



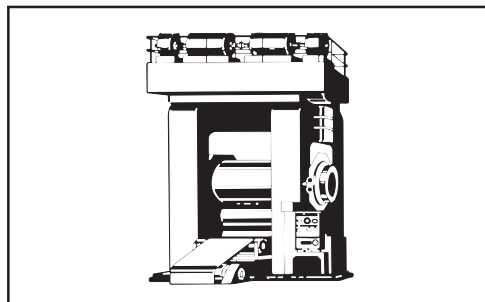
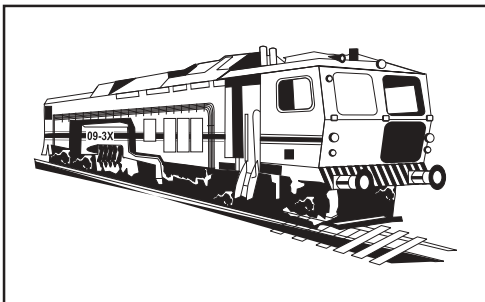
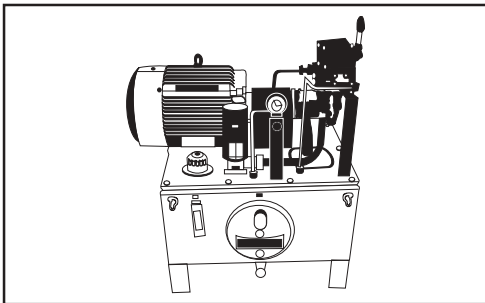
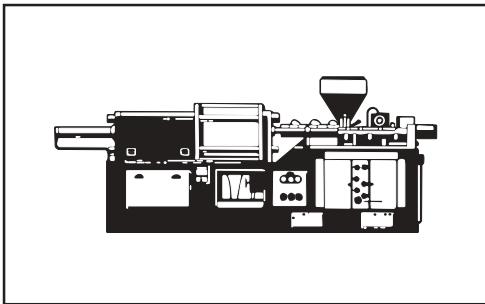
VELJAN

