

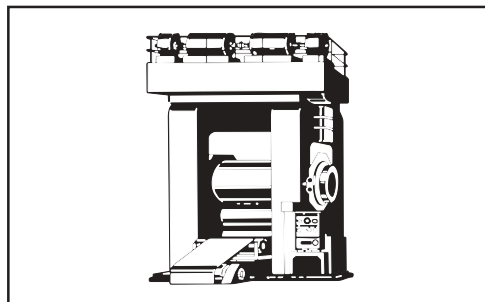
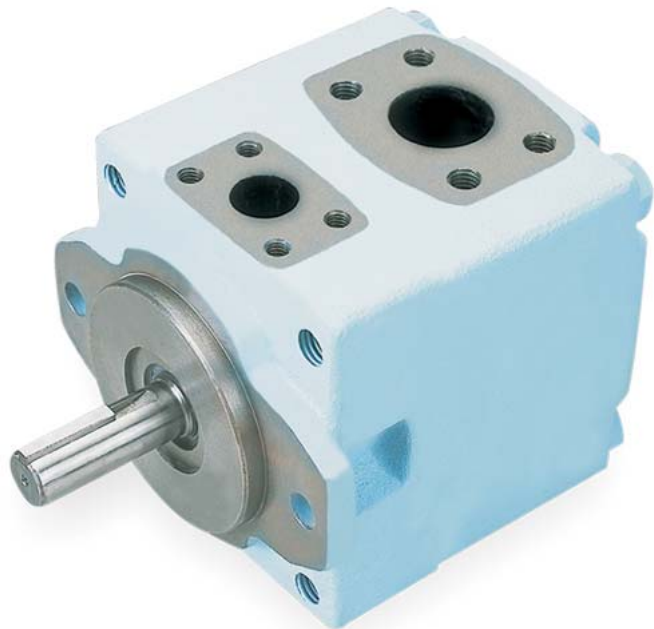
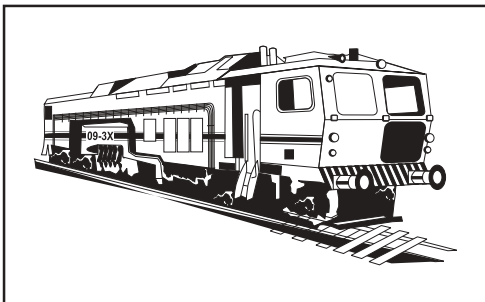
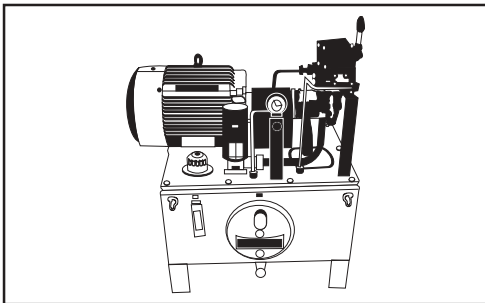
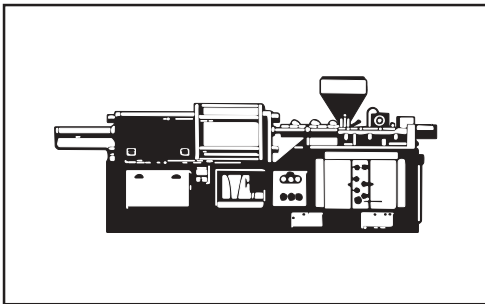


