

VAPS1672 Pipe Stand

**WARNING****WARNING**

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

- Before operating or servicing any grooving tools, read all instructions in this manual and all warning labels on the tool.
- Wear safety glasses, hardhat, foot protection, and hearing protection while working around this tool.
- Save this operating and maintenance manual in a place accessible to all operators of the tool.

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

Original Instructions

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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 VAPS1672 Pipe Stand is designed for the sole purpose of supporting pipe to be roll grooved. These instructions must be read and understood by each operator PRIOR to working with the stand. These instructions describe safe operation of the stand, including set up and maintenance. Each operator must become familiar with the stand’s operations, applications, and limitations. Particular care should be given to reading and understanding the dangers, warnings, and cautions described throughout these operating instructions.

Use of this stand requires dexterity and mechanical skills, as well as sound safety habits. Although this stand is designed and manufactured for safe, dependable operation, it is difficult to anticipate all combinations of circumstances that could result in an accident. The following instructions are recommended for safe operation of this stand. The operator is cautioned to always practice “safety first” during each phase of use, including set up and maintenance. It is the responsibility of the lessee or user of this stand to ensure that all operators read this manual and fully understand the operation of this stand.

Store this manual in a clean, dry area where it is always readily available. Additional copies of this manual are available upon request through Victaulic, or can be downloaded at victaulic.com.

DANGER

1. **Avoid using the pipe stand in potentially dangerous environments.** Do not expose the pipe stand to rain, and do not use the pipe stand in damp or wet locations. Do not use the pipe stand on sloped or uneven surfaces. Keep the work area well lit. Allow sufficient space to operate the pipe stand properly.
2. **Secure the work, stand, and accessories.** Ensure that the pipe stand is stable and well-supported on a level surface, and cannot tip over. Refer to the “Tool Setup” section.

WARNING

1. **Prevent back injury.** Always use proper lifting techniques when handling pipe stand components.
2. **Wear proper apparel.** Do not wear loose clothing, jewelry, or anything that can become entangled in moving parts.
3. **Wear protective items when working with the pipe stand.** Always wear safety glasses, hardhat, foot protection, and hearing protection.
4. **Keep hands and tools away from the pipe stand while pipe is being loaded, rotated, and positioned on the pipe stand.** Pipe can crush or cut fingers and hands.
5. **Do not reach inside pipe ends during tool operation.** Pipe edges can be sharp and can snag hands and shirt sleeves.
7. **Do not over-reach.** Maintain proper balance at all times. Ensure that all controls are easily accessible to the operator.
8. **Do not make any modifications to the pipe stand.** Do not remove any safety guarding or any components that would affect pipe stand performance.

CAUTION

1. **The VAPS1672 pipe stand is designed ONLY for supporting pipe sizes, materials, and wall thicknesses as designated.**
2. **Inspect the equipment.** Before using the pipe stand, check moveable parts for obstructions. Ensure that pipe stand components are installed and adjusted in accordance with setup instructions. Ensure that pipe stand components are stable and secure.
3. **Stay alert.** Do not operate the pipe stand if you are drowsy from medication or fatigue.
4. **Keep visitors, trainees, and observers away from the immediate work area.** All visitors should be kept a safe distance from the equipment at all times.
5. **Keep work areas clean.** Keep the work area around the pipe stand clear of any obstructions that could limit movement of the operator. Clean up any spills on the floor to prevent slips or falls.
6. **Do not force the pipe stand.** Do not force the pipe stand or accessories to perform any functions beyond the capabilities described in these instructions. Do not overload the pipe stand.
7. **Maintain pipe stand with care.** Keep the pipe stand clean to ensure proper and safe performance. Follow the instructions for matching and lubricating pipe stand components, if applicable.
8. **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.
9. **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.

The VAPS1672 Pipe Stand is designed specifically for supporting pipe to be grooved with Victaulic Roll Grooving Tools. This pipe stand incorporates a free-standing base and uses polyethylene wheels for pipe rotation. The polyethylene wheels are mounted to permit the use of pipe slings.

CAUTION

- This pipe stand must be used ONLY for supporting pipe with specifications that fall within the designated parameters.
 - This pipe stand is not designed to support fittings for roll grooving.
- Failure to follow these instructions could damage the pipe stand and cause product failure, resulting in property damage or personal injury.

The VAPS1672 Pipe Stand supports pipe sizes 16–72 inches/406.4–1829-mm (11/2-foot/ 0.5-meter to full, single 20-foot/6-meter random lengths) and has a load rating of 10,000 pounds/4536 kilograms.

- Vertical Stroke - 17 inches/432 mm
- Minimum Pipe Height from Floor - 16 inches/406 mm for 72-inch/1829-mm Pipe
- Maximum Pipe Height from Floor - 28 inches/711 mm for 16-inch/406.4-mm Pipe

RECEIVING THE TOOL

The VAPS1672 Pipe Stand is shipped completely assembled and packaged in a palletized container. Save the original packaging for return shipment of rental tools.