Service Information

SS4 - 00131

VT67EB

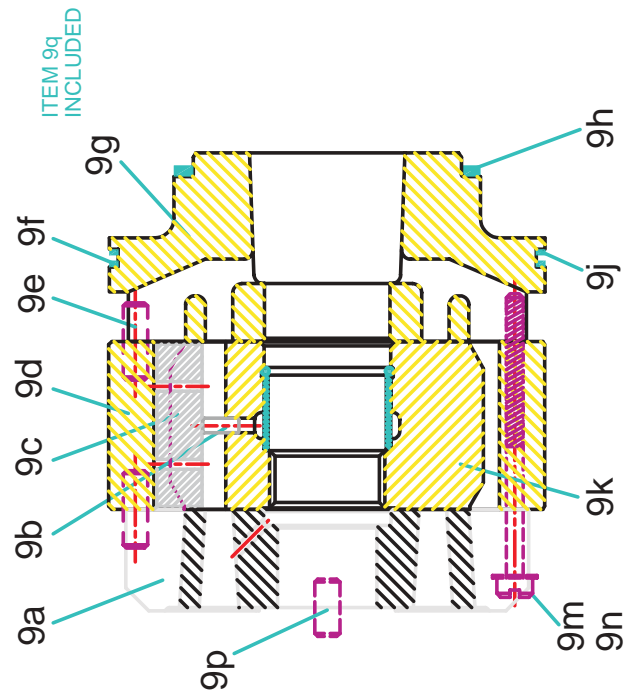
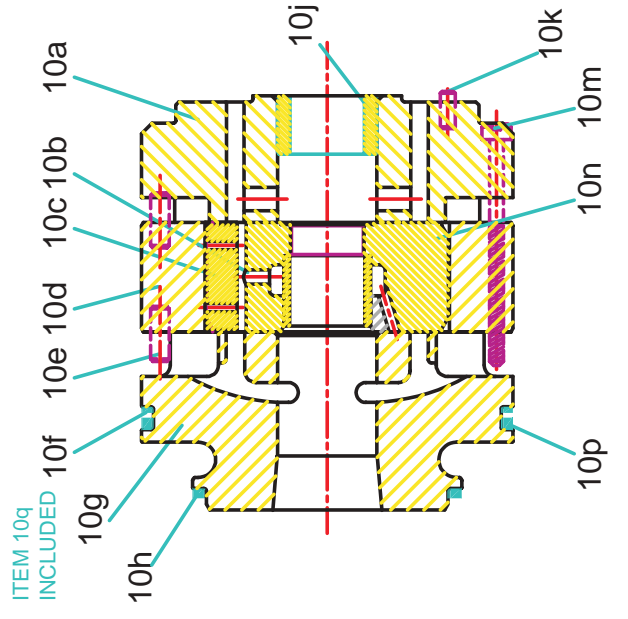
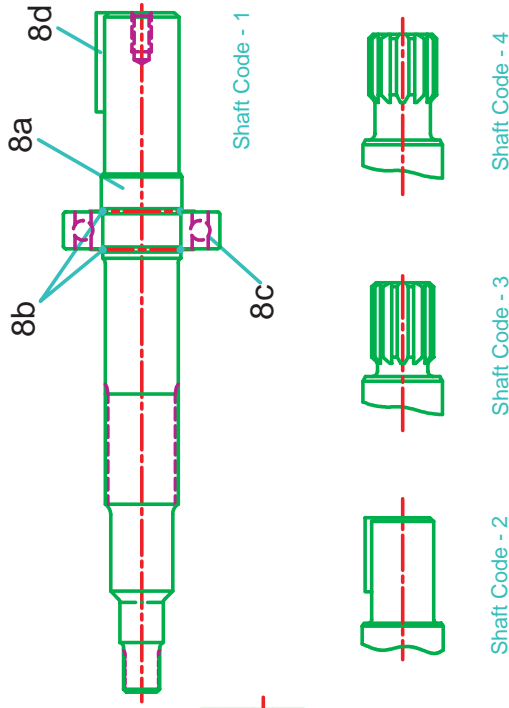
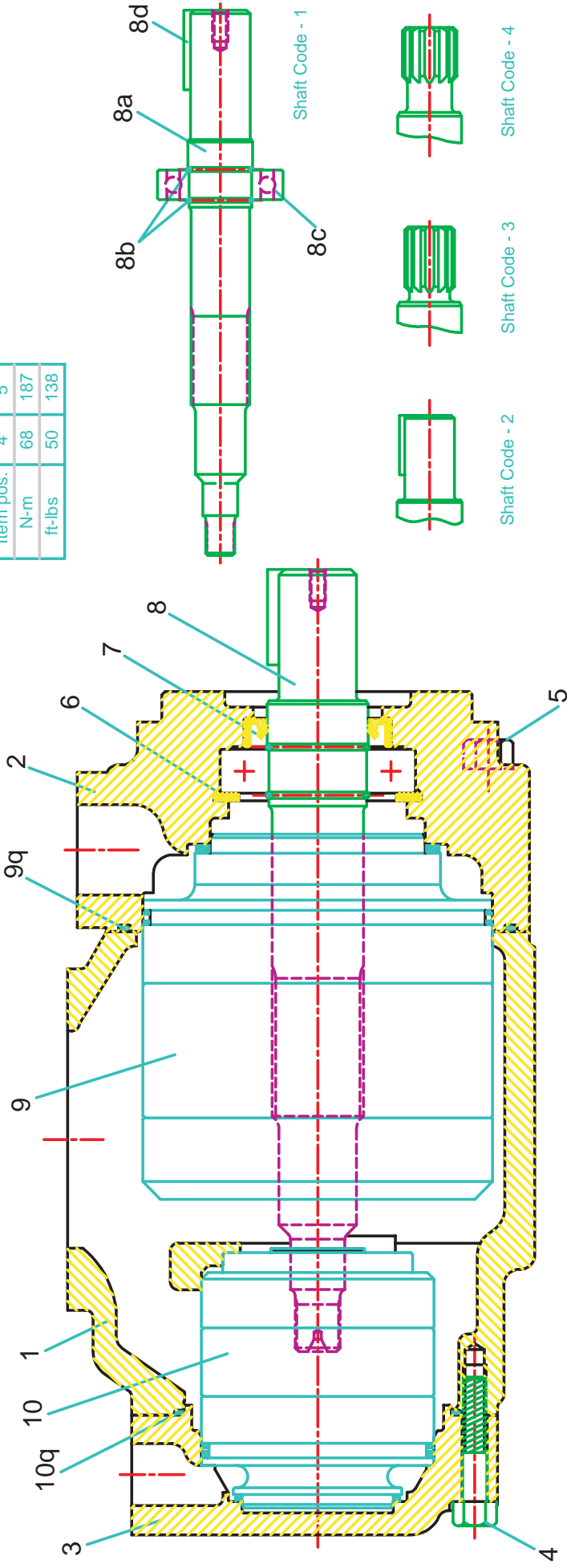
Double vane pump



