



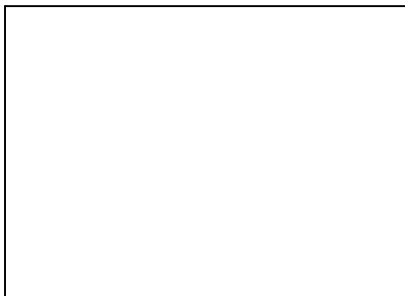
VELJAN

Service Information

SS4-00127

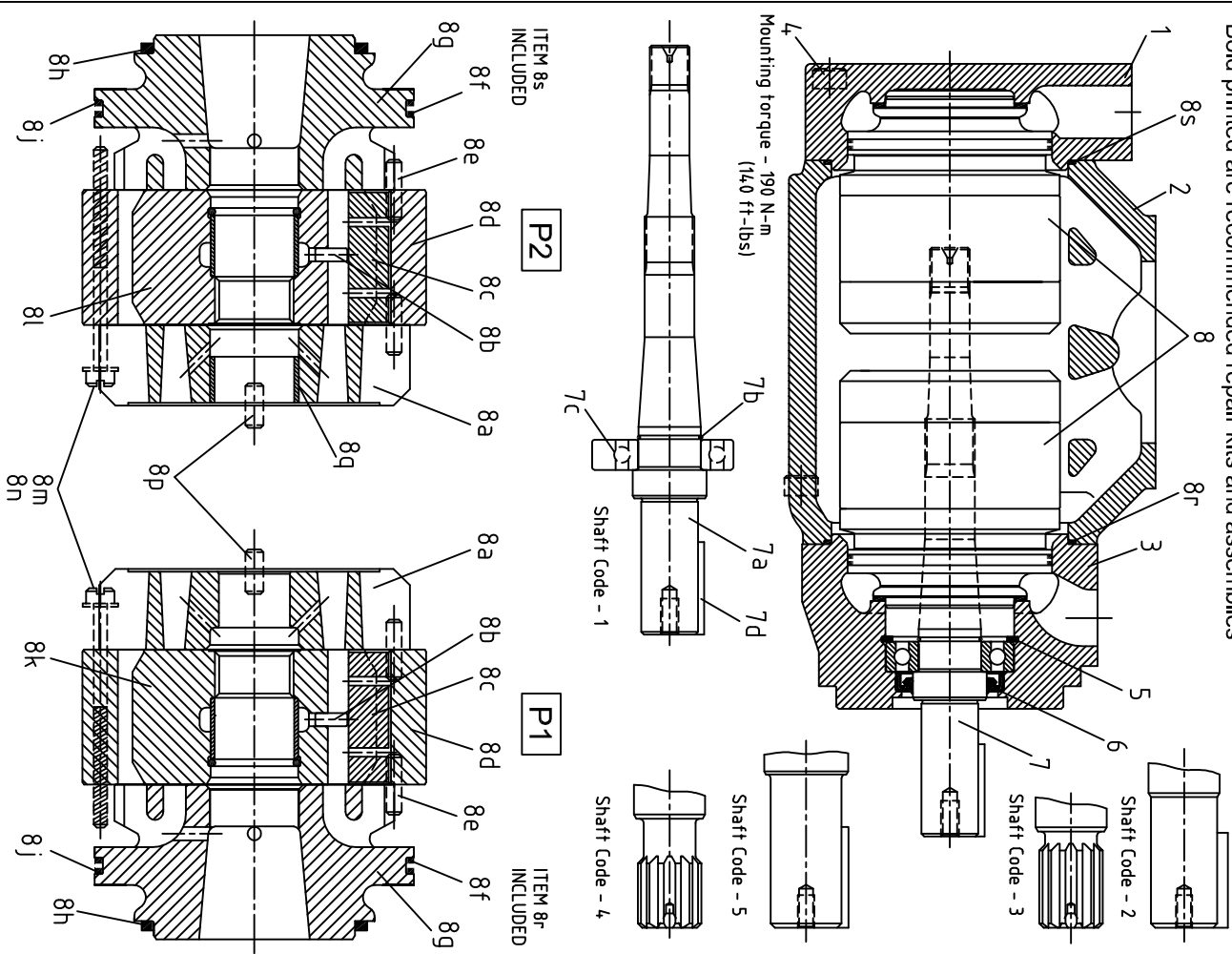
VT6DDS

Double vane pump



PHOTO

Bold printed are recommended repair kits and assemblies



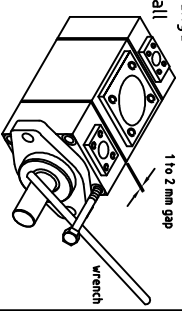
Item pos.	Description	Part No.		Qty
		VT6DDS	VT6DDS (B-dir plates)	
1	End cap (UNC)	V034-70275	V034-70275	1
	End cap (Metric)	H-034-66894	H-034-66894	1
2	Housing (UNC)	H-034-67341	H-034-67341	1
	Housing (Metric)	H-034-67340	H-034-67340	1
3	Mounting flange (UNC)	H-034-67343	H-034-67343	1
	Mounting flange (Metric)	H-034-67342	H-034-67342	1
4	Mounting Screw	C-314,001616	C-314,001616	8
5	Retaining ring	V356-32283	V356-32283	1
6	Shaft seal (S1-0.7 bar)	V620-82064	V620-82064	1
	Shaft seal (S4-S5-7 bar)	V620-82072	V620-82072	1
7	Shaft and bearing ass'y (Code-1)	VS24-72352	VS24-72352	1
	Shaft and bearing ass'y (Code-2)	VS24-72353	VS24-72353	1
	Shaft and bearing ass'y (Code-3)	VS24-72354	VS24-72354	1
	Shaft and bearing ass'y (Code-4)	VS24-72355	VS24-72355	1
	Shaft and bearing ass'y (Code-5)	VS24-72356	VS24-72356	1
7a	Shaft keyed (Code-1)	H-034-67344	H-034-67344	1
	Shaft keyed (Code-2)	H-034-67345	H-034-67345	1
	Shaft splined (Code-3)	H-034-67347	H-034-67347	1
