



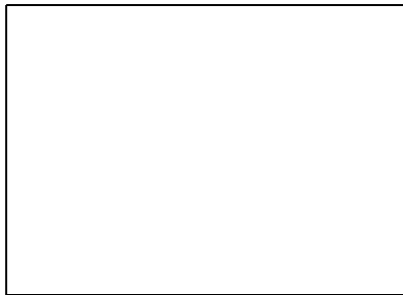
**VELJAN**

Service Information

SS4 - 00156

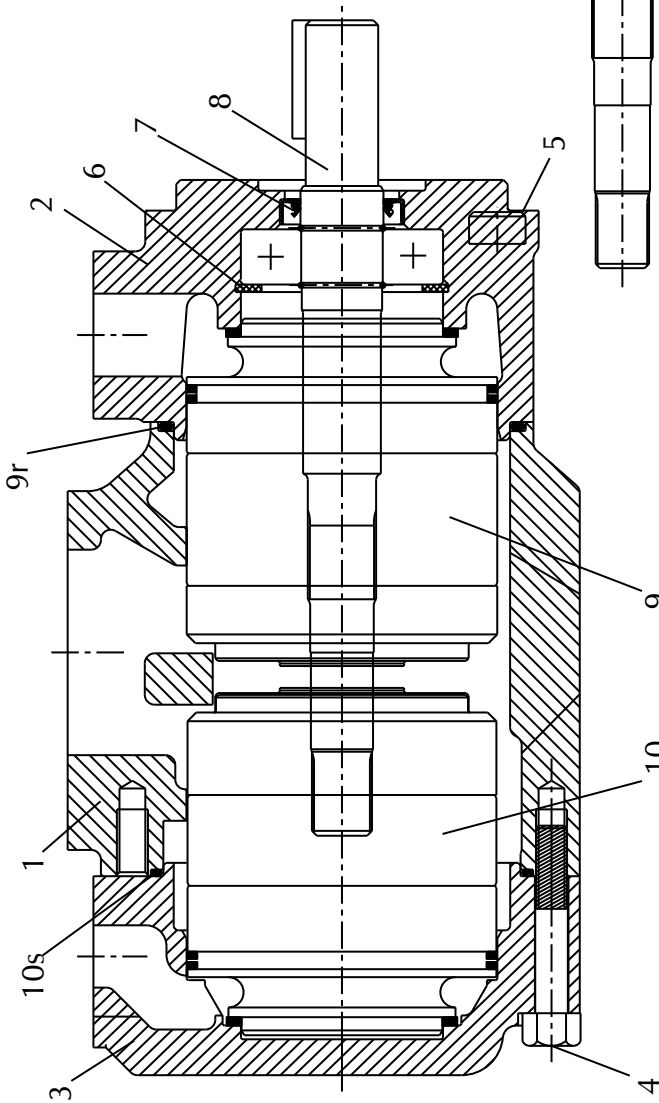
**VT67BB**

Double vane pump

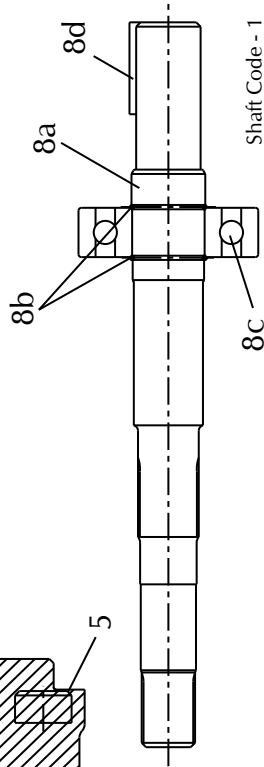


**PHOTO**

Bold printed are recommended repair kits and assemblies

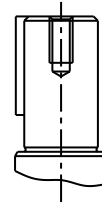
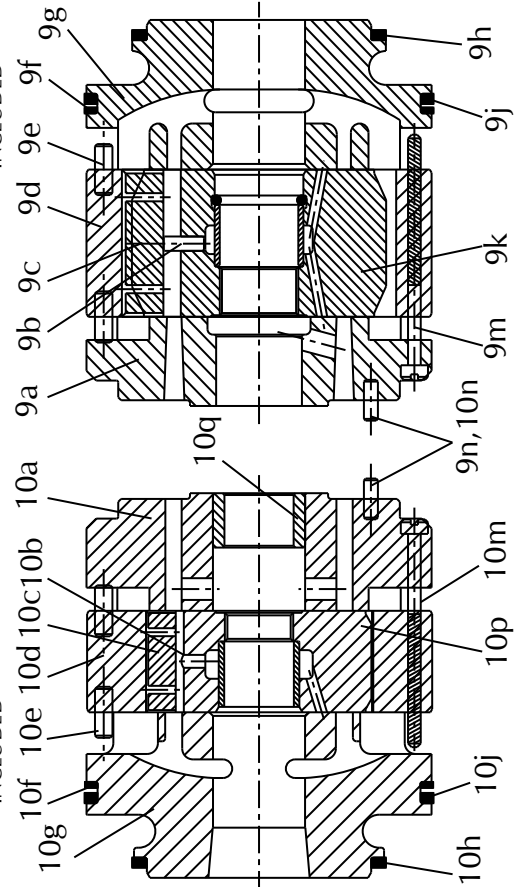


Mounting torque	
Item pos.	4 5
ft-lbs	45 117
N-m	61 159

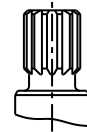


**P2**  
ITEM 10s  
INCLUDED

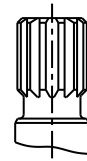
**P1**  
ITEM 9r  
INCLUDED



Shaft Code - 2



Shaft Code - 3



Shaft Code - 5

Item pos.	Description	Part No.	Qty
		VT67BB	
1	Housing (UNC) (S = 2½")	V034-59125	1
	Housing (Metric) (S = 2½")	H-034-66509	
2	Mounting flange (UNC) (for Shafts 1-3-5)	V034-59107	1
	Mounting flange (Metric) (for Shafts 1-3-5)	H-034-66690	
	Mounting flange (UNC) (for Shaft - 2) (VT67BBW)	H-034-66579	
	Mounting flange (Metric) (for Shaft - 2) (VT67BBW)	H-034-66507	
3	End cap (UNC) (P2 = ¾")	V034-59425	1
	End cap (Metric) (P2 = ¾")	H-034-66508	
4	Mounting Screw	V306-40094	7
5	Mounting Screw	V358-20320	4
6	Retaining ring	V356-30244	1
7	Shaft seal (S1-0.7 bar) (for Shafts 1-3-5)	V620-82012	1
	Shaft seal (S4-S5-7 bar) (for Shafts 1-3-5)	V620-82068	
	Shaft seal (S1-0.7 bar) for Shaft - 2) (VT67BBW)	V620-82046	
	Shaft seal (S4-0.7 bar) (for Shaft - 2) (VT67BBW)	V620-82046-4	
	Shaft seal (S5-0.7 bar) (for Shaft - 2) (VT67BBW)	V620-82046-5	
8	Shaft and bearing ass'y (Code-1)	VS24-10346	1
	Shaft and bearing ass'y (Code-2) (VT67BBW)	VS24-26208	
	Shaft and bearing ass'y (Code-3)	VS24-10348	