Bold printed are recommended repair kits and assemblies

Mounting torque

Item pos.	4	5
N-m	68	187
ft-lbs	50	138



Item pos.	Description	Part No.	Qty
		VT67EB	
1	Housing (UNC)	V034-70263	1
	Housing (Metric)	C-034-03069	
2	Mounting flange (UNC)	V034-70265	1
	Mounting flange (Metric)	C-034-03070	
3	End cap (UNC) (P2=3/4")	V034-66533	1
	End cap (Metric) (P2=3/4")	H-034-66765	
4	Mounting Screw	V306-40111	7
5	Mounting Screw	V306-40216	4
6	Retaining ring	V356-30315	1
7	Shaft seal (S1-0.7 bar)	V620-82064	1
	Shaft seal (S4-S5-7 bar)	V620-82072	
8	Shaft and bearing ass'y (Code-1)	VS14-28178	1
	Shaft and bearing ass'y (Code-2)	VS24-49213	
	Shaft and bearing ass'y (Code-3)	VS14-28176	
	Shaft and bearing ass'y (Code-4)	VS14-28177	
8a	Shaft (Keyed) (Code-1)	V034-71408	1
	Shaft (Keyed) (Code-2)	V034-66891	
	Shaft (Splined) (Code-3)	V034-71315	
	Shaft (splined) (Code-4)	V034-71409	
8b	Round section ring	V034-70866	2
8c	Ball bearing	V230-03208	1
8d	Key (Code -1)	V034-70330	1
	Key (Code -2)	V034-49676	
9	Cartridge assembly 042 C.W. (P1)	VS24-49390	1
	Cartridge assembly 042 C.C.W. (P1)	VS24-49391	
	Cartridge assembly 045 C.W. (P1)	VS24-10205	
	Cartridge assembly 045 C.C.W. (P1)	VS24-10206	
	Cartridge assembly 050 C.W. (P1)	VS24-40769	
	Cartridge assembly 050 C.C.W. (P1)	VS24-40770	
	Cartridge assembly 052 C.W. (P1)	VS24-10207	
	Cartridge assembly 052 C.C.W. (P1)	VS24-10208	
	Cartridge assembly 062 C.W. (P1)	VS24-10209	
	Cartridge assembly 062 C.C.W. (P1)	VS24-10210	
	Cartridge assembly 066 C.W. (P1)	VS24-10211	
	Cartridge assembly 066 C.C.W. (P1)	VS24-10212	
	Cartridge assembly 072 C.W. (P1)	VS24-40375	
	Cartridge assembly 072 C.C.W. (P1)	VS24-40376	
	Cartridge assembly 085 C.W. (P1)	VS24-59352	
	Cartridge assembly 085 C.C.W. (P1)	VS24-59353	
9a	Port plate - rear C.W.	V034-59082	1
	Port plate - rear C.C.W.	V034-59083	
9b	Pin vane holdout	V034-70259	12
9c	Vane	V034-59162	12
9d	Cam ring - 042	V034-66899	1
	Cam ring - 045	V034-59164	
	Cam ring - 050	V034-66744	
	Cam ring - 052	V034-59165	
	Cam ring - 062	V034-59166	
	Cam ring - 066	V034-59167	
	Cam ring - 072	V034-66736	
	Cam ring - 085	V034-67030	
9e	Dowel pin	V324-22016	2
9f	Back-up ring	V618-15018	1
9g	Port plate - pressure C.W.	V034-59159	1
	Port plate - pressure C.C.W.	V034-59160	
9h	Sq. section seal	V691-10237	1
9j	Sq. section seal	V691-10253	1

