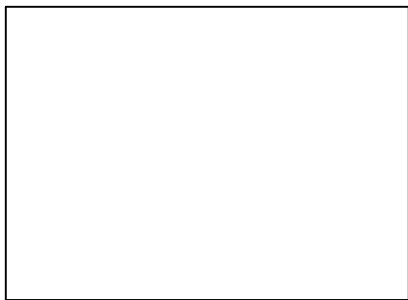
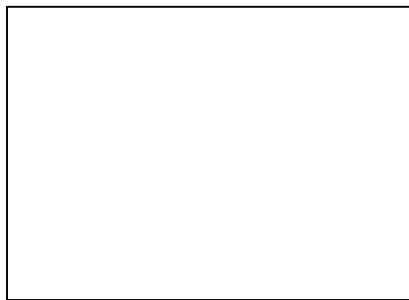
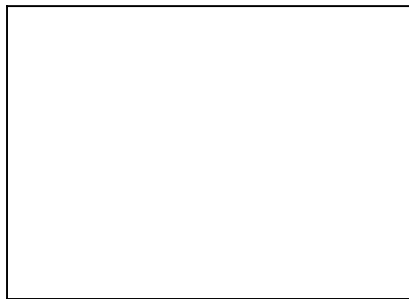
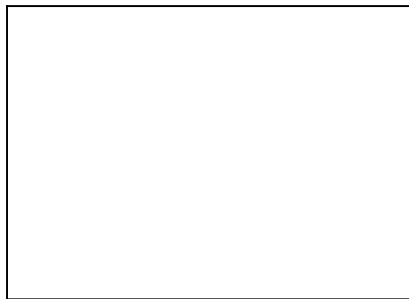
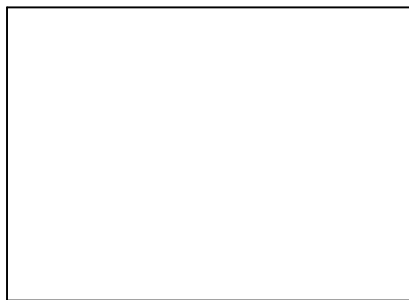




Service Information **SS4 - 00160**

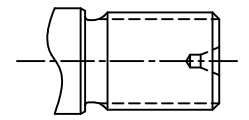
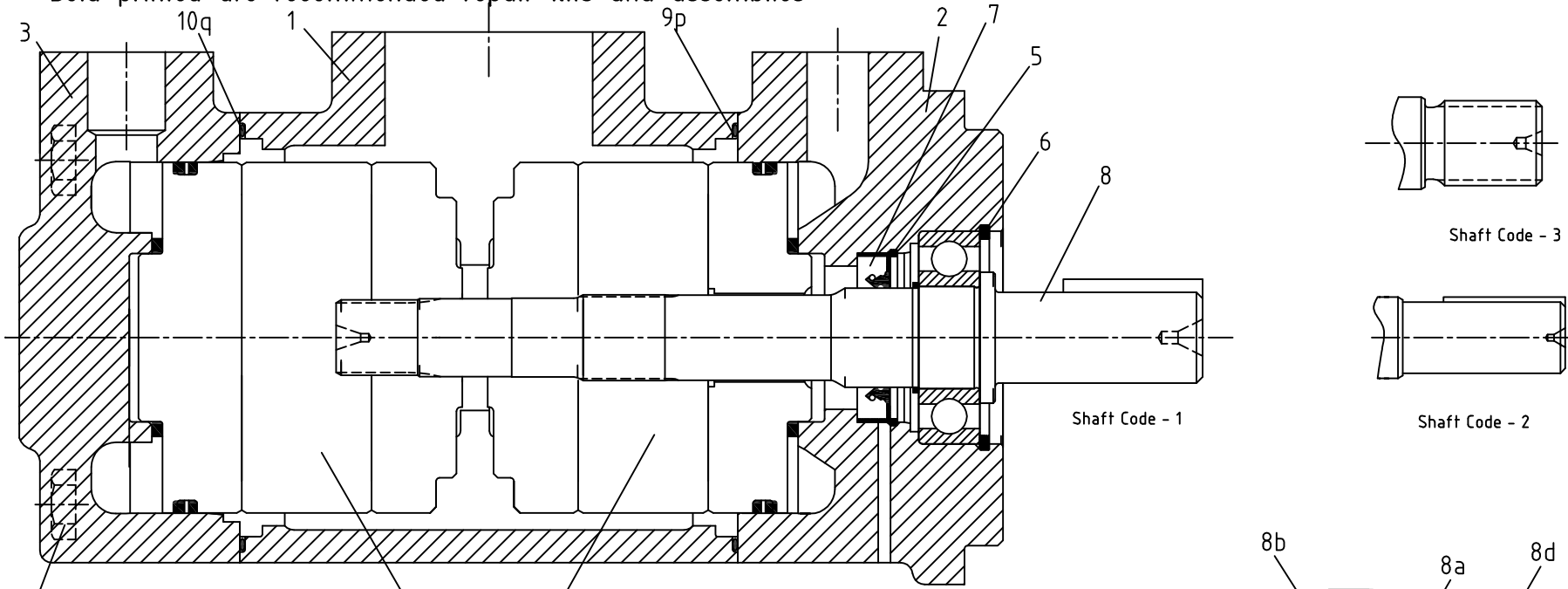
VTXBB1-VTXBB2

