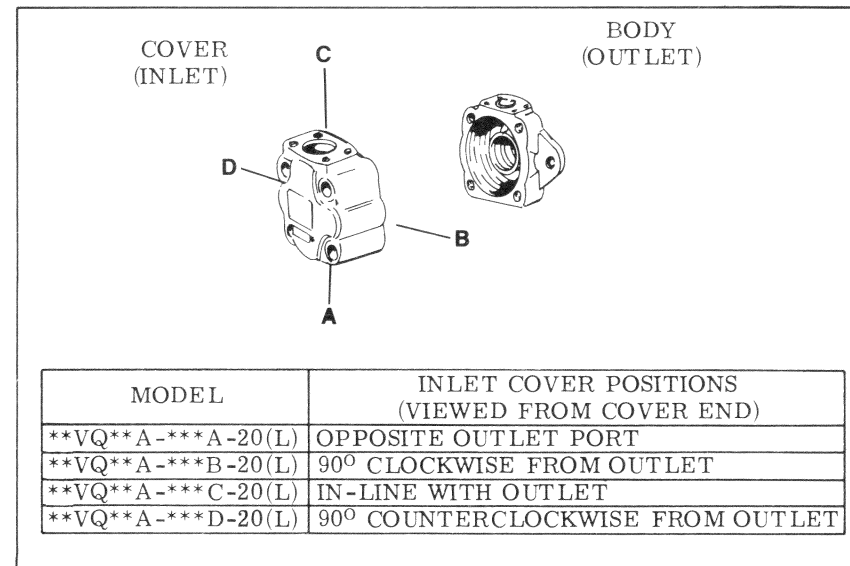


MODEL CODE BREAKDOWN

(F3) – ** VQ ** A * – * * * 20 (*)