Item pos.	Description	Part No.	Qty
		VT67EB	
9k	Rotor-insert ass'y	VS24-30019	1
9m	Screw	V310-10340	2
9n	Lockwasher internal tooth	V348-10010	2
9p	Dowel pin	V323-82014	1
9q	Sq. section seal	V671-10259	1
10	Cartridge assembly B02 C.W (P2)	VS24-51513	1
	Cartridge assembly B02 C.C.W (P2)	VS24-51514	
	Cartridge assembly B03 C.W (P2)	VS24-51515	
	Cartridge assembly B03 C.C.W (P2)	VS24-51516	
	Cartridge assembly B04 C.W (P2)	VS24-51617	
	Cartridge assembly B04 C.C.W (P2)	VS24-51518	
	Cartridge assembly B05 C.W (P2)	VS24-51519	
	Cartridge assembly B05 C.C.W (P2)	VS24-51520	
	Cartridge assembly B06 C.W (P2)	VS24-51521	
	Cartridge assembly B06 C.C.W (P2)	VS24-51522	
	Cartridge assembly B07 C.W (P2)	VS24-59972	
	Cartridge assembly B07 C.C.W (P2)	VS24-59973	
	Cartridge assembly B08 C.W (P2)	VS24-51523	
	Cartridge assembly B08 C.C.W (P2)	VS24-51524	
	Cartridge assembly B09 C.W (P2)	VS24-77376	
	Cartridge assembly B09 C.C.W (P2)	VS24-77377	
	Cartridge assembly B10 C.W (P2)	VS24-51525	
	Cartridge assembly B10 C.C.W (P2)	VS24-51526	
	Cartridge assembly B11 C.W (P2)	VS24-77378	
	Cartridge assembly B11 C.C.W (P2)	VS24-77379	
	Cartridge assembly B12 C.W (P2)	VS24-59017	
	Cartridge assembly B12 C.C.W (P2)	VS24-59018	
	Cartridge assembly B14 C.W (P2)	VS24-77380	
	Cartridge assembly B14 C.C.W (P2)	VS24-77381	
	Cartridge assembly B15 C.W (P2)	VS24-59019	
	Cartridge assembly B15 C.C.W (P2)	VS24-59020	
10a	Port plate - rear Bi-dir	C-034-03220	1
10b	Pin vane holdout	H-034-66920	12
10c	Vane	H-034-66917	12
10d	Cam ring - B02	H-034-66909	1
	Cam ring - B03	H-034-66910	
	Cam ring - B04	H-034-66911	
	Cam ring - B05	H-034-66912	
	Cam ring - B06	H-034-66913	
	Cam ring - B07	H-034-67063	
	Cam ring - B08	H-034-66914	
	Cam ring - B09	H-034-67383	
	Cam ring - B10	H-034-66915	
	Cam ring - B11	H-034-64461	
	Cam ring - B12	C-034-03219	
	Cam ring - B14	H-034-67409	
	Cam ring - B15	C-034-03218	
10e	Dowel pin	V324-21208	2
10f	Back-up ring	V618-15016	1
10g	Port plate - pressure Bi-dir	H-034-66923	1
10h	Sq. section seal	V691-10229	1
10j	Sq. section seal	V691-10238	1
10k	Rotor-insert ass'y	H-S24-49820	1
10m	Screw	V317-06266	2
10n	Dowel pin	V323-82010	1
10p	Bush	V034-70868	1
10q	Sq. section seal	V671-10156	1

