



Operating and Maintenance Instructions Manual

VAPS112 Pipe Stand



WARNING



Failure to follow instructions and warnings could result in serious personal injury, property damage, and/or product damage.

- Before operating or servicing the VAPS112 Pipe Stand, read all instructions in this manual and all warning labels on the pipe stand.
- Wear safety glasses, hardhat, foot protection, and hearing protection.
- Save this operating and maintenance manual.

If you need additional copies of any literature, or if you have questions concerning the safe and proper operation of this pipe stand, contact Victaulic Tool Company, P.O. Box 31, Easton, PA 18044-0031, Phone: 1-800-PICK VIC, e-mail: pickvic@victaulic.com.

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HAZARD IDENTIFICATION

Definitions for identifying the various hazard levels are provided below.



This safety alert symbol indicates important safety messages. When you see this symbol, be alert to the possibility of personal injury. Carefully read and fully understand the message that follows.

DANGER

- The use of the word “DANGER” identifies an immediate hazard with a likelihood of death or serious personal injury if instructions, including recommended precautions, are not followed.

WARNING

- The use of the word “WARNING” identifies the presence of hazards or unsafe practices that could result in death or serious personal injury if instructions, including recommended precautions, are not followed.

CAUTION

- The use of the word “CAUTION” identifies possible hazards or unsafe practices that could result in personal injury and product or property damage if instructions, including recommended precautions, are not followed.

NOTICE

- The use of the word “NOTICE” identifies special instructions that are important but not related to hazards.

OPERATOR SAFETY INSTRUCTIONS

The VAPS112 is designed only for supporting pipe to be roll grooved. Use of this pipe stand requires dexterity and mechanical skills, as well as sound safety habits. Although this pipe stand is manufactured for safe, dependable operation, it is impossible to anticipate the combinations of circumstances that could result in an accident. The following instructions are recommended for safe operation of this pipe stand. The operator is cautioned to always practice "safety first" during each phase of use, including setup and maintenance. It is the responsibility of the owner, lessee, or user of this pipe stand to ensure that all operators read this manual and are fully trained to operate this pipe stand.

Read this manual before operating or servicing this pipe stand. Become familiar with the pipe stand's operations, applications, and limitations. Be particularly aware of its specific hazards. Store this manual in a clean area where it is always readily available. Additional copies of this manual are available upon request through the Victaulic Tool Company.

GENERAL

- 1. Avoid dangerous environments.** Keep work area well lit. Allow sufficient space to operate tool and accessories properly and for others to pass safely.
- 2. This pipe stand is designed ONLY for supporting pipe to be roll grooved for pipe sizes, materials, and wall thicknesses listed in the "Tool Ratings" section on page 11.**
- 3. Inspect the equipment.** Before using the pipe stand, check all moveable parts for any obstructions. Make sure all guards and pipe stand components are installed and secured properly.
- 4. Wear proper apparel.** Do not wear loose clothing, jewelry, or anything that can become entangled in moving parts.
- 5. Wear protective items when working with tools.** Always wear safety glasses, hardhat, foot protection, and hearing protection.

6. Stay alert. Do not operate the tool if you are drowsy from medication or fatigue. Avoid horseplay around the equipment.

7. Keep visitors away from the immediate work area. All visitors should be kept a safe distance from the equipment at all times. When using the pipe stand at elevated locations, the area below must remain clear of other personnel.

8. Keep work areas clean. Keep the work area around the pipe stand clear of any obstructions that could limit the movement of the operator. Clean up any oil or other spills.

9. Do not overreach. Keep your proper footing and balance at all times. Do not reach across the tool or pipe.

10. Keep hands and tools away from grooving rolls during the grooving operation. Grooving rolls can crush or cut fingers and hands.

11. Do not reach inside the pipe end during tool operation.

12. Do not force the tool. Do not force the tool or accessories to perform any functions beyond their capabilities. Do not overload the tool.

13. Maintain tools with care. Keep tools clean at all times to ensure proper and safe performance. Follow the instructions for lubricating tool components.

14. When tools are not in use, store them in a dry, secure place.

15. Use only Victaulic replacement parts and accessories. Use of any other parts may result in a voided warranty, improper operation, and hazardous situations. Refer to the "Parts Ordering Information" section on page 9.

