

ENGINEERING
TOMORROW



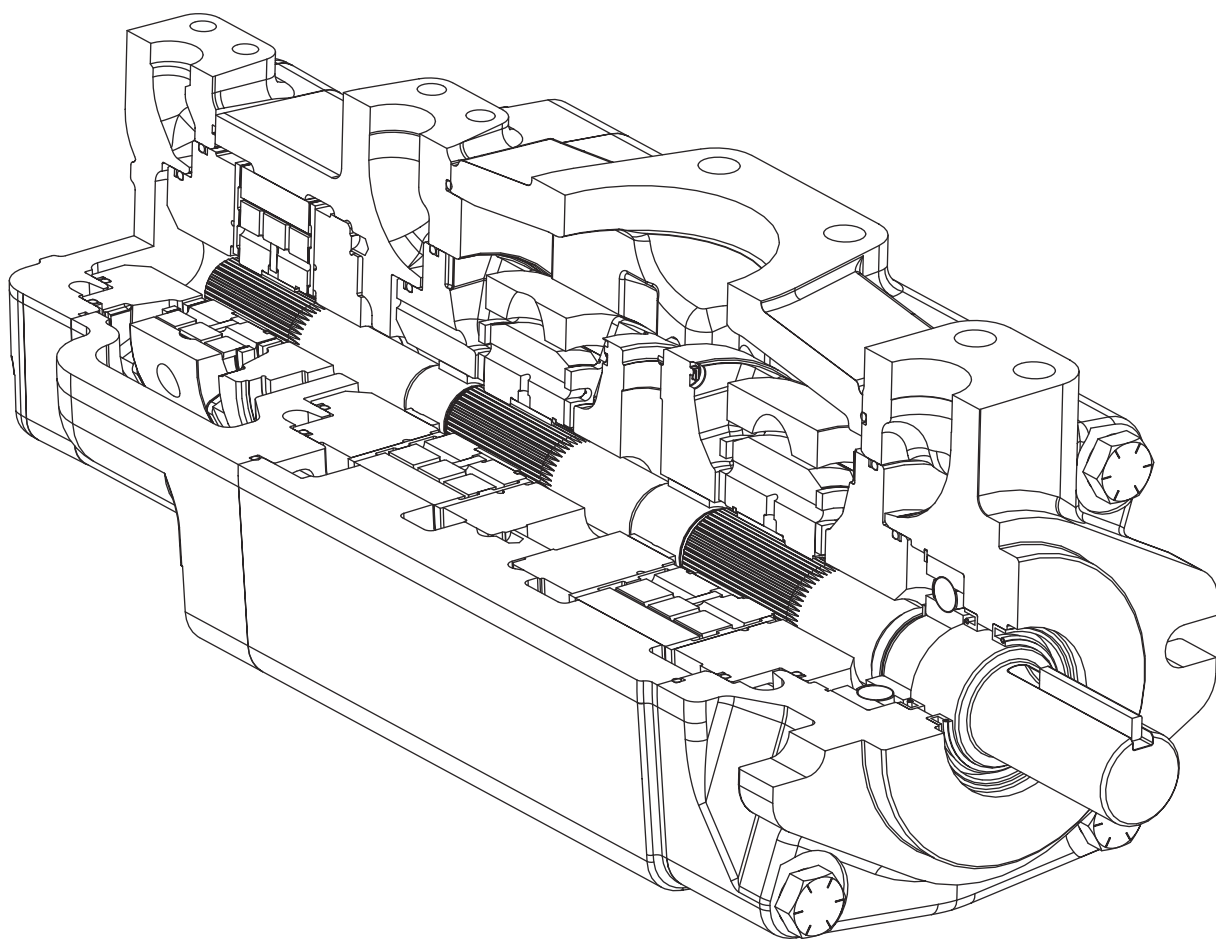
Vickers® by Danfoss

**High Pressure, High Performance
Triple Vane Pumps**

Parts and Service Manual

AX438767922867en-000101

VMQ3453525S Series
– 32 Design



VICKERS®

High Pressure, High Performance Triple Vane Pump VMQ3453525S Series — 32 Design

▲ △ 154115 Outlet Section O-ring Buna-N
262441 Outlet Section O-ring Viton

▲ △ 998927 SAE Outlet Section
998928 ISO Outlet Section

Cartridge Kit (See Table 3)

