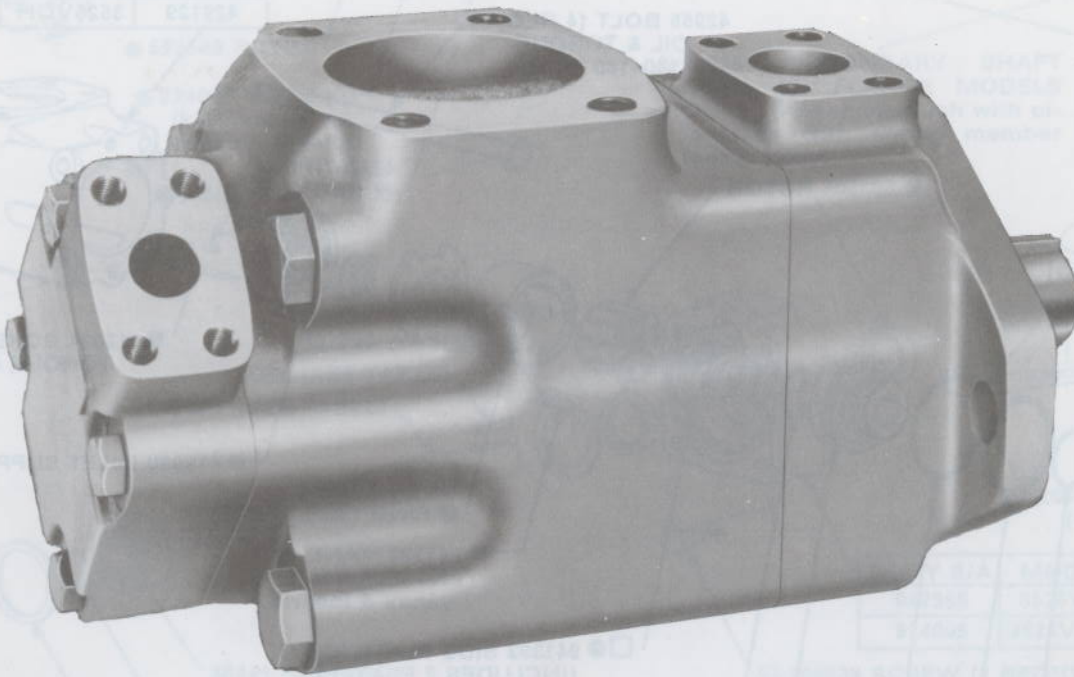




# Service Parts Information

Double  
Pumps

(F3)-3525VQ(H) Series  
- 30 Design



Vickers, Incorporated

1401 Crooks Road  
Troy, Michigan 48084

Released 10-1-87 M-2506-S

MODEL	REV	DATE	DESCRIPTION
3525VQ(H)-30	00001	08/18/87	INITIAL DESIGN
3525VQ(H)-30	00002	09/15/87	REVISED TO INCLUDE MOUNTING BRACKET
3525VQ(H)-30	00003	10/10/87	REVISED TO INCLUDE PORT PLATE
3525VQ(H)-30	00004	11/05/87	REVISED TO INCLUDE SEALBACK PLATE
3525VQ(H)-30	00005	12/01/87	REVISED TO INCLUDE WELD KNUCKLES
3525VQ(H)-30	00006	01/08/88	REVISED TO INCLUDE SUPPORT PLATE
3525VQ(H)-30	00007	02/05/88	REVISED TO INCLUDE GASKET
3525VQ(H)-30	00008	03/05/88	REVISED TO INCLUDE O-RING
3525VQ(H)-30	00009	04/05/88	REVISED TO INCLUDE BUSHING
3525VQ(H)-30	00010	05/05/88	REVISED TO INCLUDE BALL BEARING
3525VQ(H)-30	00011	06/05/88	REVISED TO INCLUDE HOSE END
3525VQ(H)-30	00012	07/05/88	REVISED TO INCLUDE HOSE END
3525VQ(H)-30	00013	08/05/88	REVISED TO INCLUDE HOSE END
3525VQ(H)-30	00014	09/05/88	REVISED TO INCLUDE HOSE END
3525VQ(H)-30	00015	10/05/88	REVISED TO INCLUDE HOSE END
3525VQ(H)-30	00016	11/05/88	REVISED TO INCLUDE HOSE END
3525VQ(H)-30	00017	12/05/88	REVISED TO INCLUDE HOSE END
3525VQ(H)-30	00018	01/05/89	REVISED TO INCLUDE HOSE END
3525VQ(H)-30	00019	02/05/89	REVISED TO INCLUDE HOSE END
3525VQ(H)-30	00020	03/05/89	REVISED TO INCLUDE HOSE END
3525VQ(H)-30	00021	04/05/89	REVISED TO INCLUDE HOSE END
3525VQ(H)-30	00022	05/05/89	REVISED TO INCLUDE HOSE END
3525VQ(H)-30	00023	06/05/89	REVISED TO INCLUDE HOSE END
3525VQ(H)-30	00024	07/05/89	REVISED TO INCLUDE HOSE END
3525VQ(H)-30	00025	08/05/89	REVISED TO INCLUDE HOSE END
3525VQ(H)-30	00026	09/05/89	REVISED TO INCLUDE HOSE END
3525VQ(H)-30	00027	10/05/89	REVISED TO INCLUDE HOSE END
3525VQ(H)-30	00028	11/05/89	REVISED TO INCLUDE HOSE END
3525VQ(H)-30	00029	12/05/89	REVISED TO INCLUDE HOSE END
3525VQ(H)-30	00030	01/05/90	REVISED TO INCLUDE HOSE END