16. Do not remove any labels from the pipe stand. Replace any damaged or worn labels.

INTRODUCTION

NOTICE

- Drawings and/or pictures in this manual may be exaggerated for clarity.
- The pipe stand, along with this operating and maintenance instructions manual, contains trademarks, copyrights, and/or patented features that are the exclusive property of Victaulic Company.

The Victaulic VAPS112 pipe stand is designed specifically for supporting pipe to be roll grooved (1 $\frac{1}{2}$ ' long to full single 20' random). The VAPS112 pipe stand is a self-standing heavy duty unit that 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 the stand.

CAUTION

- This stand is not designed to support fittings for roll grooving.
Failure to follow this instruction could cause damage to the pipe stand.

The VAPS112 pipe stand supports pipe sizes $\frac{3}{4}$ - 12" up to 1075 lbs. (490 kg) in weight. It is designed for direct use with Vic-Easy roll grooving tools.

CAUTION

- This pipe stand must be used ONLY for supporting pipe designated in the "Tool Ratings" section of this manual.
Failure to follow this instruction could cause damage to the pipe stand.

RECEIVING THE PIPE STAND

The VAPS112 pipe stand is shipped completely assembled and packed in a palletized container. Net pipe stand weight is 215 lbs.

Upon receipt of the pipe stand, make sure all necessary parts are included. If any parts are missing, notify the Victaulic Tool Company.

VAPS112 CONTAINER CONTENTS

Qty.	Description
1	Table with one $\frac{5}{16}$ " bolt in each leg
1	Trough assembly consisting of: (1) V-shaped trough (1) Safety chain (1) Height adjusting nut assembly (1) Acme threaded rod (4) Snap-in ball transfers
2	Legs with casters
2	Legs without casters
2	Operating and Maintenance Instructions Manual

PRE-OPERATION

PIPE PREPARATION

Prepare pipe for roll grooving in accordance with the roll grooving tool's Operating Instructions. In addition to the pipe preparation required for roll grooving, inspect the pipe surface where it will contact the stand's ball transfers for dents or surface build-ups. The pipe surface should be free of large dents, accumulations of dirt, rust or grime that may interfere with smooth pipe rotation and/or traversing.



CAUTION

- **This stand is not designed to support fittings for roll grooving.**

Failure to follow this instruction could cause damage to the pipe stand.

Pipe with external axial weld seams can be grooved with the stand. However, the weld bead must be smooth and rounded and at least three times as wide as it is high. It must not exceed $\frac{1}{8}$ " (3,2 mm) in height.

