

ENGINEERING
TOMORROW



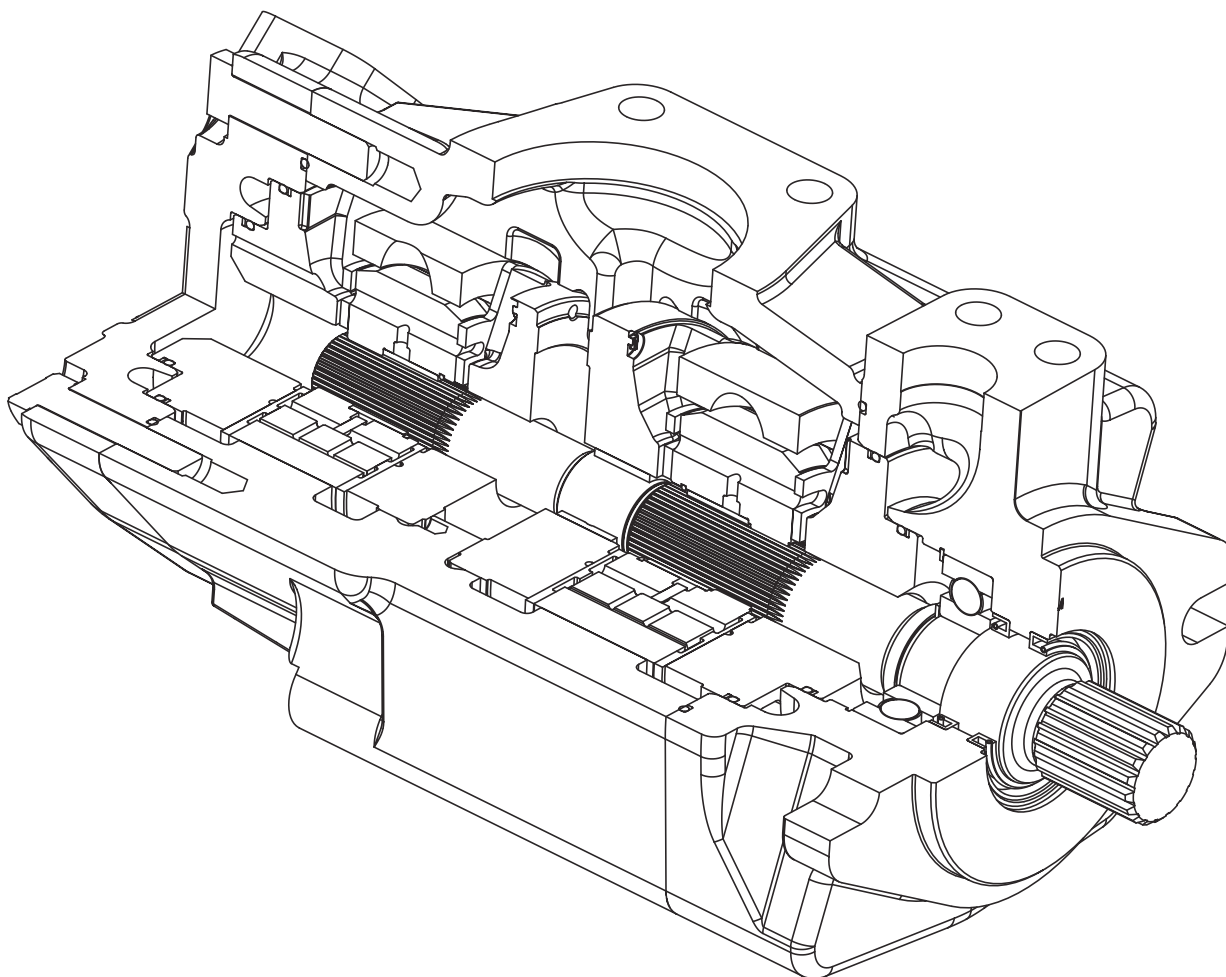
Vickers® by Danfoss

**High Pressure, High Performance
Double Vane Pumps**

Parts and Service Manual

AX438767571861en-000101

VMQ22525S Series
– 32 Design



VICKERS®

High Pressure,
High Performance
Double Vane Pump
VMQ22525S Series
— 32 Design

Note Lubricate all parts and seals with a thin coat of oil at assembly.