	Shaft and bearing ass'y (Code-5)	VS24-10347	
8a	Shaft (Keyed) (Code-1)	V034-59110	1
	Shaft (Keyed) (Code-2) (VT67BBW)	H-034-66576	
	Shaft (Splined) (Code-3)	V034-59108	
	Shaft (Splined) (Code-5)	V034-59109	
8b	Round section ring (shafts 1-3-5)	V034-70777	2
	Round section ring (shaft 2) (VT67BBW)	V034-70777	1
8c	Ball bearing	V230-82054	1
8d	Key (Code -1)	V034-49622	1
	Key (Code -2)	V034-48690	
9	Cartridge assembly B02 C.W. (P1)	VS24-58078	1
	Cartridge assembly B02 C.C.W. (P1)	VS24-58079	
	Cartridge assembly B03 C.W. (P1)	VS24-58080	
	Cartridge assembly B03 C.C.W. (P1)	VS24-58081	
	Cartridge assembly B04 C.W. (P1)	VS24-58082	
	Cartridge assembly B04 C.C.W. (P1)	VS24-58083	
	Cartridge assembly B05 C.W. (P1)	VS24-58084	
	Cartridge assembly B05 C.C.W. (P1)	VS24-58085	
	Cartridge assembly B06 C.W. (P1)	VS24-58086	
	Cartridge assembly B06 C.C.W. (P1)	VS24-58087	
	Cartridge assembly B07 C.W. (P1)	VS24-59974	
	Cartridge assembly B07 C.C.W. (P1)	VS24-59975	
	Cartridge assembly B08 C.W. (P1)	VS24-58088	
	Cartridge assembly B08 C.C.W. (P1)	VS24-58089	
	Cartridge assembly B10 C.W. (P1)	VS24-58090	
	Cartridge assembly B10 C.C.W. (P1)	VS24-58091	
	Cartridge assembly B12 C.W.(P1)	VS24-59013	
Cartridge assembly B12 C.C.W. (P1)	VS24-59014		
Cartridge assembly B15 C.W. (P1)	VS24-59015		
Cartridge assembly B15 C.C.W. (P1)	VS24-59016		
9a, 10a	Port plate - rear	H-034-66922	2
9b, 10b	Pin vane holdout	H-034-66920	24
9c, 10c	Vane	H-034-66917	24
9d 10d	Cam ring - 002	H-034-66909	2
	Cam ring - 003	H-034-66910	
	Cam ring - 004	H-034-66911	
	Cam ring - 005	H-034-66912	
	Cam ring - 006	H-034-67063	