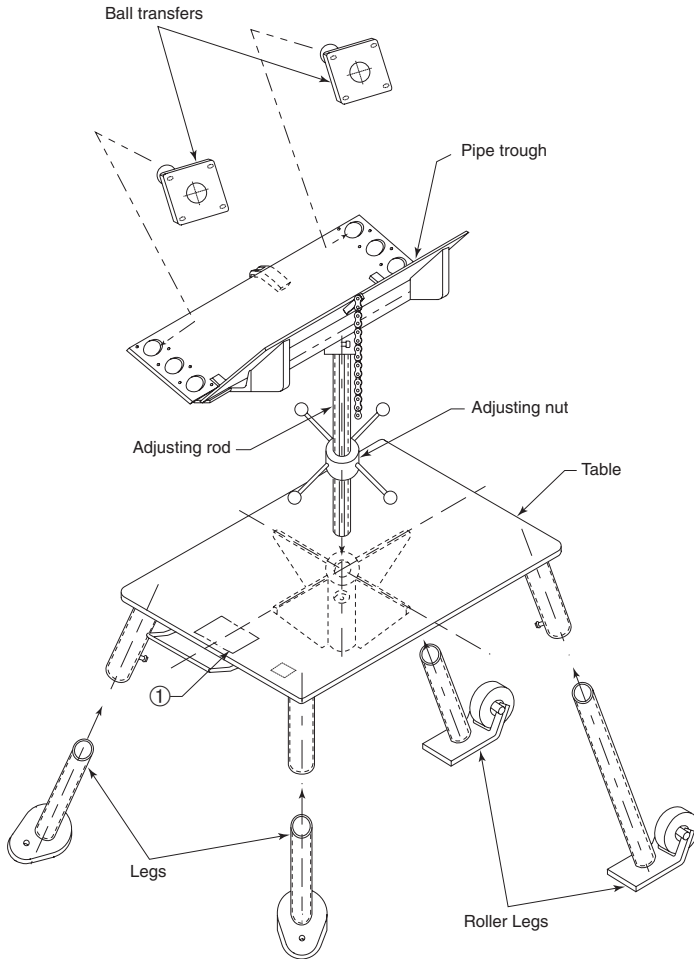
NOTICE

- **Grooving of pipe with external weld seams will shorten stand life.**

TOOL NOMENCLATURE

NOTICE

- Drawings and/or pictures in this manual may be exaggerated for clarity.
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①

⚠ WARNING	
	Failure to follow instructions and warnings can result in serious injury, property damage, or faulty installation.
	• Before installing, operating, or servicing this tool, read and understand the Operating Instructions and all warning labels on this tool.
	• Always wear safety glasses and foot protection.
If you have any questions about the safe operation of this tool, contact Victaulic Tool Company, P.O. Box 31, Easton, PA 18044-0031. 610-555-3300.	

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TOOL AND PIPE STAND SETUP

The VAPS112 pipe stand is designed specifically for supporting pipe to be roll grooved.

Make sure the roll grooving tool is LEVELED and SECURELY FASTENED to the ground or floor. (Refer to the Operating and Maintenance Instructions Manual for the grooving tool.)

PIPE STAND SETUP

1. When grooving pipe that is supported with a pipe stand, select a location for the tool and pipe stand by taking into consideration the following factors:

- 1a.** Adequate space to handle pipe lengths
- 1b.** A firm and level surface for the pipe stand

TOOL SETUP

1. Position the stand in approximate operating location as follows. Always refer to the "Long Pipe Lengths" section in the Operating and Maintenance Instructions Manual for the grooving tool.

- 1a.** Determine the length of the pipe to be roll grooved.
- 1b.** Position the VAPS112 pipe stand at a distance slightly greater than half the pipe length from the tool ($\frac{1}{2}$ pipe length plus 5%).
- 1c.** Position the stand approximately in line with the tool's grooving rolls or slightly to the left.

GROOVING OPERATION

for Initial Stand Adjustments

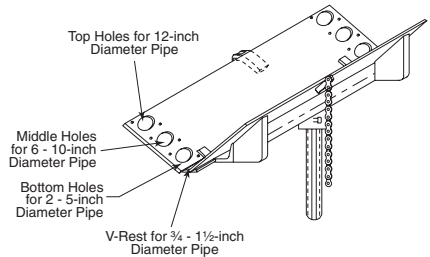
CAUTION

- This pipe stand must be used **ONLY** for roll grooving pipe designated in the "Tool Ratings" section of this manual.
Failure to follow this instruction could cause damage to the pipe stand.

1. Determine the pipe size to be roll grooved.



Position Ball Transfers, as listed below.



- 2.** Position ball transfers to the positions noted for the pipe size to be grooved.
- 3.** Position the pipe stand according to the "Long Pipe Lengths" section in the Operating and Maintenance Instructions Manual for the grooving tool.

WARNING

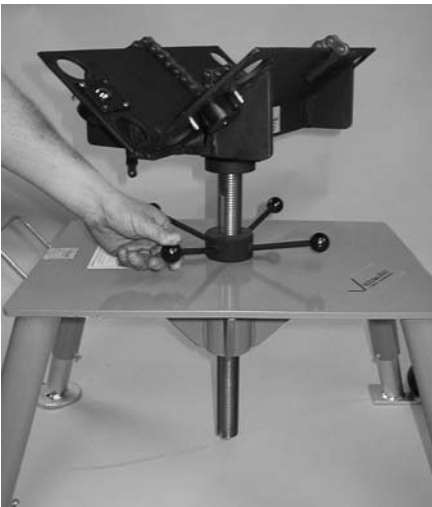
- The pipe stand must be positioned properly to avoid an unbalanced pipe condition.
Failure to follow this instruction could result in damage to the pipe stand or serious personal injury.