	Shaft splined (Code-4)	H-034-67348	H-034-67348	1
	Shaft keyed (Code-5)	H-034-67346	H-034-67346	1
7b	Round section ring	V034-70853	V034-70853	1
7c	Ball bearing	V230-00207	V230-00207	1
7d	Key code-1	V034-46754	V034-46754	1
	Key code-2	V034-70330	V034-70330	1
	Key code-5	V034-66980	V034-66980	1
8	Cartridge assembly 014 C.W. (P1)	VS24-40791	VS24-63394	1
	Cartridge assembly 014 C.C.W. (P1)	VS24-40792	VS24-63395	1
	Cartridge assembly 017 C.W. (P1)	VS24-63800	VS24-63195	1
	Cartridge assembly 017 C.C.W. (P1)	VS24-63801	VS24-63196	1
	Cartridge assembly 020 C.W. (P1)	VS24-26490	VS24-26578	1
	Cartridge assembly 020 C.C.W. (P1)	VS24-26491	VS24-26579	1
	Cartridge assembly 024 C.W. (P1)	VS24-25891	VS24-26580	1
	Cartridge assembly 024 C.C.W. (P1)	VS24-25892	VS24-26581	1
	Cartridge assembly 028 C.W. (P1)	VS24-10849	VS24-10158	1
	Cartridge assembly 028 C.C.W. (P1)	VS24-10850	VS24-10159	1
	Cartridge assembly 031 C.W. (P1)	VS24-10851	VS24-10160	1
	Cartridge assembly 031 C.C.W. (P1)	VS24-10852	VS24-10161	1
	Cartridge assembly 035 C.W. (P1)	VS24-10853	VS24-10162	1
	Cartridge assembly 035 C.C.W. (P1)	VS24-10854	VS24-10163	1
	Cartridge assembly 038 C.W. (P1)	VS24-10855	VS24-10164	1
	Cartridge assembly 038 C.C.W. (P1)	VS24-10856	VS24-10165	1