- Included in Cartridge Kit (see table)
- ▲ Included in 02-334552 Buna-N Seal Kit, Single Shaft Seal or 02-334553 Viton® Seal Kit, Single Shaft Seal.
- △ Included in 02-334635 Buna-N Seal Kit, Double Shaft Seal or 02-334636 Viton® Seal Kit, Double Shaft Seal.
- * With double and triple pumps, the orientation of the kits is such that the kit rotation is a reverse of the pump rotation. See tables X1 and X2 for the correct kit rotation relative to the pump rotation.

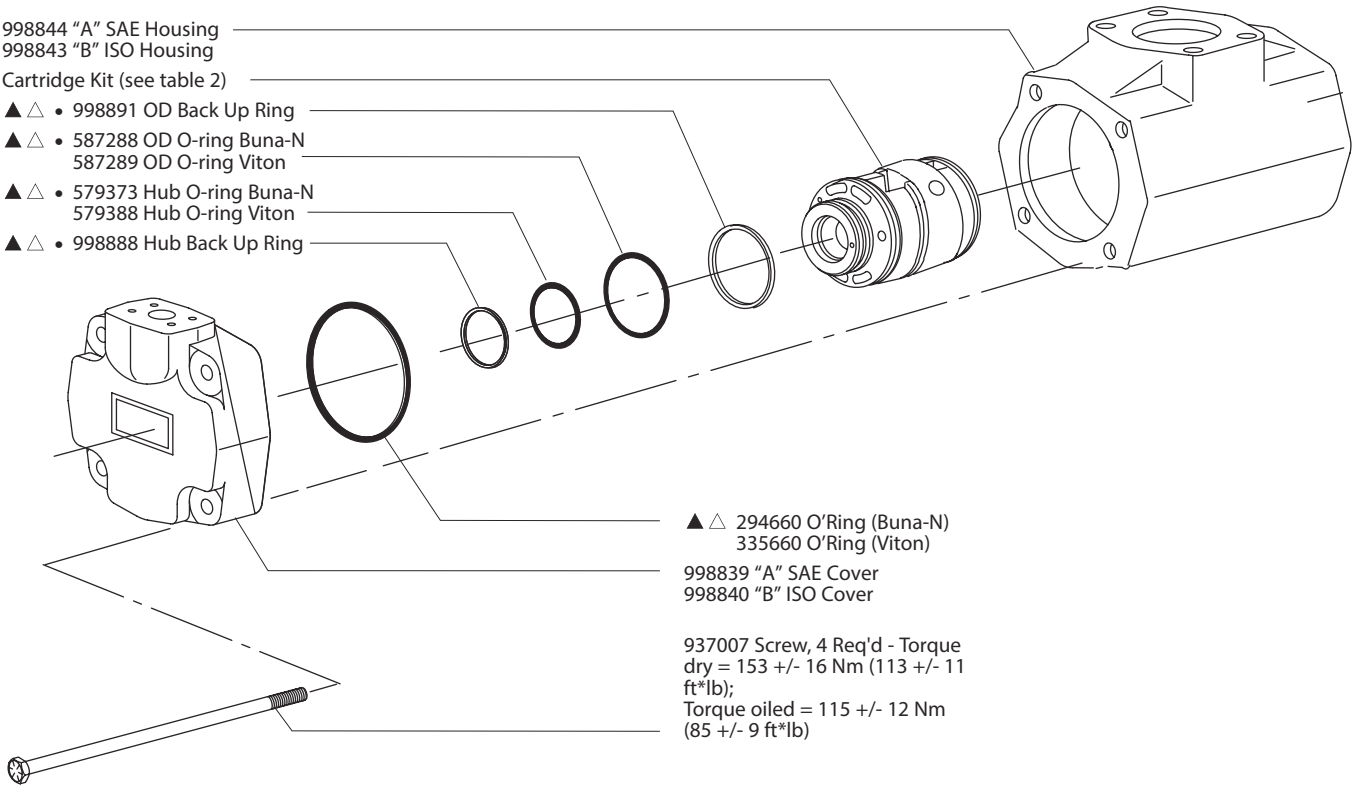


TABLE X1

Cartridge Kit Rotation for Right Hand Rotation Pump

R= Right Hand Rotation		L=Left Hand Rotation	
PUMP ROTATION	SHAFT END KIT ROTATION	CENTER KIT ROTATION	COVER END KIT ROTATION
Double (R)	(R)	-	(L)

*Notes: - A right hand rotation pump has the shaft turning clockwise when viewed from the input shaft end
- When ordering a right hand rotation kit, the part number will not have a suffix

TABLE X2

Cartridge Kit Rotation for Left Hand Rotation Pump

R= Right Hand Rotation		L=Left Hand Rotation	
PUMP ROTATION	SHAFT END KIT ROTATION	CENTER KIT ROTATION	COVER END KIT ROTATION
Double (L)	(L)	-	(R)