4. Adjust the leg height using the height adjusting nut.



4a. Make sure table is level front to back, as shown above.



5. Adjust the V-shaped pipe trough to the approximate height necessary for grooving using the height adjusting nut.



6. Place the pipe on the pipe stand.



7. Connect the safety chain loosely over the top of the pipe.

8. Position the pipe onto the roll grooving tool's lower roll and make the final height adjustment.

CAUTION

- Remove any pipe lifting devices from the pipe before proceeding further.
- Failure to follow this instruction could cause damage to the pipe stand.

9. Move the pipe stand to the position required in the "Long Pipe Lengths" section of the Operating and Maintenance Instructions Manual for the grooving tool. During grooving, if a burr or flare forms at the pipe end, the angle is too great and must be reduced.

10. Groove the pipe by referring to the Operating and Maintenance Instructions Manual for the grooving tool.

11. Release the pipe from the roll grooving tool, rotate the pipe to position the opposite end for grooving. Groove the pipe.



12. Release the safety chain and remove the pipe from the pipe stand.

13. Additional pipe of the same diameter and length can be grooved by repeating steps 5, 6, 9, 10, 11 and 12.

MAINTENANCE

This section provides information about keeping the pipe stand in proper operating condition and guidance for making repairs when it becomes necessary. Preventive maintenance during operation will pay for itself in repair and operating savings.

Replacement parts must be ordered from Victaulic Tool Company to ensure proper and safe operation of the tool.

LUBRICATION



1. Regular lubrication is required for the VAPS112 pipe stand. On a weekly basis, apply a few drops of light oil to the ball transfer units. Work the oil in by rotating the units.



2. On a monthly basis, raise the pipe stand to its maximum height and grease the threaded height adjusting rod by applying #2EP Lithium base grease to the exposed threads.



2a. Work in the grease by lowering the stand to its minimum height.

PARTS ORDERING INFORMATION

When ordering parts, the following information is required for the Victaulic Tool Company to process the order and send the correct part(s). Request the RP-VAPS112 Repair Parts List for detailed drawings and parts listings.

- 1.** Tool Model Number – VAPS112
- 2.** Tool Serial Number – The serial number is stamped onto a plate located on the table
- 3.** Quantity, Part Number, and Description – For example: (1), R-100-112-PS0, Ball Transfers
- 4.** Where to Send the Part(s) – Company name and address
- 5.** To Whose Attention to Send the Part(s)
- 6.** Purchase Order Number

Order parts by calling 1-800-PICKVIC.

TROUBLESHOOTING

GENERAL

Problem	Possible Cause	Solution
Pipe flare is excessive.	Pipe is "over tracking". Pipe height adjustment is too high. Roll grooving tool is tilted forward.	Refer to the Operating and Maintenance Instructions Manual for the grooving tool. Refer to the Operating and Maintenance Instructions Manual for the grooving tool. Refer to the Operating and Maintenance Instructions Manual for the grooving tool.
Pipe face is excessively scuffed.	Pipe is "over tracking".	Refer to the Operating and Maintenance Instructions Manual for the grooving tool.
Pipe will not stay in roll grooving tool.	Insufficient pipe tracking angle. Pipe rotating in the wrong direction. Pipe not square cut. Pipe is below level. Roll grooving tool is tilted forward. Ball transfers are jammed or sticking.	Refer to the Operating and Maintenance Instructions Manual for the grooving tool. Refer to the Operating and Maintenance Instructions Manual for the grooving tool. Cut the pipe end squarely. Refer to the Operating and Maintenance Instructions Manual for the grooving tool. Refer to the Operating and Maintenance Instructions Manual for the grooving tool. Refer to the Operating and Maintenance Instructions Manual for the grooving tool. Clean and lubricate the ball transfers.