VELJAN

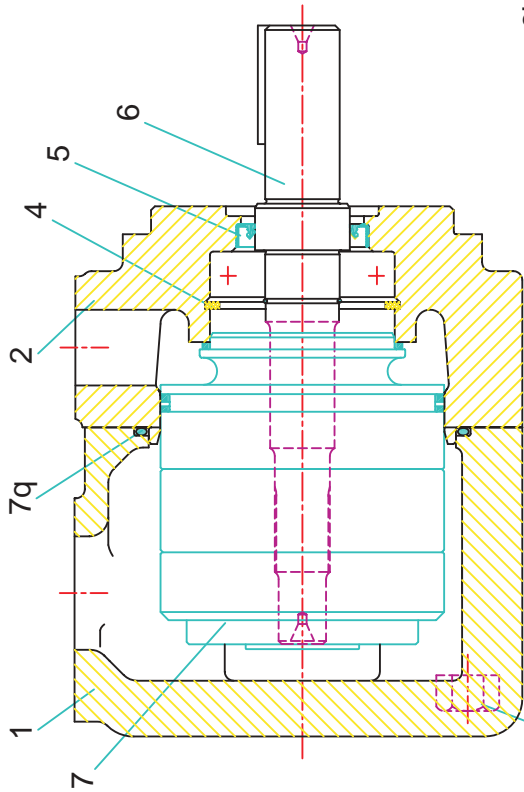
Service Information

SS4 - 00125

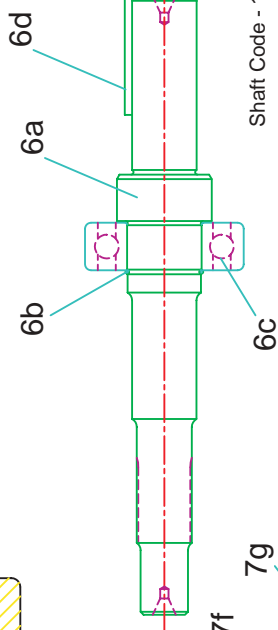
VT7B - VT7BS **Single vane pump**



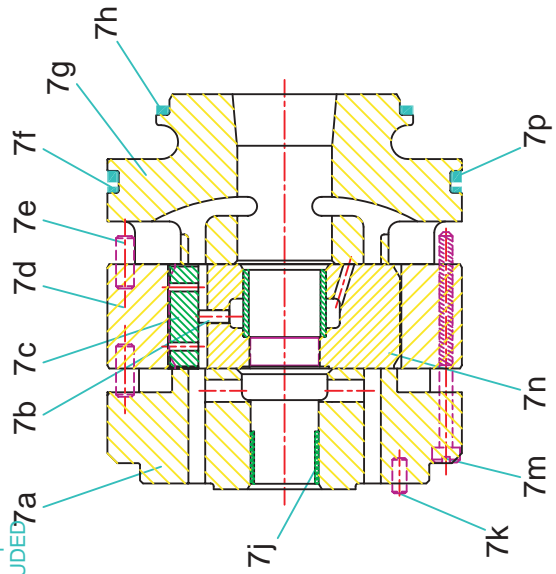
Bold printed are recommended repair kits and assemblies



3 — Mounting torque : 138 ft. lbs
(187 Nm)



ITEM 7q
INCLUDED



Item pos.	Description	Part No.	
		VT7B - VT7BS	Qty
1	Housing (UNC) Standard	H-034-66871	1
	Housing (Metric) (VT7B-VT7BS)	H-034-66869	
2	Mounting flange 1" (UNC)	H-034-66884	1
	Mounting flange 1" (Metric)	H-034-66883	
	Mounting flange 1" (Metric) (VT7B)	H-034-66928	
	Mounting flange 3/4" (UNC)	H-034-66925	
	Mounting flange 3/4" (Metric)	H-034-66926	
	Mounting flange 3/4" (Metric) (VT7B)	H-034-66927	
3	Mounting Screw	C-314011624	4
4	Retaining ring	V356-30244	1
5	Shaft seal (S1-0.7 bar)	V620-82046	1
	Shaft seal (S4-7 bar)	V620-82046-4	
	Shaft seal (S5-7 bar)	V620-82046-5	

6	Shaft and bearing assy (Keyed) (Code-1)	VS24-50140	1
	Shaft and bearing assy (Keyed) (Code-2) (VT7B-VT7BS)	VS24-50142	
	Shaft and bearing assy (Splined) (Code-3)	VS24-50141	
	Shaft and bearing assy (Splined) (Code-4)	VS24-59295	
6a	Shaft (Keyed) (Code-1)	H-034-66929	1
	Shaft (Keyed) (Code-2) (VT7B-VT7BS)	H-034-66930	
	Shaft (Splined) (Code-3)	H-034-66931	
	Shaft (splined) (Code-4)	C-034-03027	
6b	Round section ring	V034-70777	1
6c	Ball bearing	V230-82054	1
6d	Key (Code -1)	V034-48690	1
	Key (Code -2) (VT7B-VT7BS)	V211-00005-3	