Item pos.	Description	Part No.		Qty
		VT6DDS	VT6DDS (Bi-dir plates)	
	Cartridge assembly 042 C.C.W. (P1)	VS24-10857	VS24-10166	
	Cartridge assembly 042 C.C.W. (P1)	VS24-10858	VS24-10167	
	Cartridge assembly 045 C.C.W. (P1)	VS24-10859	VS24-10168	
	Cartridge assembly 045 C.C.W. (P1)	VS24-10860	VS24-10169	
	Cartridge assembly 050 C.C.W. (P1)	VS24-40236	VS24-51679	
	Cartridge assembly 050 C.C.W. (P1)	VS24-40237	VS24-51680	
	Cartridge assembly 061 C.C.W. (P1)	C-S14-72350	C-S14-71690	
	Cartridge assembly 061 C.C.W. (P1)	C-S14-72351	C-S14-71691	
	Cartridge assembly 014 C.C.W. (P2)	VS24-58160	VS24-58140	1
	Cartridge assembly 014 C.C.W. (P2)	VS24-58161	VS24-58141	
	Cartridge assembly 017 C.C.W. (P2)	VS24-59677	C-S14-72305	
	Cartridge assembly 017 C.C.W. (P2)	VS24-72348	C-S14-72306	
	Cartridge assembly 020 C.C.W. (P2)	VS24-58162	VS24-58142	
	Cartridge assembly 020 C.C.W. (P2)	VS24-58163	VS24-58143	
	Cartridge assembly 024 C.C.W. (P2)	VS24-58164	VS24-58144	
	Cartridge assembly 024 C.C.W. (P2)	VS24-58165	VS24-58145	
	Cartridge assembly 028 C.C.W. (P2)	VS24-58166	VS24-58146	
	Cartridge assembly 028 C.C.W. (P2)	VS24-58167	VS24-58147	
	Cartridge assembly 031 C.C.W. (P2)	VS24-58168	VS24-58148	
	Cartridge assembly 031 C.C.W. (P2)	VS24-58169	VS24-58149	
	Cartridge assembly 035 C.C.W. (P2)	VS24-58170	VS24-58150	
	Cartridge assembly 035 C.C.W. (P2)	VS24-58171	VS24-58151	
	Cartridge assembly 038 C.C.W. (P2)	VS24-58172	VS24-58152	
	Cartridge assembly 038 C.C.W. (P2)	VS24-58173	VS24-58153	
	Cartridge assembly 042 C.C.W. (P2)	VS24-58174	VS24-58154	
	Cartridge assembly 042 C.C.W. (P2)	VS24-58175	VS24-58155	
	Cartridge assembly 045 C.C.W. (P2)	VS24-58176	VS24-58156	
	Cartridge assembly 045 C.C.W. (P2)	VS24-58177	VS24-58157	
	Cartridge assembly 050 C.C.W. (P2)	VS24-58178	VS24-58158	
	Cartridge assembly 050 C.C.W. (P2)	VS24-58195	VS24-58159	
	Cartridge assembly 061 C.C.W. (P2)	C-S14-72173	C-S14-72325	
	Cartridge assembly 061 C.C.W. (P2)	C-S14-72174	C-S14-72326	
8a	Port plate - rear C.W. (P1)	V034-59811		1
	Port plate - rear C.C.W. (P1)	V034-59810		
	Port plate - rear C.W. (P2)	V034-59810		
	Port plate - rear C.C.W. (P2)	V034-59811		
8b	Pin vane holdout	V034-53588	V034-53588	20
8c	Vane	V034-59130	V034-59130	20
	Cam ring - 014	V034-66708	V034-66708	2
	Cam ring - 017	V034-67028	V034-67028	
	Cam ring - 020	V034-66596	V034-66596	
	Cam ring - 024	V034-59294	V034-59294	