▲ △ • 998891 OD Back Up Ring

▲ △ • 587288 OD O-Ring Buna-N
587289 OD O-Ring Viton

▲ △ • 579373 Hub O-Ring Buna-N
579388 Hub O-Ring Viton

▲ △ 998888 Hub Back Up Ring

294660 Outlet Cover O-ring Buna-N
335660 Outlet Cover O-ring Viton

998839 SAE Outlet Cover
998840 ISO Outlet Cover

11163 Outlet Cover Screw
4 Req'd - Torque dry =
153 +/- 16 Nm
(113 +/- 11 ft*lb); Torque
oiled = 115 +/- 12 Nm
(85 +/- 9 ft*lb)

8876 Outlet Section Screw,
4 Req'd - Torque dry =
305 +/- 31 Nm
(225 +/- 23 ft*lb);
Torque oiled 229 +/- 23 Nm
(169 +/- 17 ft*lb)

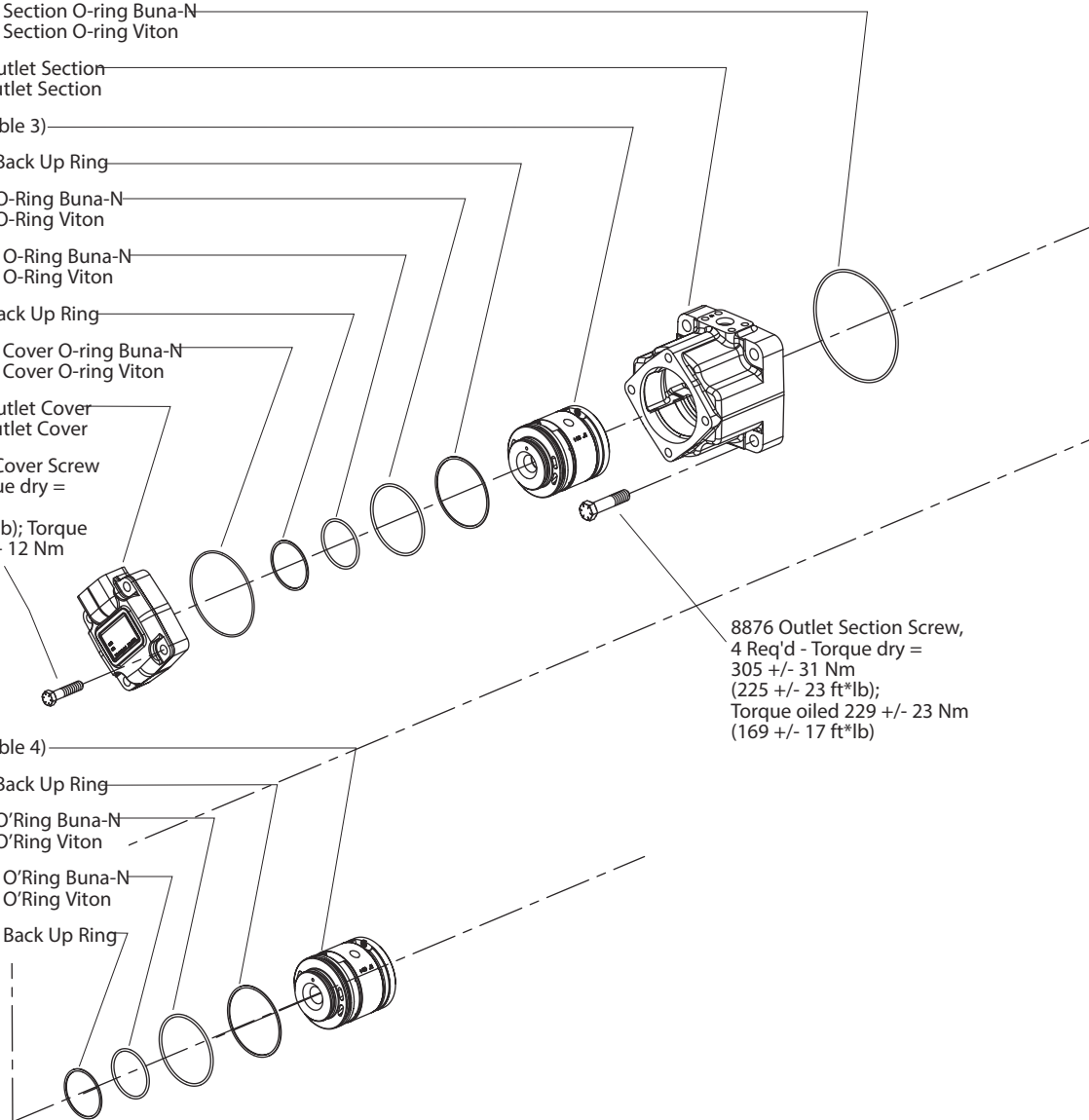
Cartridge Kit (See Table 4)