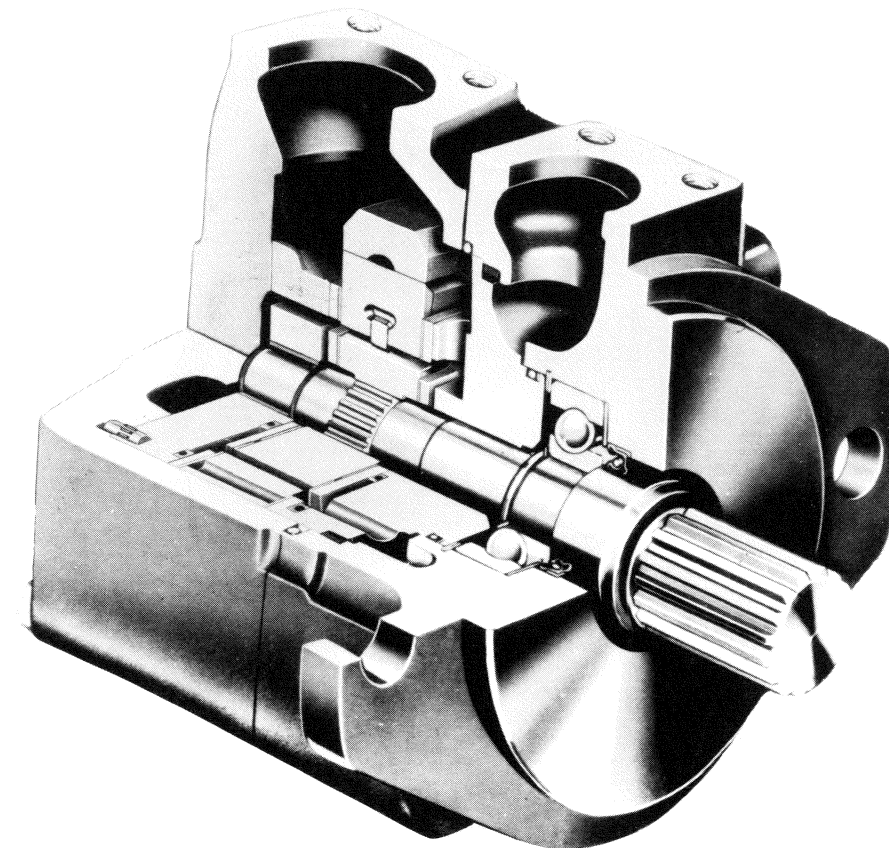
1 2 3 4 5 6 7 8 9 10

<p>1 VITON SEALS (OMIT IF NOT REQUIRED)</p> <p>2 SERIES 25, 26, 30, 31</p> <p>3 VANE TYPE</p> <p>4 SAE RATED CAPACITY (RATING AT 1200 RPM – 100 PSI) SEE CAPACITY (USGPM) – SEE TABLE INSIDE</p> <p>5 PORT CONNECTIONS</p> <table border="0"> <tr> <td>CODE</td> <td>INLET CONNECTION</td> <td>OUTLET CONNECTION</td> </tr> <tr> <td>A</td> <td>SAE 4-BOLT</td> <td>SAE 4-BOLT</td> </tr> <tr> <td>B</td> <td>SAE STR. THD.</td> <td>SAE STR. THD.</td> </tr> <tr> <td>C</td> <td>SAE 4-BOLT</td> <td>SAE STR. THD.</td> </tr> <tr> <td>D</td> <td>SAE STR. THD.</td> <td>SAE 4-BOLT</td> </tr> </table>	CODE	INLET CONNECTION	OUTLET CONNECTION	A	SAE 4-BOLT	SAE 4-BOLT	B	SAE STR. THD.	SAE STR. THD.	C	SAE 4-BOLT	SAE STR. THD.	D	SAE STR. THD.	SAE 4-BOLT	<p>6 MOUNTING & SHAFT SEALS ASSY. F – FOOT (SINGLE SHAFT SEAL ASSY.) S – FLANGE (DOUBLE SHAFT SEAL ASSY.) OMITTED – FLANGE (SINGLE SHAFT SEAL ASSY.)</p> <p>7 SHAFTS SEE TABLE INSIDE</p> <p>8 PORT POSITIONS (SEE CHART BELOW)</p> <p>9 DESIGN</p> <p>10 ROTATION (VIEWED FROM SHAFT END) L – LEFT HAND (CCW ROTATION) OMITTED – RIGHT HAND ROTATION</p>
CODE	INLET CONNECTION	OUTLET CONNECTION														
A	SAE 4-BOLT	SAE 4-BOLT														
B	SAE STR. THD.	SAE STR. THD.														
C	SAE 4-BOLT	SAE STR. THD.														
D	SAE STR. THD.	SAE 4-BOLT														



Vane Type Single Pump

25/26/30/31 VQ Series –20 Design



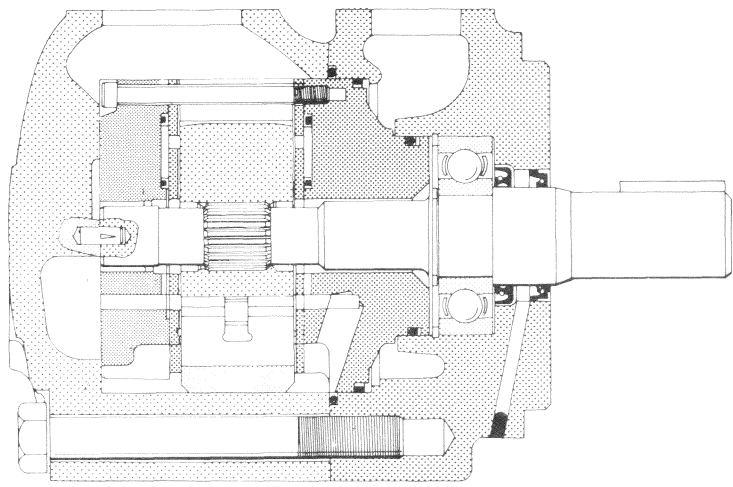
PARTS ORDERING

PARTS ARE THE SAME FOR BOTH RIGHT AND LEFT HAND ROTATION. WHEN ORDERING SPARE CARTRIDGE PARTS, IT IS RECOMMENDED THEY BE OBTAINED IN CARTRIDGE KITS. KITS ARE ASSEMBLED AND TESTED 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 KIT NUMBER. FOR EXAMPLE, 416439-L.