Upon receipt of the pipe stand, ensure that all necessary parts are included. If any parts are missing, contact Victaulic.

CONTAINER CONTENTS

Qty.	Description
1	VAPS1672 Adjustable Pipe Stand
1	Ratchet
4	Polyethylene Wheels
2	Operating and Maintenance Instructions Manual

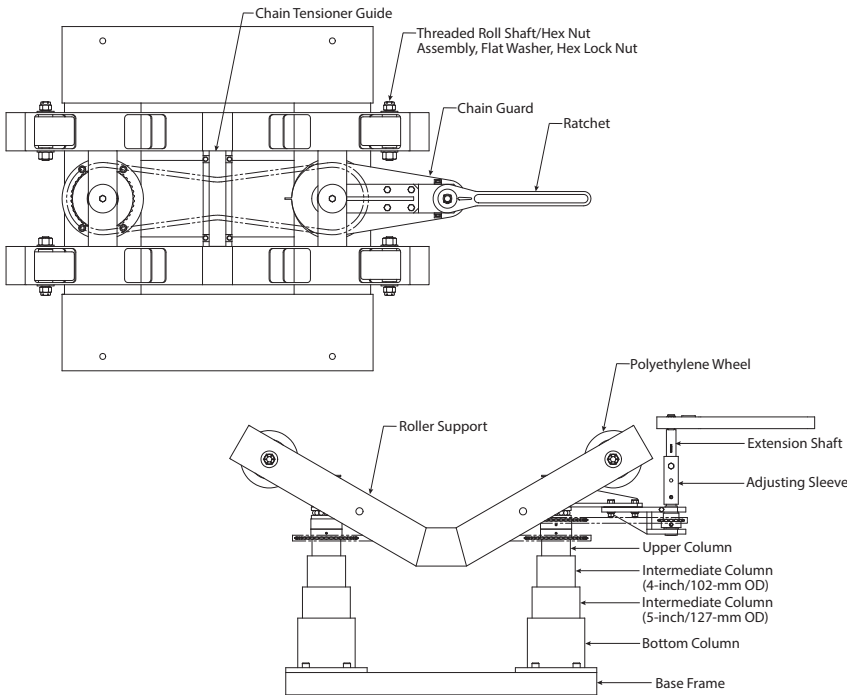
RETURNING THE TOOL

Prepare pipe stand for shipment as received. Contact Victaulic with questions.

TOOL NOMENCLATURE

NOTICE

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



Located on Base Frame

WARNING



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

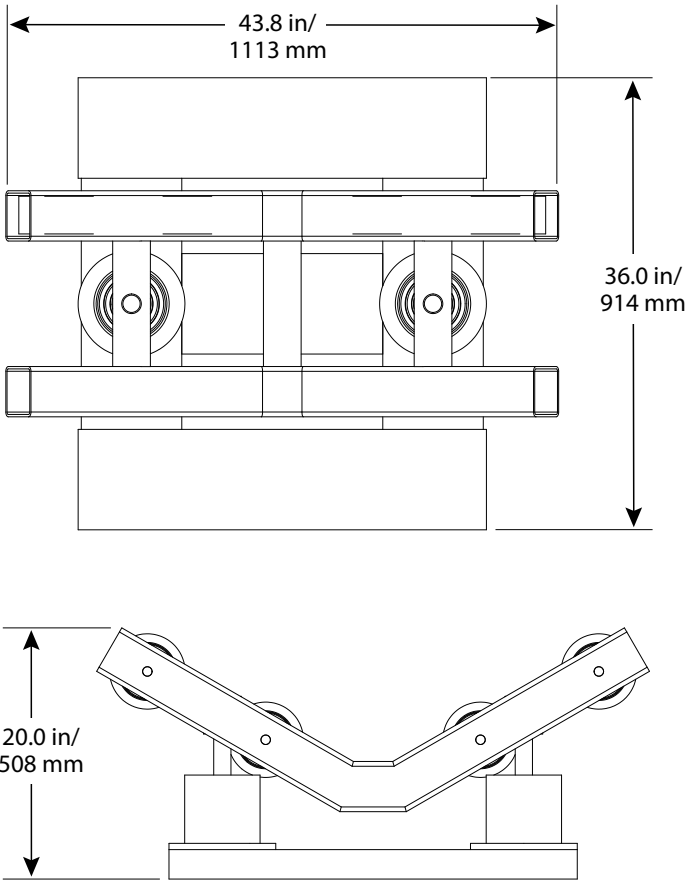
- Before operating or servicing any pipe preparation tools, read all instructions in the Operating and Maintenance Instructions Manual and all labels on the tool.
- Wear safety glasses, hardhat, foot protection, and hearing protection when working around tools.

