Kit Includes (1) 21420, (3) 21407, and (3) 21405
152	R-152-416-MAC	1	Spacer
154	N-M27-000-004	1	Oil Seal
155	R-155-416-MAC	1	Bearing Spacer
156	R-156-416-MAC	1	Main Shaft Spacer
157	N-B09-157-001	2	Tapered Roller Bearing
158	N-M41-000-001	1	Adjustable Spacer



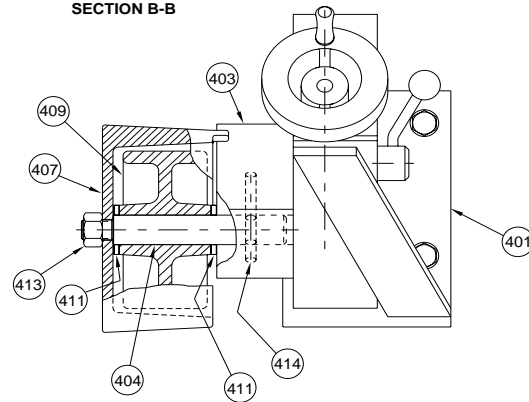
VE416FS/VE416FSD Pump Assembly			
Item #	Part #	Qty.	Description
001	N-H05-000-009	1	Hand Pump
002	N-H02-006-002	1	Hydraulic Hose 25" Long w/ 3/8 NPT Ends
003	N-H50-000-017	1	Male Hose Half Coupler
004	N-H12-006-001	1	Street Elbow 90° - 3/8 NPT
005	N-H50-000-076		Handle with Grip
006	N-H50-000-015	1	Dust Cap



SECTION A-A
ROTATED FOR CLARITY



SECTION B-B



VE416FS/VE416FSD Stabilizer Assembly			
Item #	Part #	Qty.	Description
401	R-401-416-PNT	1	Stabilizer Body
402	R-402-416-PLT	1	Stabilizer Guide Nut
403	R-403-416-PLT	1	Stabilizer Guide
404	R-404-416-MAC	1	Stabilizer Roller Shaft
405	R-405-416-MAC	1	Stabilizer Adjusting Screw
406	R-406-416-MAC	1	Stabilizer Hand Wheel
407	R-407-416-PNT	1	Stabilizer Wheel Guard
408	R-450-416-MAC	1	Stabilizer Locking Handle Assembly
409	N-M05-000-004	1	Ø 4 x 2 Polyurethane Wheel
410	N-B05-037-002	2	Thrust Washer
411	N-B05-075-004	2	Thrust Washer
412	N-S05-080-012	2	Socket Head Shoulder Bolt Ø.50 x .75 Long, Blk. Ox.
413	N-N02-080-000	1	Hex Nut, ½ - 20 UNF, Pltd.
414	N-P01-004-208	1	Roll Pin, Ø.25 x 2.50 Long
415	N-P01-002-102	1	Roll Pin, Ø.125 x 1.125 Long
417	N-S02-060-100	4	¾ - 16 UNC Hex Head Cap Screw x 1.0 Long, Pltd.
418	N-W03-060-000	4	¾ Lockwasher, Pltd.



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Sales & Lease Payments:
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