Vickers Incorporated
A TRINOVA Company
5445 Corporate Drive
P. O. Box 302
Troy, Michigan 48007-0302
U.S.A.

For satisfactory service life of these components, use full flow filtration to provide fluid which meets ISO cleanliness code 16/13 or cleaner. Selections from pressure, return, and in-line filter series are recommended.

Litho in U. S. A.



⊖ TO REVERSE CARTRIDGE KIT ROTATION, REMOVE THE TWO (2) 413834 SCREWS, AND REVERSE THE LOCATION OF THE INLET SUPPORT PLATE 430805 AND OUTLET SUPPORT PLATE 419079. REINSTALL THE TWO (2) SCREWS HAND TIGHT. USE PUMP COVER TO ALIGN ALL SECTIONS OF THE CARTRIDGE. REMOVE COVER CAREFULLY AND TIGHTEN SCREWS TO 50 lb. in. TORQUE.

□ WIPE O. D. OF SEAL WITH OIL BEFORE PRESSING INTO BODY. APPLY GREASE TO SEAL I. D. BEFORE INSTALLATION OF SHAFT.

*INCLUDED IN CARTRIDGE KIT

▲ INCLUDED IN SINGLE SHAFT SEAL KIT 920021
F3 EQUIVALENT 920023

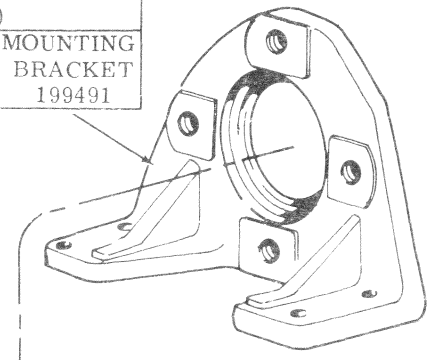
▲▲ INCLUDED IN DOUBLE SHAFT SEAL KIT 920022
F3 EQUIVALENT 920024

○ ASSEMBLE SEAL WITH SPRING LOADED SEALING MEMBER TOWARD BEARING.

● ASSEMBLE SEAL FLUSH WITH PILOT FACE WITH SPRING LOADED SEALING MEMBER FACING INWARD AS SHOWN.

MOUNTING ASSEMBLY **VQ**F-**-20(L)		
INCLUDED IN MOUNTING KIT FB-B-10	SCREW (2 REQ'D) 205533	MOUNTING BRACKET 199491

BODY S/A	MODEL
942353	2*VQA/D-**-20
942378	2*VQB/C-**-20
942354	3*VQA/D-**-20
942378	3*VQB/C-**-20



MODEL	TYPE DUTY	BEARING
25VQ	STANDARD	1705
26VQ	HEAVY DUTY	232750
30VQ	STANDARD	1705
31VQ	HEAVY DUTY	232750

▲ 429283 SHAFT SEAL (USE ON "S" FLANGE MOUNTED MODELS ONLY)

▲ 394976 SHAFT SEAL

190362 WASHER

KEY (SEE TABLE)

KEY (SEE TABLE)

SCREW (SEE TABLE)

NUT (SEE TABLE)

MODEL DESIGNATION	SCREW (4 REQ'D) (TORQUE TO 65-75 lb. ft.)	COVER
2*VQ*A/C-(-)***-20(*)		224309
2*VQ*B/D-(-)***-20(*)	96168	242215
3*VQ*A/C-(-)***-20(*)		224526
3*VQ*B/D-(-)***-20(*)	119805	242214

NOTE
BRONZE FACES MUST BE INSTALLED TOWARD THE ROTOR.