*Notes: - A left hand rotation pump has the shaft turning counterclockwise when viewed from the input shaft end
- When ordering a left hand rotation kit, the part number will have a suffix of '-L'

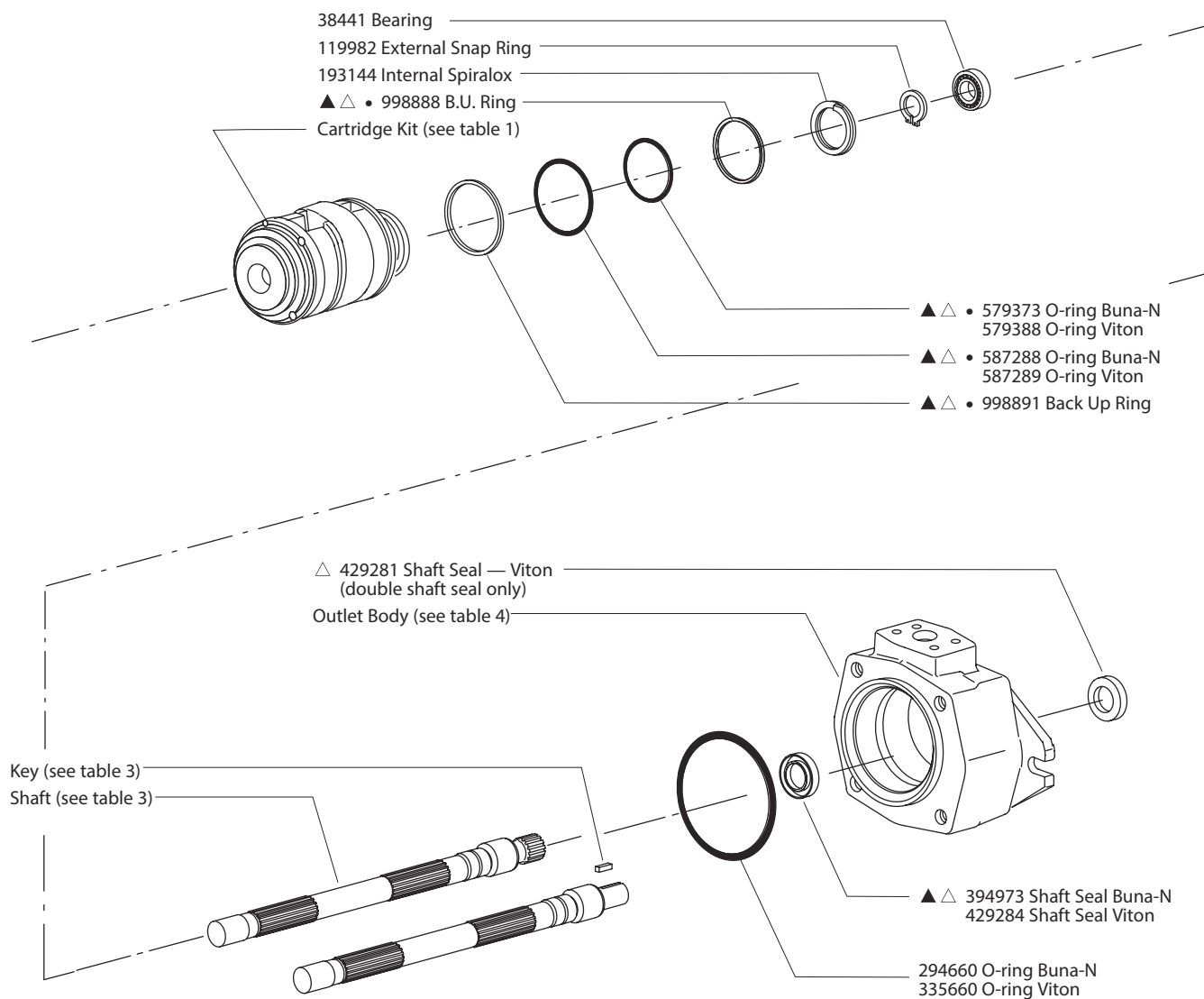


TABLE 1

MODEL CODE SHAFT END	* • CARTRIDGE KIT (BUNA-N)	* • CARTRIDGE KIT (VITON®)
VMQ22525S010***	02-465574	02-465569
VMQ22525S016***	02-465575	02-465570
VMQ22525S020***	02-465576	02-465571
VMQ22525S025***	02-465578	02-465572
VMQ22525S032***	02-465577	02-465573
VMQ22525S040***	02-348974	02-348981
VMQ22525S045***	02-348975	02-348982
VMQ22525S050***	02-348976	02-348983
VMQ22525S063***	02-348977	02-348984
VMQ22525S071***	02-348978	02-348985
VMQ22525S080***	02-348979	02-348986
VMQ22525S090***	02-348980	02-348987

Viton® is a registered trademark of E.I. DuPont Co.