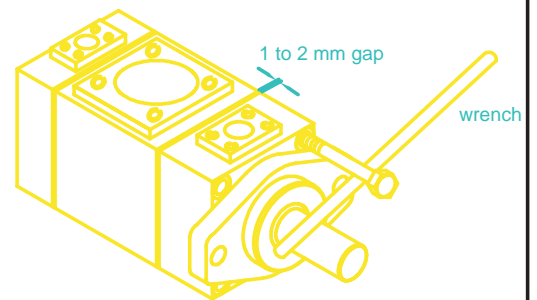
Item pos.	Description	Part No.	Qty
		VT67EB	
7	Seal kit (S1 - 0,7 bar)	VS24-10242	1
9f,9h	Seal kit (S4 - 7 bar)	VS24-10242-4	
9j,9q	Seal kit (S5 - 7 bar)	VS24-10242-5	
10f,10h 10j,10q			
9a	Port plate - rear ass'y C.W. (P1)	VS24-10214	1
9P	Port plate - rear ass'y C.C.W. (P1)	VS24-10215	
10a,10p 10n	Port plate - rear and bush ass'y	VS24-51527	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 to 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

VT67EB - 066 - B10 - 1 R 00 - A 1 M1 *

Series

Cam ring	Displacement in ³ /rev (cm ³ /rev)	Cam ring	Displacement in ³ /rev (cm ³ /rev)
042	= 8.07 (132.2)	062	= 12.0 (196.6)
045	= 8.77 (142.5)	066	= 13.0 (213.0)
050	= 9.67 (158.5)	072	= 13.86 (227.1)
052	= 10.0 (163.8)	085	= 16.40 (268.7)
057	= 11.18 (183.2)		

Cam ring	Displacement in ³ /rev (cm ³ /rev)	Cam ring	Displacement in ³ /rev (cm ³ /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

- | | |
|--------|----------------------|
| VT67EB | 1 = Keyed (SAE -CC) |
| | 2 = Keyed (no SAE) |
| | 3 = Splined (SAE -C) |
| | 4 = Splined (SAE-CC) |

Modification

Mounting W/connection variables

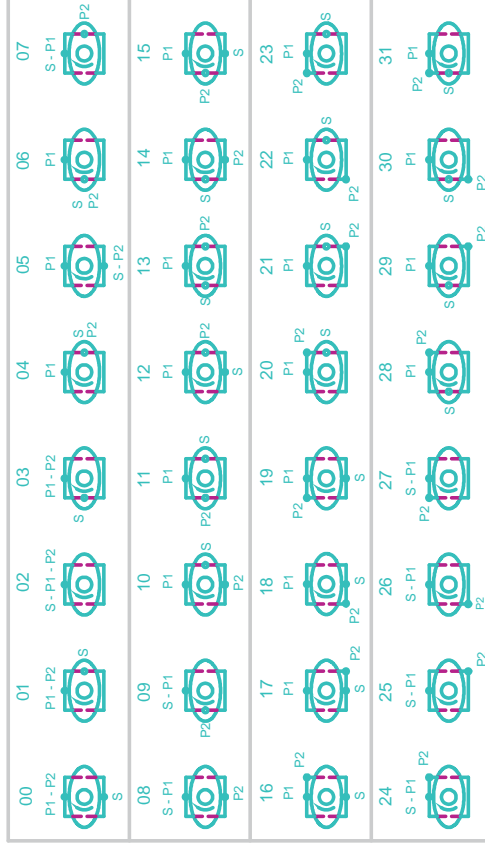
P1=1 1/2" P2=3/4" S=3/2"	
UNC	METRIC
01	M1

Seal class

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

Design letter

Porting combination : (00 = Standard)



Direction of rotation

- R = Clockwise
- L = Counter - clockwise