Double vane pump

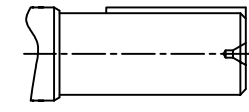


PHOTO

Bold printed are recommended repair kits and assemblies



Shaft Code - 3

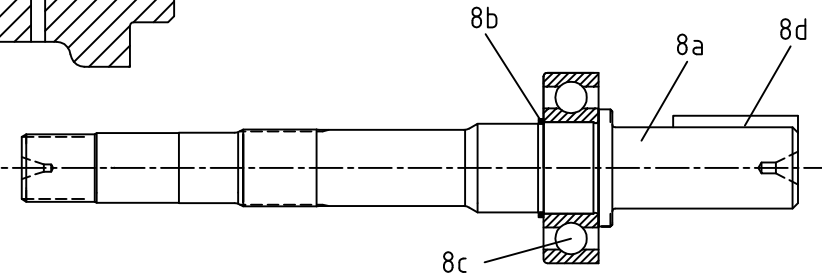
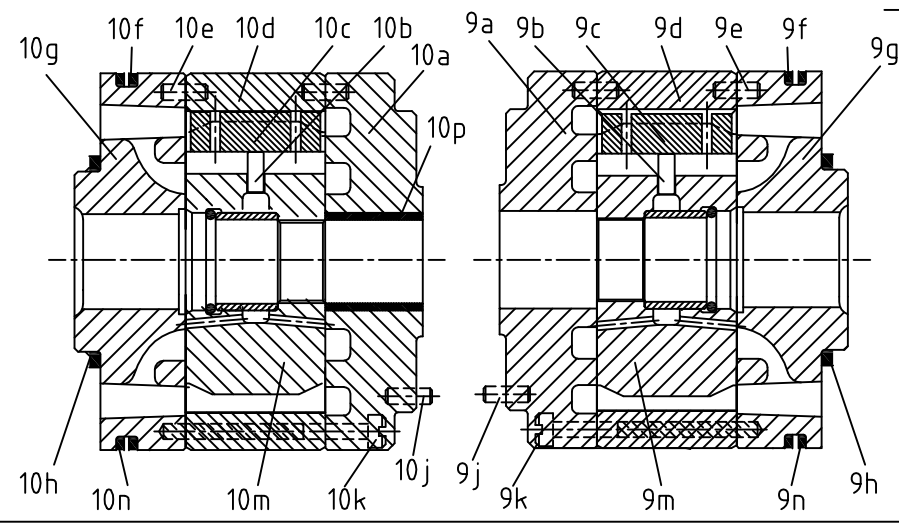