TABLE 2

MODEL CODE COVER END	* • CARTRIDGE KIT (BUNA-N)	* • CARTRIDGE KIT (VITON®)
VMQ22525S***010	02-465564	02-465563
VMQ22525S***016	02-465565	02-465562
VMQ22525S***020	02-465566	02-465561
VMQ22525S***025	02-465567	02-465560
VMQ22525S***032	02-465568	02-465559
VMQ22525S***040	02-465551	02-465558
VMQ22525S***045	02-465550	02-465557
VMQ22525S***050	02-465549	02-465555
VMQ22525S***063	02-465548	02-465556
VMQ22525S***071	02-465547	02-465553
VMQ22525S***080	02-465546	02-465554
VMQ22525S***090	02-465545	02-465552

TABLE 3

MODEL CODE	SHAFT	KEY
VMQ22525S-***-***-**-01	932950	928540
VMQ22525S-***-***-**-02	932936	—
VMQ22525S-***-***-**-03	932951	928545
VMQ22525S-***-***-**-04	932952	928563
VMQ22525S-***-***-**-05	932953	928541
VMQ22525S-***-***-**-06	932954	—
VMQ22525S-***-***-**-07	932955	928546
VMQ22525S-***-***-**-08	932956	928564
VMQ22525S-***-***-**-09	943997	—
VMQ22525S-***-***-**-10	944259	—

TABLE 4

OUTLET BODY				
Flange Mounting Style	Single Shaft Seal Inch Port Threads	Metric Port Threads	Double Shaft Seal Inch Port Threads	Metric Port Threads
SAE B	998600	998602	998601	998603
ISO 100	—	998604	—	998605

```
VMQ2  **  **  S  ***  ***  *  0  **  00  *  *  *  *  *  *  *  *  00  *  0  32
```

34 35

Design code

32 – 32 design
Installation dimensions
remain unchanged for
design numbers 30 to 39
inclusive.

* Verify shaft torque ratings meet or exceed input torque requirements

Products we offer:

- Cartridge valves
- DCV directional control valves
- Electric converters
- Electric machines
- Electric motors
- Gear motors
- Gear pumps
- Hydraulic integrated circuits (HICs)
- Hydrostatic motors
- Hydrostatic pumps
- Orbital motors
- PLUS+1® controllers
- PLUS+1® displays
- PLUS+1® joysticks and pedals
- PLUS+1® operator interfaces
- PLUS+1® sensors
- PLUS+1® software
- PLUS+1® software services, support and training
- Position controls and sensors
- PVG proportional valves
- Steering components and systems
- Telematics

Danfoss Power Solutions is a global manufacturer and supplier of high-quality hydraulic and electric components. We specialize in providing state-of-the-art technology and solutions that excel in the harsh operating conditions of the mobile off-highway market as well as the marine sector. Building on our extensive applications expertise, we work closely with you to ensure exceptional performance for a broad range of applications. We help you and other customers around the world speed up system development, reduce costs and bring vehicles and vessels to market faster.

Danfoss Power Solutions – your strongest partner in mobile hydraulics and mobile electrification.

Go to www.danfoss.com for further product information.

We offer you expert worldwide support for ensuring the best possible solutions for outstanding performance. And with an extensive network of Global Service Partners, we also provide you with comprehensive global service for all of our components.

Local address:

Hydro-Gear

www.hydro-gear.com

Daikin-Sauer-Danfoss

www.daikin-sauer-danfoss.com

**Danfoss
Power Solutions (US) Company**
2800 East 13th Street
Ames, IA 50010, USA
Phone: +1 515 239 6000

**Danfoss
Power Solutions GmbH & Co. OHG**
Krokamp 35
D-24539 Neumünster, Germany
Phone: +49 4321 871 0

**Danfoss
Power Solutions ApS**
Nordborgvej 81
DK-6430 Nordborg, Denmark
Phone: +45 7488 2222

**Danfoss
Power Solutions Trading
(Shanghai) Co., Ltd.**
Building #22, No. 1000 Jin Hai Rd
Jin Qiao, Pudong New District
Shanghai, China 201206
Phone: +86 21 2080 6201