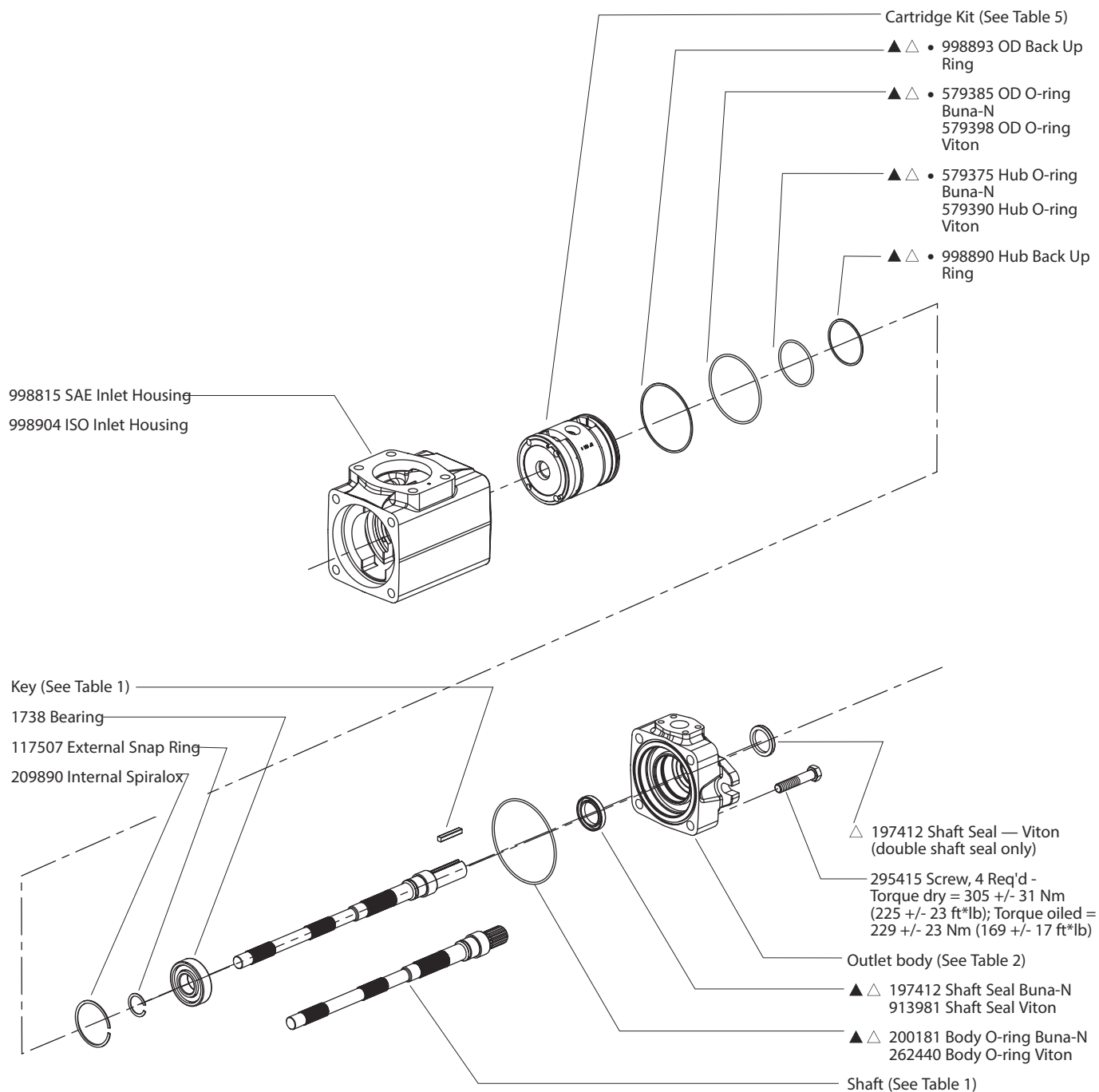
▲ △ • 998892 OD Back Up Ring

▲ △ • 579377 OD O'Ring Buna-N
579392 OD O'Ring Viton

▲ △ • 579374 Hub O'Ring Buna-N
579389 Hub O'Ring Viton

▲ △ • 998889 Hub Back Up Ring





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

- Included in Cartridge Kit (see table 3-5)
- ▲ Included in Single STD Seal Kit 02-346523 or Viton Seal Kit 02-346532.
- △ Included in Double STD Seal Kit 02-346531 or Viton Seal Kit 02-346533.
- * 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
Triple (R)	(R)	(L)	(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
Triple (L)	(L)	(R)	(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	30TH DESIGN SHAFT	31ST & 32ND DESIGN SHAFT	KEY
3453525VMQ-***-***-*--01	997092	4993377-001	928542
3453525VMQ-***-***-*--02	997080	4993376-001	—
3453525VMQ-***-***-*--03	997093	4993378-001	928547
3453525VMQ-***-***-*--05	997094	4993379-001	928543
3453525VMQ-***-***-*--06	997095	4993380-001	—
3453525VMQ-***-***-*--09	997096	4993381-001	—

TABLE 2

OUTLET BODY				
Flange Mounting Style	Single Shaft Seal		Double Shaft Seal	
	Inch Port Threads	Metric Port Threads	Inch Port Threads	Metric Port Threads
SAE B	998754	998748	998755	998749
ISO 100	—	998756	—	998757

TABLE 3

MODEL CODE COVER END	* • CARTRIDGE KIT (BUNA-N)	* • CARTRIDGE KIT (VITON [®])