Shaft Code - 2

Shaft Code - 1

ITEM 10q INCLUDED **P2**

ITEM 9p INCLUDED **P1**



Item pos.	Description	Part No.		Qty
		VTXBB1	VTXBB2	
1	Housing (UNC)	C-034-03504	C-034-03504	1
	Housing (Metric)	C-034-03535	C-034-03535	
2	Mounting flange (UNC)	C-034-03574	C-034-03580	1
	Mounting flange (Metric)	C-034-03575	C-034-03581	
	Mounting flange (SAE12 1-1/16"-12 UNF)	C-034-03573	C-034-03579	
	Mounting flange (3/4" BSP)	C-034-03576	C-034-03582	
	Mounting flange (3/4" NPTF)	C-034-03577	C-034-03583	
3	End cap (UNC) (SAE 4 BOLTS)	C-034-03536	C-034-03536	1
	End cap (Metric)	C-034-03537	C-034-03537	
	End cap (SAE12 1"1/16-12 UNF)	C-034-03517	C-034-03517	
4	Mounting Screw	361-12284-3	361-12284-3	4
5	Retaining ring	V356-30206	V356-30206	1
6	Retaining ring	V356-30156	V356-30156	1
7	Shaft seal (S1-0.7 bar)	V620-50255	V620-50255	1
8	Shaft and bearing ass'y (Code-1)	C-S14-72749	C-S14-72749	1
	Shaft and bearing ass'y (Code-2)	C-S14-72750	C-S14-72750	
	Shaft and bearing ass'y (Code-3)	C-S14-72751	C-S14-72751	
8a	Shaft keyed (Code-1)	C-034-03506	C-034-03506	1
	Shaft keyed (Code-2)	C-034-03700	C-034-03700	
	Shaft splined (Code-3)	C-034-03730	C-034-03730	
8b	Round section ring	V034-70777	V034-70777	1
8c	Ball bearing	V230-82149	V230-82149	1
8d	Key code-1	V034-48690	V034-48690	1
	Key code-2	V034-48690	V034-48690	
9	Cartridge assembly B02 CW (P1)	C-S14-72364	C-S14-72364	1
	Cartridge assembly B02 CCW (P1)	C-S14-72365	C-S14-72365	
	Cartridge assembly B03 CW (P1)	C-S14-72366	C-S14-72366	
	Cartridge assembly B03 CCW (P1)	C-S14-72367	C-S14-72367	
	Cartridge assembly B04 CW (P1)	C-S14-72368	C-S14-72368	
	Cartridge assembly B04 CCW (P1)	C-S14-72369	C-S14-72369	
	Cartridge assembly B05 CW (P1)	C-S14-72433	C-S14-72433	
	Cartridge assembly B05 CCW (P1)	C-S14-72434	C-S14-72434	
	Cartridge assembly B06 CW (P1)	C-S14-72370	C-S14-72370	
	Cartridge assembly B06 CCW (P1)	C-S14-72371	C-S14-72371	

Item pos.	Description	Part No.		Qty
		VTXBB1	VTXBB2	
	Cartridge assembly B07 CW (P1)	C-S14-72435	C-S14-72435	
	Cartridge assembly B07 CCW (P1)	C-S14-72443	C-S14-72443	
	Cartridge assembly B08 CW (P1)	C-S14-72372	C-S14-72372	
	Cartridge assembly B08 CCW (P1)	C-S14-72373	C-S14-72373	
	Cartridge assembly B09 CW (P1)	C-S14-72374	C-S14-72374	
	Cartridge assembly B09 CCW (P1)	C-S14-72375	C-S14-72375	
	Cartridge assembly B10 CW (P1)	C-S14-72444	C-S14-72444	
	Cartridge assembly B10 CCW (P1)	C-S14-72445	C-S14-72445	
	Cartridge assembly B11 CW (P1)	C-S14-72446	C-S14-72446	
	Cartridge assembly B11 CCW (P1)	C-S14-72447	C-S14-72447	
	Cartridge assembly B12 CW (P1)	C-S14-72376	C-S14-72376	
	Cartridge assembly B12 CCW (P1)	C-S14-72377	C-S14-72377	
	Cartridge assembly B14 CW (P1)	C-S14-72419	C-S14-72419	
	Cartridge assembly B14 CCW (P1)	C-S14-72420	C-S14-72420	
9a	Port plate - rear (Bi-dir)	C-034-03493	C-034-03493	1
9b	Pin vane holdout	C-SK-01280	C-SK-01280	12
9c	Vane	C-034-03457	C-034-03457	12
9d	Cam ring - 002	C-034-03486	C-034-03486	1
	Cam ring - 003	C-034-03487	C-034-03487	
	Cam ring - 004	C-034-03488	C-034-03488	
	Cam ring - 005	C-034-03497	C-034-03497	
	Cam ring - 006	C-034-03489	C-034-03489	
	Cam ring - 007	C-034-03498	C-034-03498	
	Cam ring - 008	C-034-03490	C-034-03490	
	Cam ring - 009	C-034-03491	C-034-03491	
	Cam ring - 010	C-034-03500	C-034-03500	
	Cam ring - 011	C-034-03501	C-034-03501	
	Cam ring - 012	C-034-03492	C-034-03492	
	Cam ring - 014	C-034-03426	C-034-03426	
9e	Dowel pin	V324-21208	V324-21208	2
9f	Back-up ring	C-618-00005	C-618-00005	1
9g	Port plate - pressure (Bi-dir)	C-034-03455	C-034-03455	1
9h	Sq. section seal	V691-10223	V691-10223	1
9j	Drive lock pin	V323-82010	V323-82010	1
9k	Screw	V317-06246	V317-06246	2
9m	Rotor-insert ass'y	C-S14-72387	C-S14-72387	1
9n	Sq. section seal	V691-10235	V691-10235	1
9p	O' ring	V691-00045	V691-00045	1
10	Cartridge assembly B02 CW (P2)	C-S14-72405	C-S14-72405	1
	Cartridge assembly B02 CCW (P2)	C-S14-72406	C-S14-72406	