*▲ 419673 RING SEALING (ASSEMBLY NOTE: INSTALL IN BODY BEFORE INSTALLATION OF CARTRIDGE KIT.)

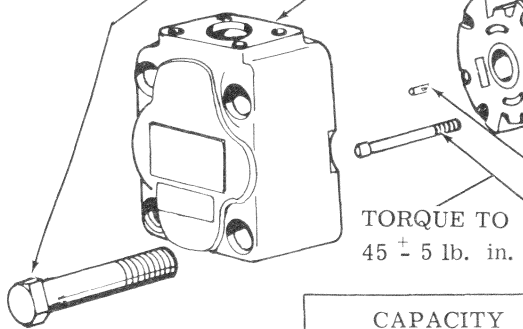
*▲ 154095 "O" RING

*▲ 154078 "O" RING

*▲ 588507 BACK-UP RING

120128 SNAP RING

191400 SNAP RING

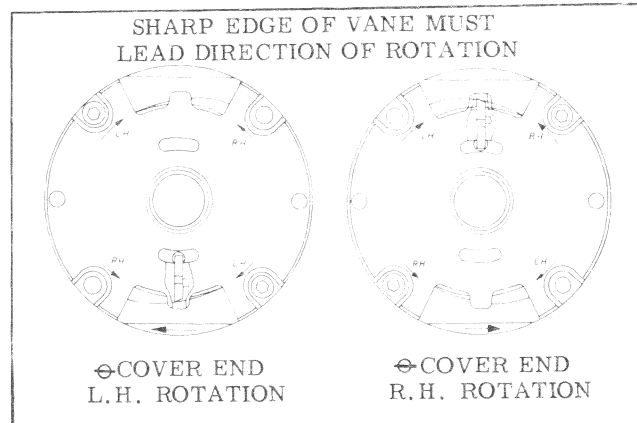


TORQUE TO 45 ± 5 lb. in.

NOTE:
USE 25VQ PARTS TO SERVICE 25V -10/12 DESIGN UNITS.

SINGLE SEAL MODELS		DOUBLE SEAL MODELS		KEY	NUT	TYPE
SHAFT NO.	PART NO.	SHAFT	PART NO.			
1	238755	—	—	9955	—	STRAIGHT, KEYED
3	242747	—	—	1617	18755	KEYED WITH NUT
6	242767	—	—	1617	—	KEYED SHAFT
11	238929	—	—	—	—	SPLINE
86	419082	—	—	3418	—	STRAIGHT, KEYED, HEAVY DUTY

CAPACITY (USGPM)	SCREW (2 REQ'D)	PIN (2 REQ'D)	INLET SUPPORT PLATE	▲ SEAL PACK (4 REQ'D)	FLEX-SIDE PLATE KIT	ROTOR	VANE KIT (10 VANES & 10 INSERTS)	RING	OUTLET SUPPORT PLATE	CART. KIT	F3 CART. KIT
THESE PARTS ARE INCLUDED IN CARTRIDGE KIT											
2*VQ12A-(-)***-20(*)	413834	422207	430805 (INCLUDES BUSHING)	433764 S/A	923956	270597	922710	326984	419079	416439	421570
2*VQ14A-(-)***-20(*)										416440	421571
2*VQ17A-(-)***-20(*)										416441	421572
2*VQ19A-(-)***-20(*)										421232	421573
2*VQ21A-(-)***-20(*)										416442	421574
3*VQ24A-(-)***-20(*)	416454					262152	922648	234470	417052	421645	
3*VQ28A-(-)***-20(*)								224525	416452	421646	



WARNING: USE THIS DRAWING FOR PARTS INFORMATION ONLY. SEE OVERHAUL MANUAL I-3144-S FOR MAINTENANCE INFORMATION