TOOL RATINGS

VAPS112

Pipe Size Nominal inches Actual (mm)	Nominal Wall Thickness Dimensions – inches (mm) *							
	Steel Pipe Wall Thickness		Stainless Steel Pipe Wall Thickness		Aluminum Pipe Wall Thickness		PVC Plastic Pipe Wall Thickness	
	Minimum	Maximum	Minimum	Maximum	Minimum	Maximum	Minimum	Maximum
3/4 26,9	0.065 1,7	0.113 2,9	0.065 1,7	0.113 2,9	0.065 1,7	0.113 2,9	0.113 2,9	0.113 2,9
1 33,7	0.065 1,7	0.133 3,4	0.065 1,7	0.133 3,4	0.065 1,7	0.133 3,4	0.133 3,4	0.133 3,4
1 1/4 42,4	0.065 1,7	0.140 3,6	0.065 1,7	0.140 3,6	0.065 1,7	0.0140 3,6	0.140 3,6	0.140 3,6
1 1/2 48,3	0.065 1,7	0.145 3,7	0.065 1,7	0.145 3,7	0.065 1,7	0.145 3,7	0.145 3,7	0.145 3,7
2 60,3	0.065 1,7	0.154 3,9	0.154 3,9	0.154 3,9	0.065 1,7	0.154 3,9	0.154 3,9	0.154 3,9
2 1/2 73,0	0.083 2,1	0.203 5,2	0.203 5,2	0.203 5,2	0.083 2,1	0.203 5,2	0.203 5,2	0.276 7,0
3 88,9	0.083 2,1	0.216 5,5	0.216 5,5	0.216 5,5	0.083 2,1	0.216 5,5	0.216 5,5	0.300 7,6
3 1/2 101,6	0.083 2,1	0.226 5,7	0.226 5,7	0.226 5,7	0.083 2,1	0.226 5,7	0.226 5,7	0.318 8,1
4 114,3	0.083 2,1	0.237 6,0	0.237 6,0	0.237 6,0	0.083 2,1	0.237 6,0	0.237 6,0	0.337 8,6
4 1/2 127,0	0.095 2,4	0.237 6,0	0.237 6,0	0.237 6,0	0.095 2,4	0.237 6,0	- -	- -
5 141,3	0.109 2,8	0.258 6,6	0.258 6,6	0.258 6,6	0.109 2,8	0.258 6,6	0.258 6,6	0.375 9,5
6 O.D. 152,4	0.109 2,8	0.258 6,6	0.258 6,6	0.258 6,6	0.109 2,8	0.258 6,6	- -	- -
6 168,3	0.109 2,8	0.280 7,1	0.280 7,1	0.280 7,1	0.109 2,8	0.280 7,1	0.280 7,1	0.432 11,0
8 O.D. 203,2	0.109 2,8	0.322 8,2	0.250 6,4	0.322 8,2	0.109 2,8	0.322 8,2	0.322 8,2	0.322 8,2
8 219,1	0.109 2,8	0.322 8,2	0.250 6,4	0.322 8,2	0.109 2,8	0.322 8,2	0.322 8,2	0.322 8,2
10 273,0	0.134 3,4	0.250 6,4	0.250 6,4	0.250 6,4	0.134 3,4	0.250 6,4	0.365 9,3	0.365 9,3
12 323,9	0.156 4,0	0.250 6,4	0.250 6,4	0.250 6,4	0.156 4,0	0.250 6,4	0.406 10,3	0.406 10,3

This tool rating table is applicable only to ANSI piping and is based upon the following material grades. Refer to the appropriate international standard for other systems.

Steel – Brinell Hardness Number (BHN) of 180 BHN and less

Stainless Steel – Types 304/304L and 316/316L

Aluminum – Grades 6061-T4 and 6063-T4

PVC Type I, Grade I (PVC 1120)

PVC Type I, Grade II (PVC 1220)

PVC Type II, Grade I (PVC 2116)

* All minimum and maximum wall thicknesses are nominal

VICTAULIC GLOBAL LOCATIONS

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Easton, PA 18044-0031
1-610-559-3300
1-610-923-3090 (fax)
victtools@victaulic.com

TOOL SHIPMENTS

1326 Tatamy Road
Easton, PA 18045-7400

SALES AND LEASE PAYMENTS

P.O. Box 8538-244
Philadelphia, PA 19171-0244

WORLD HEADQUARTERS

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