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

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TOOL DIMENSIONS AND SPECIFICATIONS



Net pipe stand weight is 480 pounds/218 kilograms.

PRE-OPERATION CHECKS AND ADJUSTMENTS

Every Victaulic pipe stand is checked, adjusted, and tested at the factory prior to shipment. The pipe stand should be inspected for any damage that may have occurred during shipping and handling.

Before operating the pipe stand, the following checks and adjustments should be made to ensure proper pipe stand operation. Repeat these steps when the pipe stand is moved and when it is transported to an alternate location.

PIPE PREPARATION

Prepare pipe for roll grooving in accordance with the Operating and Maintenance Instructions Manual for the applicable tool being used to roll groove the pipe. In addition, inspect the pipe surface for dents or surface build-up where contact with the pipe stand's polyethylene wheels will occur. The pipe surface should be free of large dents, and free of accumulations of dirt, rust, or grime that may interfere with smooth pipe rotation.

Pipe with external, axial weld seams can be used with the stand. However, the weld bead must be smooth and rounded, and must be at least three times as wide as it is high. The weld bead must not exceed 1/8 inch/3 mm in height.

To minimize wear on the rollers and polyethylene wheels, grind the weld bead flush where the pipe makes contact with the stand.

NOTICE

- Grooving pipe that contains external weld seams will shorten the life of the polyethylene wheels.

TOOL AND 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:
 - a. Adequate space to handle pipe lengths
 - b. A firm and level surface for the pipe stand
 - c. Anchoring requirements for the pipe stand
2. Ensure that the roll grooving tool is **LEVELED** and **FASTENED SECURELY** to a concrete floor. Refer to the Operating and Maintenance Instructions Manual for the applicable tool being used to roll groove the pipe.
3. Position the stand in an approximate operating location, as explained below. Always refer to the "Grooving Long Pipe Lengths" section in the Operating and Maintenance Instructions Manual for the applicable tool being used to roll groove the pipe.
 - a. Determine the length of the pipe to be roll grooved.
 - b. Position the pipe stand at a distance slightly greater than half the pipe length from the tool (half the pipe length, plus 5%).
 - c. Position the pipe stand approximately in line with the tool's grooving rolls or slightly to the left.
 - d. Ensure that the base is level, front to back.

INITIAL PIPE STAND ADJUSTMENTS

CAUTION

- This pipe stand must be used **ONLY** for supporting pipe sizes, materials, and wall thicknesses as designated.

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

1. Determine the pipe size to be roll grooved.



When grooving 16–46-inch/406.4–1168-mm pipe sizes: The polyethylene wheels must be installed in the lower hole locations, as shown above.



When grooving 48–72-inch/1219–1829-mm pipe sizes: The polyethylene wheels must be installed in the upper hole locations, as shown above.



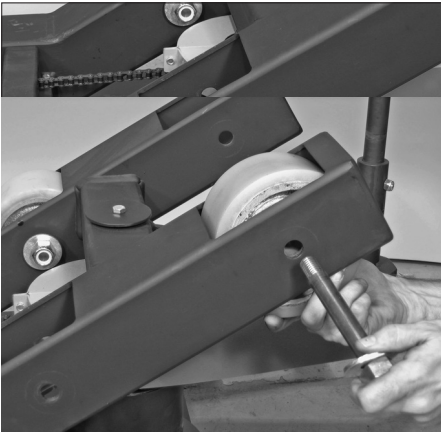
2. To change locations of the polyethylene wheels, remove the hex lock nut and flat washer from the interior section of the roller support.



3. While supporting the polyethylene wheel, remove the threaded roll shaft/hex nut assembly and flat washer, as shown above.



4. Remove the polyethylene wheel from underneath the roller support, as shown above.



- 5a. Install the polyethylene wheel into the new location on the roller support.
- 5b. Insert the threaded roll shaft/hex nut assembly with flat washer through the roller support and polyethylene wheel.



- 6. Install a flat washer and hex lock nut onto the end of the threaded roll shaft/hex nut assembly.



- 7. Tighten the hex lock nut completely to retain the polyethylene wheel.
- 8. Repeat steps 2–7 to relocate the other three polyethylene wheels to the new locations on the roller support.
- 9. Ensure that all wheels are secure and that they have full freedom of movement before proceeding.

RATCHET OPERATION

The ratchet has three settings that can be used for raising or lowering the roller support to accommodate various pipe sizes.



1. Place the indicator on the ratchet to the left (when viewed from the end of the ratchet) to raise the roller support.



2. Place the indicator on the ratchet to the right (when viewed from the end of the ratchet) to lower the roller support.