Item pos.	Description	Part No.	Qty
		VT67CB	
	Cam ring - 008	H-034-66914	
	Cam ring - 010	H-034-66915	
	Cam ring - 012	H-034-67032	
	Cam ring - 015	H-034-67034	
9e,10e	Dowel pin	V324-21208	4
9f,10f	Back-up ring	V618-15016	2
9g,10g	Port plate - pressure	H-034-66923	2
9h,10h	Sq. section seal	V691-10229	2
9j,10j	Sq. section seal	V691-10238	2
9k	Rotor-insert ass'y (P1)	H-S24-51722	1
9m, 10m	Screw	V317-06266	4
9n, 10n	Dowel pin	V323-82010	2
9r	O' ring	V671-00244	1
10	Cartridge assembly B02 C.W. (P2)	VS24-50610	1
	Cartridge assembly B02 C.C.W. (P2)	VS24-50611	
	Cartridge assembly B03 C.W. (P2)	VS24-50612	
	Cartridge assembly B03 C.C.W. (P2)	VS24-50613	
	Cartridge assembly B04 C.W. (P2)	VS24-50614	
	Cartridge assembly B04 C.C.W. (P2)	VS24-50615	
	Cartridge assembly B05 C.W. (P2)	VS24-50616	
	Cartridge assembly B05 C.C.W. (P2)	VS24-50617	
	Cartridge assembly B06 C.W. (P2)	VS24-50618	
	Cartridge assembly B06 C.C.W. (P2)	VS24-50619	
	Cartridge assembly B07 C.W. (P2)	VS24-59907	
	Cartridge assembly B07 C.C.W. (P2)	VS24-59908	
	Cartridge assembly B08 C.W. (P2)	VS24-50620	
	Cartridge assembly B08 C.C.W. (P2)	VS24-50621	
	Cartridge assembly B10 C.W. (P2)	VS24-50622	
	Cartridge assembly B10 C.C.W. (P2)	VS24-50623	
	Cartridge assembly B12 C.W. (P2)	VS24-59009	
	Cartridge assembly B12 C.C.W. (P2)	VS24-59010	
	Cartridge assembly B15 C.W. (P2)	VS24-59011	
	Cartridge assembly B15 C.C.W. (P2)	VS24-59011	
10p	Rotor-insert ass'y (P2)	H-S24-49820	1
10q	Bearing bush	C-EX-00448	1
10s	Sq. section seal	V671-10156	1
7,9r 9j,9h 9f,10f 10j, 10h	Seal kit (s1-0.7 bar) (for shafts 1-3-5)	VS24-10352	1
	Seal kit (s4-7 bar) (for shafts 1-3-5)	VS24-10352-4	
	Seal kit (s5-7 bar) (for shafts 1-3-5)	VS24-10352-5	
	Seal kit (s1-0.7 bar) (for shaft 2) (VT67BBW)	VS14-97724	
	Seal kit (s4-0.7 bar) (for shaft 2) (VT67BBW)	VS14-97724-4	
	Seal kit (s5-0.7 bar) (for shaft 2) (VT67BBW)	VS14-97724-5	
9a, 9n	Port plate - rear ass'y (P1)	VS24-58196	1
10a,10g 10n	Port plate - rear and bush ass'y (P2)	VS24-50642	1