VMQ3453525S***-***-010	02-465574	02-465569
VMQ3453525S***-***-016	02-465575	02-465570
VMQ3453525S***-***-020	02-465576	02-465571
VMQ3453525S***-***-025	02-465578	02-465572
VMQ3453525S***-***-032	02-465577	02-465573
VMQ3453525S***-***-040	02-348974	02-348981
VMQ3453525S***-***-045	02-348975	02-348982
VMQ3453525S***-***-050	02-348976	02-348983
VMQ3453525S***-***-063	02-348977	02-348984
VMQ3453525S***-***-071	02-348978	02-348985
VMQ3453525S***-***-080	02-348979	02-348986
VMQ3453525S***-***-090	02-348980	02-348987

TABLE 4

MODEL CODE CENTER SECTION	* • CARTRIDGE KIT (BUNA-N)	* • CARTRIDGE KIT (VITON [®])
VMQ3453525S***-090-***	02-465621	02-465622
VMQ3453525S***-100-***	02-465623	02-465624
VMQ3453525S***-112-***	02-465625	02-465626
VMQ3453525S***-125-***	02-465627	02-465628
VMQ3453525S***-135-***	02-465629	02-465630
VMQ3453525S***-140-***	02-465631	02-465632
VMQ3453525S***-158-***	02-465633	02-465634

TABLE 5

MODEL CODE SHAFT END	* • CARTRIDGE KIT (BUNA-N)	* • CARTRIDGE KIT (VITON [®])
VMQ3453525-140-***-***	02-346970	02-346971
VMQ3453525-160-***-***	02-346968	02-346969
VMQ3453525-180-***-***	02-346966	02-346967
VMQ3453525-195-***-***	02-346964	02-346965
VMQ3453525-215-***-***	02-346962	02-346963

VMQ3 ** ** 25 *** *** *** * ** * * * * * * 00 * 0 32

* 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