# 3525VQ(H)-\*\*\*-30

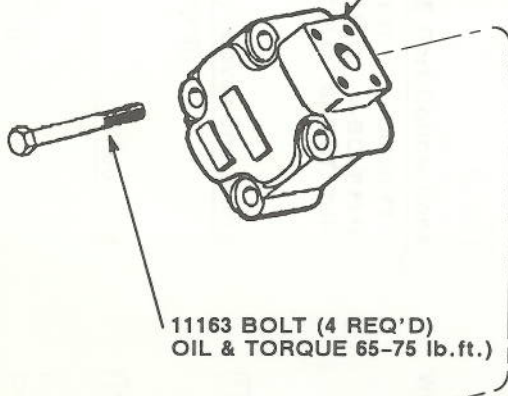
COVER	MODEL
231532	3525VQ**A-***-30
242250	3525VQ**E-***-30
429133	3525VQH**A-***-30

### NOTE

Seals must be completely wetted at time of assembly with an SAE 10W motor oil of "SE" quality or an industrial hydraulic equivalent.

### CAUTION

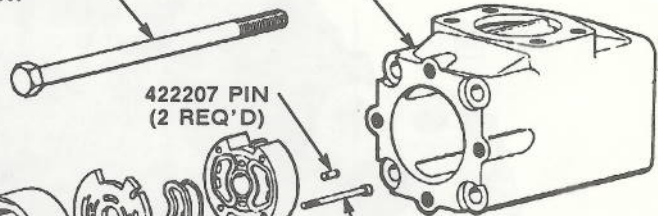
Individual cartridge parts are not interchangeable with similar parts of the previous design. Complete cartridges are interchangeable with the previous design.



11163 BOLT (4 REQ'D)  
OIL & TORQUE 65-75 lb.ft.)

42955 BOLT (4 REQ'D)  
OIL & TORQUE  
140-160 lb. ft.

HOUSING	MODEL
230189	3525VQ
429129	3525VQH



422207 PIN  
(2 REQ'D)

413834 SCREW (2 REQ'D)  
TORQUE 40-50 lb.in.

● 593506 ROTOR

● 419080 INLET SUPPORT PLATE

● RING (SEE TABLE)

● 941392 VANE KIT  
Kit includes 10  
vanes & inserts

□ ● 941393 SIDE PLATE KIT  
(INCLUDES 2 PLATES)

□ ▲ ▲ ● 433763 SEALPACK (4 REQ'D)