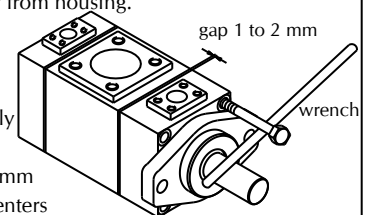
To change porting position, follow the steps below:

1. Secure pump and remove 4 bolts from mounting flange. Move the mounting flange 1 to 2 mm away from housing.

Insert one bolt halfway into mounting flange. Install a wrench between the shaft and bolt and turn in the desired way, so that the required position of P1 port with respect to Suction is obtained. Reinstall the bolts and tighten to corresponding mounting torque as provided on page 2.

2. Follow similar procedure for changing P2 position. Use wrench between two bolts placed diagonally opposite.

Instruction : Do not remove mounting flange/end cap completely from the housing 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 into the gap to avoid leakage. If it is difficult to turn mounting flange/end cap put some hydraulic oil in to the pressure port to lubricate the pressure port seals.



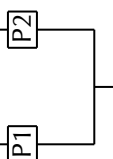
# MODEL CODE

Series

VT67BB series-**SAE B 2 bolts**  
Mounting flange **J744C**

Use for severe duty shaft only

**VT67BB W - B10 - B10 -1 R 00 - A 1 M1 - \***



Cam ring — Displacement — Cam ring — Displacement

	in <sup>3</sup> /rev (cm <sup>3</sup> /rev)		in <sup>3</sup> /rev (cm <sup>3</sup> /rev)
B02 =	0.35 (5.7)	B09 =	1.71 (28.0)
B03 =	0.60 (9.8)	B10 =	1.94 (31.8)
B04 =	0.78 (12.8)	B11 =	2.13 (34.9)
B05 =	0.97 (15.9)	B12 =	2.50 (40.9)
B06 =	1.21 (19.8)	B14 =	2.75 (45.1)
B07 =	1.37 (22.5)	B15 =	3.05 (50.0)
B08 =	1.52 (24.9)		

Type of Shaft

- 1 = Keyed (no SAE)
- 3 = Splined (SAE-BB)
- 5 = Splined (SAE-B)

- VT67BBW
- 2 = Keyed (SAE-BB)

Direction of rotation

- R = Clockwise
- L = Counter - clockwise

Modification

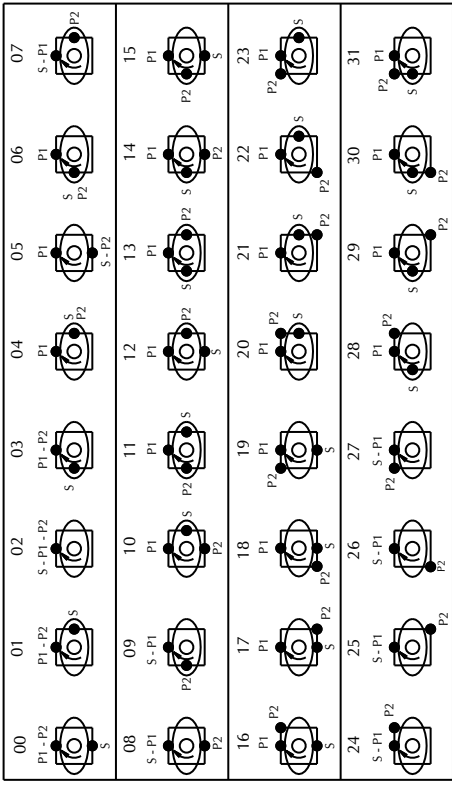
P1 = 1" P2 = 3/4" S = 2 1/2"	
UNC	METRIC
11	M1

Mounting W/connection variables

- Seal class
- 1 = S1 - BUNA N
- 4 = S4 - EPDM
- 5 = S5 - VITON

Design letter

Porting combination : (00 = Standard)



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