MODEL CODE

VTXBB 1 - B09 - B11 - 1 R 00 - A 1 02 *

Series _____
 Mounting _____
 1 - SAE A
 2 - SAE B
 Cam ring _____ Displacement _____ Cam ring _____ Displacement _____
 (P1 & P2) cm^3/rev (in^3/rev) cm^3/rev (in^3/rev)

B02 = 5.8 (0.35)	B08 = 24.9 (1.52)
B03 = 9.8 (0.60)	B09 = 28.0 (1.71)
B04 = 12.8 (0.78)	B10 = 31.8 (1.94)
B05 = 15.9 (0.97)	B11 = 34.9 (2.13)
B06 = 19.8 (1.21)	B12 = 41.0 (2.50)
B07 = 22.5 (1.37)	B14 = 45.0 (2.75)

Type of Shaft _____
 1 - Keyed (Non SAE)
 2 - Keyed
 3 - Splined
 Direction of rotation (view on shaft end) _____
 R - clockwise
 L - counter-clockwise

Modifications
 Port connections

CODE	S	P1 & P2
00	2" SAE 4 bolt (UNC)	SAE 12 1" 1/16 12 UNF-2B
01	2" SAE 4 bolt (UNC)	3/4" SAE 4 bolt (UNC)
M0	2" SAE 4 bolt (METRIC)	3/4" SAE 4 bolt (METRIC)

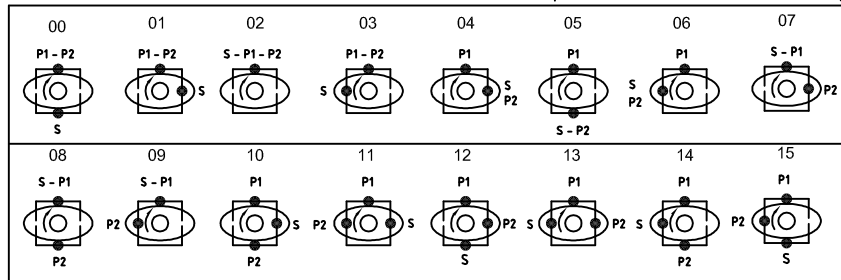
Seal class
 1 - S1 (for mineral oil)
 4 - S4 (for fire resistant fluids)
 5 - S5 (for mineral oil and fire resistant fluids)

Design letter

Porting combination _____

00 - standard

S- Suction port P1 & P2 - Pressure ports

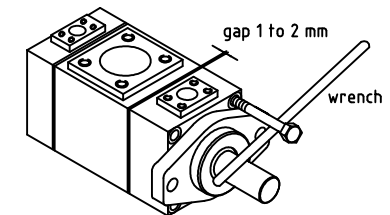


To change porting position, follow the steps below:

Secure pump and remove 4 bolts from housing. Move the housing 1 to 2 mm away from mounting flange. Insert Two bolt halfway to housing. Install a Wrench between the Two bolts and turn in the desired way, so that the required position of pressure port with respect to suction is obtained. Reinstall the bolts and tighten to corresponding torque.

Instruction : Do not remove housing completely from the mounting flange but only just 1 to 2 mm to avoid the cartridge pin to move out from the housing dowel pin hole. make sure no piece of paint enters in to the gap to avoid leakage.

If it is difficult to turn housing put some hydraulic oil to the pressure port to lubricate the pressure port seals.



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