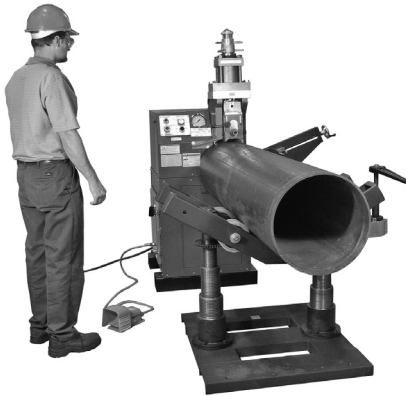


3. Place the indicator on the ratchet to the middle location (when viewed from the end of the ratchet) to enable the ratchet to rotate freely. In this position, the ratchet can be rotated clockwise to raise the roller support or counterclockwise to lower the roller support.



NOTE: The extension shaft can be adjusted to three different heights within the adjusting sleeve to facilitate ratchet operation.

4. Using the ratchet, adjust the pipe stand height to a position that will support the pipe in an approximate level position when one end of the pipe is positioned on the roll grooving tool's lower roll.



- 5a. Position the pipe in the pipe stand and onto the roll grooving tool's lower roll. If using a pipe sling, the sling can be positioned between the polyethylene wheels while the pipe is being brought into position for placement on the pipe stand. Remove the pipe sling before rolling the pipe on the stand.
- 5b. Use the ratchet to adjust the roller support height. The pipe should be approximately level when the pipe end is positioned on the roll grooving tool's lower roll.
- 5c. Slide the pipe stand right or left to obtain the proper "tracking angle." Refer to the Operating and Maintenance Instructions Manual for the applicable tool being used to roll groove the pipe.

FINAL PIPE STAND ADJUSTMENTS



CAUTION

- Remove any pipe lifting devices from the pipe before proceeding with the following steps.

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

For final adjustment of the pipe stand, a sample piece of pipe must be test grooved.

Roll groove the pipe by referring to the Operating and Maintenance Instructions Manual for the applicable tool being used to roll groove the pipe.

Follow the steps below to check the test groove for accuracy. Adjust and repeat test groove as necessary until the appropriate pipe specifications are achieved.

Examine the test-grooved pipe end for excessive flare and/or a scuffed pipe-end face.

1. If pipe is excessively flared, it may be due to the pipe stand adjustments. To minimize flare:
 - a. Ensure that the roll grooving tool is **LEVEL** (especially front to back) and **SECURED** to the floor.
 - b. Ensure that the pipe is **LEVEL** or that the back end of the pipe (end not being grooved) is slightly below level ($\frac{1}{4}$ bubble maximum on a spirit level). Pipe level should always be checked with the pipe end to be grooved resting in position on the roll grooving tool's lower roll.
 - c. Ensure that the pipe is positioned as close to parallel with the roll set as possible, while still maintaining pipe "tracking."
2. If the pipe end has an excessively scuffed face, the usual causes are "over-tracking" and/or an out-of-square pipe end. To minimize "over-tracking," keep the pipe stand tracking angle as close to 0° as possible, while ensuring adequate "tracking."

MAINTENANCE

This section provides information about maintaining the pipe stand in proper operating condition. Replacement parts must be ordered from Victaulic to ensure proper and safe operation of the pipe stand.

1. Clean the upper, intermediate, and bottom columns with a wire brush to remove any debris.



2. Regular lubrication is required for the pipe stand. On a monthly basis, apply a dry graphite spray to the upper, intermediate, and bottom columns. Work the dry graphite in by using the ratchet to lower and raise the roller support.



3. On a monthly basis, apply chain lubricant to the entire length of the chain.
4. Lubricate the threaded roll shaft/hex nut assemblies that retain the polyethylene wheels.

PARTS ORDERING INFORMATION

When ordering parts, the following information is required for Victaulic to process the order and send the correct part(s). Parts can be ordered by calling 1-800-PICK VIC.

1. Tool Model Number
2. Tool Serial Number
3. Quantity, Item Number, Part Number, and Description
4. Where to send the part(s) – Company Name and Address
5. To whose attention to send the part(s) – Person's Name
6. Purchase Order Number
7. Billing Address

TROUBLESHOOTING

PROBLEM	POSSIBLE CAUSE	SOLUTION
Pipe flare is excessive.	Pipe is "over-tracking".	Refer to the Operating and Maintenance Instructions Manual for the applicable tool being used to groove the pipe.
	Pipe height adjustment is too high.	
	Roll grooving tool is tilted forward.	
	Pipe is out of specification.	
Pipe face is excessively scuffed.	Pipe is "over-tracking".	
Pipe will not stay in roll grooving tool.	Insufficient pipe tracking angle.	
	Pipe is rotating in the wrong direction.	
	Pipe is not square cut.	
	Back end of pipe is above level.	
	Roll grooving tool is tilted forward.	

In the event of tool malfunction outside the scope of the troubleshooting section, contact Victaulic for assistance.

VAPS1672 Pipe Stand

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