● 596033 OUTLET SUPPORT PLATE

▲ ▲ ● 154095 "O" RING

▲ ▲ ● 419673 SEALING RING

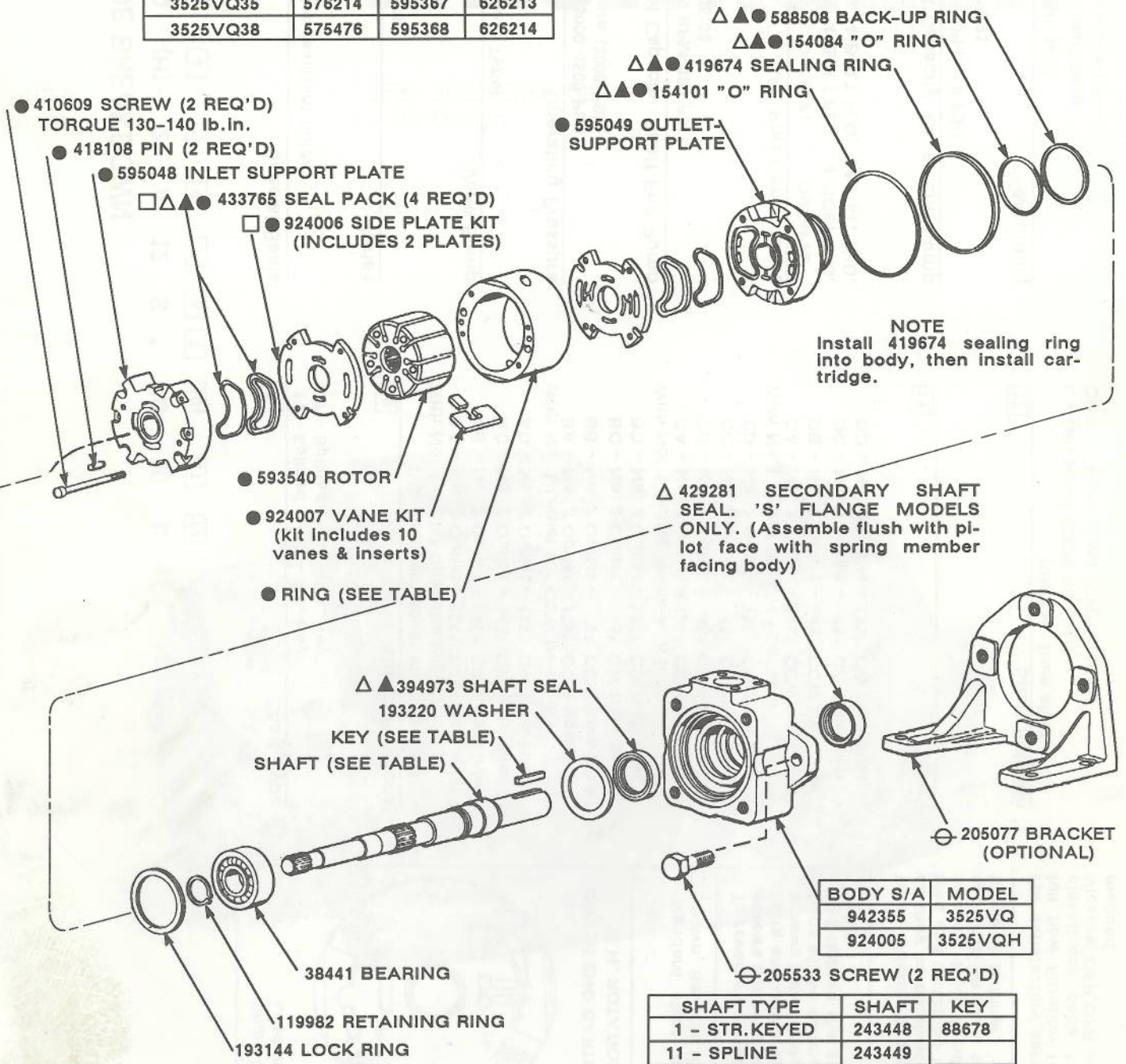
▲ ▲ ● 154078 "O" RING

▲ ▲ ● 588507 BACK-UP RING

**NOTE**  
Install 419673 sealing ring  
into cover, then install car-  
tridge.

MODEL (COVER END)	Ring	Cartridge Kit	
		Std	F3
3525VQ(H)-12	326984	595676	597179
3525VQ(H)-14	326985	595677	597180
3525VQ(H)-17	326986	595678	597181
3525VQ(H)-19	326987	595680	597183
3525VQ(H)-21	326988	595679	597182

MODEL (SHAFT END)	RING	CARTRIDGE KIT	
		STD	F3
3525VQ21	595378	595364	626210
3525VQ25	576210	595365	626211
3525VQ30	576212	595366	626212
3525VQ35	576214	595367	626213
3525VQ38	575476	595368	626214



BODY S/A	MODEL
942355	3525VQ
924005	3525VQH

SHAFT TYPE	SHAFT	KEY
1 - STR.KEYED	243448	88678
11 - SPLINE	243449	
86 - STR.KEYED	394036	393536
137 - SPLINE	428618	

Wipe O.D. of shaft seals with oil before pressing into body. Apply grease to seal I.D. before installation of shaft. Assemble seal with spring member toward bearing.