Item pos.	Description	Part No.		Qty
		VT6DDS	VT6DDS (Bi-dir plates)	
	Cam ring - 028	V034-59133	V034-59133	
	Cam ring - 031	V034-59135	V034-59135	
	Cam ring - 035	V034-59137	V034-59137	
	Cam ring - 038	V034-59139	V034-59139	
	Cam ring - 042	V034-59132	V034-59132	
	Cam ring - 045	V034-59131	V034-59131	
	Cam ring - 050	V034-66737	V034-66737	
	Cam ring - 061	V034-67127	V034-67127	
8e	Dowel pin	V034-21612	V034-21612	4
8f	Back-up ring	V618-15017	V618-15017	2
8g	Pressure port plate C.W. (P1)	V034-59809		1
	Pressure port plate C.C.W. (P1)	V034-59808		
	Pressure port plate C.W. (P2)	V034-59808		
	Pressure port plate C.C.W. (P2)	V034-59809		
	Pressure port plate Bi-dir			
8h	Sq.section seal	V691-10232	V691-10232	2
8j	Sq.section seal	V691-10244	V691-10244	2
8k	Rotor-insert ass'y	VS24-10121	VS24-10121	1
8l	Rotor-insert ass'y	H-S24-51350	H-S24-51350	1
8m	Screw	V317-10320	V317-10320	4
8n	Lockwasher internal tooth	V348-10010	V348-10010	4
8p	Dowel pin	V323-82004	V323-82004	2
8q	Bearing bush	V034-70868	V034-70868	1
8r,8s	Sq.section seal	V691-10159	V691-10159	2
8f,8h	Seal kit (S1 - 0.7 bar)	VS24-72351	VS24-72351	1
8j, 6	Seal kit (S4 - 7 bar)	VS24-72351-4	VS24-72351-4	
8r,8s	Seal kit (S5 - 7 bar)	VS24-72351-5	VS24-72351-5	
8a,8p	Port plate - rear ass'y C.W. (P1)	VS24-10831	VS24-10831	1
	Port plate - rear ass'y C.C.W. (P1)	VS24-10832	VS24-10832	
8a,8p	Port plate - rear and bush ass'y C.W. (P2)	VS24-10830	VS24-10830	1
8q	Port plate - rear and bush ass'y C.C.W. (P2)	VS24-10829	VS24-10829	

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

VT6DDDS - 050 - 035 - 1 R 00 - A 1 00 -

Series _____
 VT6DDDS - SAE C 6 bolts
 Mounting flange j744c

Cam ring — Displacement — Cam ring — Displacement —

	in ³ /rev (cm ³ /rev)	in ³ /rev (cm ³ /rev)
014/B14 = 2.90 (4.7.6)	035/B35 = 6.80 (111.0)	
017/B17 = 3.55 (58.2)	038/B38 = 7.30 (120.3)	
020/B20 = 4.00 (66.0)	042/B42 = 8.30 (136.0)	
024/B24 = 4.80 (79.5)	045/B45 = 8.90 (145.7)	
028/B28 = 5.50 (89.7)	050/B50 = 9.64 (158.0)	
031/B31 = 6.00 (98.3)	061/B61 = 11.62 (190.5)	

Type of shaft _____

- 1 - keyed (SAE C)
- 2 - keyed (SAE CC)
- 3 - splined (SAE C)
- 4 - splined (SAE BB)
- 5 - keyed (no SAE)

Direction of rotation (view on shaft end) _____

- R - clockwise
- L - counter-clockwise

Modifications

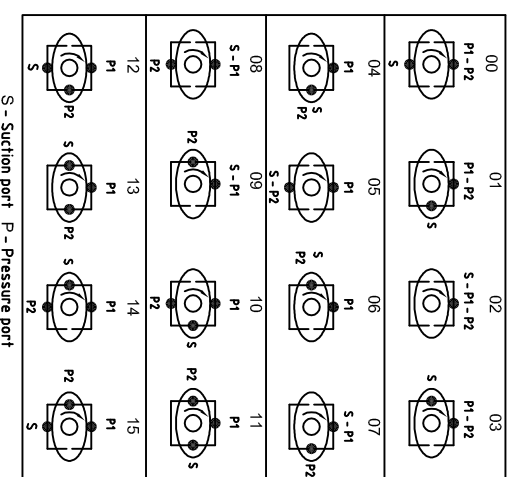
Mounting w/connection variables
 SAE 4 bolt flange (J518c)

	UNC	METRIC
VT6DDDS	00	M0

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

Design letter

Porting combination



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