Item pos.	Description	Part No.	
		VT7B - VT7BS	Qty
7	Cartridge assembly B02 C.C.W.	VS24-50144	1
	Cartridge assembly B02 C.C.W.	VS24-50145	
	Cartridge assembly B03 C.C.W.	VS24-50146	
	Cartridge assembly B03 C.C.W.	VS24-50147	
	Cartridge assembly B04 C.C.W.	VS24-50148	
	Cartridge assembly B04 C.C.W.	VS24-50149	
	Cartridge assembly B05 C.C.W.	VS24-50150	
	Cartridge assembly B05 C.C.W.	VS24-50151	
	Cartridge assembly B06 C.C.W.	VS24-50152	
	Cartridge assembly B06 C.C.W.	VS24-50153	
	Cartridge assembly B07 C.W.	VS24-59970	
	Cartridge assembly B07 C.C.W.	VS24-59971	
	Cartridge assembly B08 C.W.	VS24-50154	
	Cartridge assembly B08 C.C.W.	VS24-50155	
	Cartridge assembly B09 C.W.	VS24-77219	
	Cartridge assembly B09 C.C.W.	VS24-77220	
	Cartridge assembly B10 C.W.	VS24-50156	
	Cartridge assembly B10 C.C.W.	VS24-50157	
	Cartridge assembly B11 C.W.	VS24-77221	
	Cartridge assembly B11 C.C.W.	VS24-77233	
	Cartridge assembly B12 C.W.	C-S14-72044	
	Cartridge assembly B12 C.C.W.	C-S14-72045	
	Cartridge assembly B14 C.W.	VS24-72881	
	Cartridge assembly B14 C.C.W.	VS24-77224	
	Cartridge assembly B15 C.W.	C-S14-72040	
	Cartridge assembly B15 C.C.W.	C-S14-72041	
7a	Port plate - rear Bi-dir	H-034-66921	1
7b	Pin vane holdout	H-034-66920	12
7c	Vane	H-034-66917	12
7d	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	

Item pos.	Description	Part No.	
		VT7B - VT7BS	Qty
	Cam ring - B15	C-034-03218	
7e	Dowel pin	V324-21208	2
7f	Back-up ring	V618-15016	1
7g	Port plate - pressure Bi-dir	H-034-66923	1
7h	Sq. section seal	V691-10229	1
7j	Bush	V034-71867	1
7k	Dowel pin	V323-82010	1
7m	Screw	V317-06266	2
7n	Rotor-insert assy	H-S24-49820	1
7p	Sq. section seal	V691-10238	1
7q	O' ring	V671-00244	1
5, 7f,	Seal kit (S1 - 0.7 bar)	VS24-49112	1
7h,7p,	Seal kit (S4 - 7 bar)	VS24-49112-4	
7q,	Seal kit (S5 - 7 bar)	VS24-49112-5	
7a,7j	Port plate - rear and bush assy	VS24-49791	1
7k			

MODEL CODE

VT7B / VT7BS - B10 - 1 R 00 - A 1 - M0 -

Series

VT7B series-100 A2 HW
ISO 2 bolts 3019-2 mounting flange
VT7BSseries- SAE B 2 bolts
Mounting flange J744c

Cam ring — Displacement — Cam ring — Displacement

	in ³ /rev (cm ³ / rev)		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

VT7BS

- 1 = Keyed (SAE- B)
- 3 = Splined (SAE B)
- 4 = Splined (SAE BB)

VT7B - VT7BS

- 2 = Keyed (ISO R775)

Modification

Mounting W/connection variables
4 bolts SAE flange (J518C)

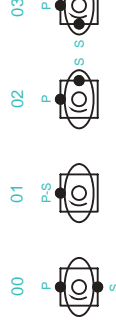
UNC	METRIC
VT7BS	VT7B-VT7BS
00	01
P	1"
S	1 1/2"

Seal class

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

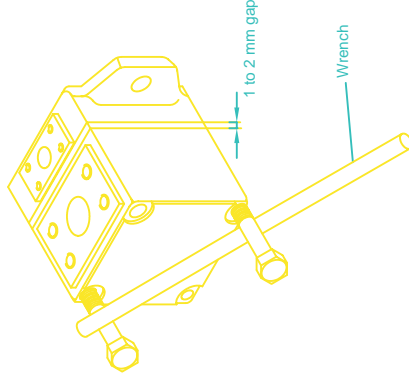
Design letter

Porting combination : (00 = Standard)



Direction of rotation

- R = Clockwise
- L = Counter - clockwise



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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