- INCLUDED IN STD CART. KIT (SEE TABLE)  
EQUIVALENT F3 CARTRIDGE KIT (SEE TABLE)
- ▲ INCLUDED IN STD SINGLE SHAFT SEAL KIT 920056  
EQUIVALENT F3 SINGLE SHAFT SEAL KIT 920058
- ▲ INCLUDED IN STD DOUBLE SHAFT SEAL KIT 920057  
EQUIVALENT F3 DOUBLE SHAFT SEAL KIT 920059
- INCLUDED IN SIDE PLATE KIT  
(BRONZE SURFACE MUST FACE ROTOR)
- ⊖ INCLUDED IN FOOT BRACKET FB-C-10

# MODEL CODE BREAKDOWN

(F3) 3525 VQ (H) 21 A 12 S \* CC 30 L

1 2 3 4 5 6 7 8 9 10 11 12

1 Special Seals

For mineral oil & fire resistant fluids.

9 Shaft Type

11 - Splined 1 - Str. Key  
137 - Splined 86 - Str. Key

2 3525VQ Double Pump Series

10 Outlet Positions

(Viewed from cover end of pump)

With No. 1 Outlet Opposite Inlet:

AA - No. 2 Outlet - 135° CCW from Inlet  
AB - No. 2 Outlet - 45° CCW from Inlet  
AC - No. 2 Outlet - 45° CW from Inlet  
AD - No. 2 Outlet - 135° CW from Inlet

With No. 1 Outlet 90° CCW from Inlet:

BA - No. 2 Outlet - 135° CCW from Inlet  
BB - No. 2 Outlet - 45° CCW from Inlet  
BC - No. 2 Outlet - 45° CW from Inlet  
BD - No. 2 Outlet - 135° CW from Inlet

With No. 1 Outlet Inline with Inlet

CA - No. 2 Outlet - 135° CCW from Inlet  
CB - No. 2 Outlet - 45° CCW from Inlet  
CC - No. 2 Outlet - 45° CW from Inlet  
CD - No. 2 Outlet - 135° CW from Inlet

With No. 1 Outlet 90° CW from Inlet

DA - No. 2 Outlet - 135° CCW from Inlet  
DB - No. 2 Outlet - 45° CCW from Inlet  
DC - No. 2 Outlet - 45° CW from Inlet  
DD - No. 2 Outlet - 135° CW from Inlet

4 Operating Pressure

H-High Pressure (3000-3500 PSI)  
Omit-Rated Pressure (3000 PSI)

5 US GPM Capacity Shaft End Pump

(SAE RATING 1200 RPM-100 PSI)  
21, 25, 30, 35, 38

6 SAE Port Connections

Code Inlet Outlet #1 Outlet #2  
A 4-BOLT FLG. 4-BOLT FLG. 4-BOLT FLG.  
E 4-BOLT FLG. 4-BOLT FLG. SAE ST. THD.

7 US GPM Capacity Cover End Pump

(SAE RATING 1200 RPM-100 PSI)  
12, 14, 17, 19, 21

8 Mounting

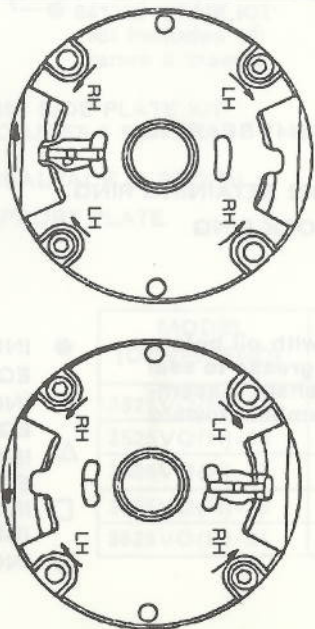
F-Foot (Single Shaft Seal)  
S-Flange (Double Shaft Seal)  
Omit-Flange (Single Shaft Seal)

12 Shaft Rotation

(Viewed from shaft end)  
L - Left Hand (CCW Rotation)  
Omit - Right Hand (CW Rotation)

11 Design

Sharp Edges of Vane Must Lead in Direction of Rotation



### NOTE

Standard right hand shaft rotation cartridges shown. Reverse for left hand rotation.

To reverse cartridge kit rotation, remove the two screws and reverse the location of the inlet support plate and outlet support plate. Re-install the two screws hand tight. Use pump cover to align all sections of the cartridge. Carefully remove the cover and tighten the screws to recommended torque value.

When ordering spare cartridge parts, it is recommended they be obtained in cartridge kits. Kits are assembled and tested by Vickers for either right or left hand rotation. If left hand rotation is required, it should be specified on parts order by adding suffix " L " to cartridge kit number.

For satisfactory service life of these components, use full flow filtration to provide fluid which meets ISO cleanliness code 18/15 or cleaner. Selections from Vickers OFF, OFR and OFRS filter series are recommended.