



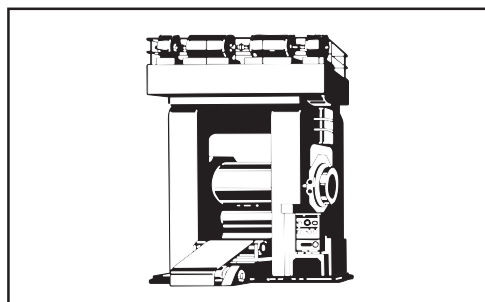
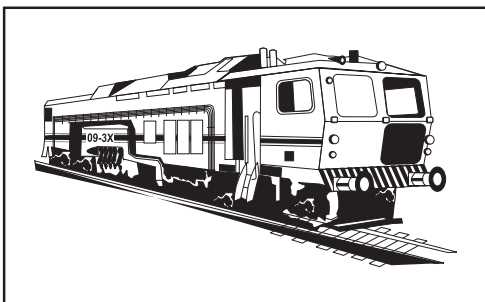
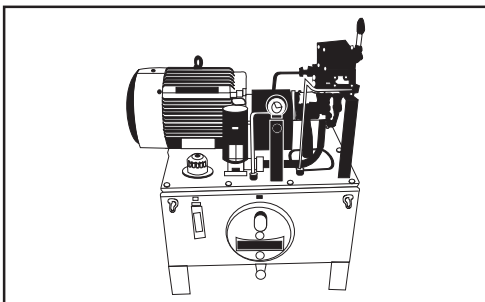
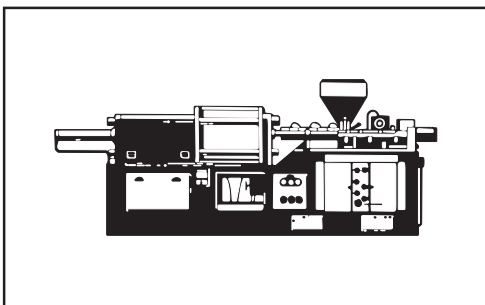
VELJAN

Service Information

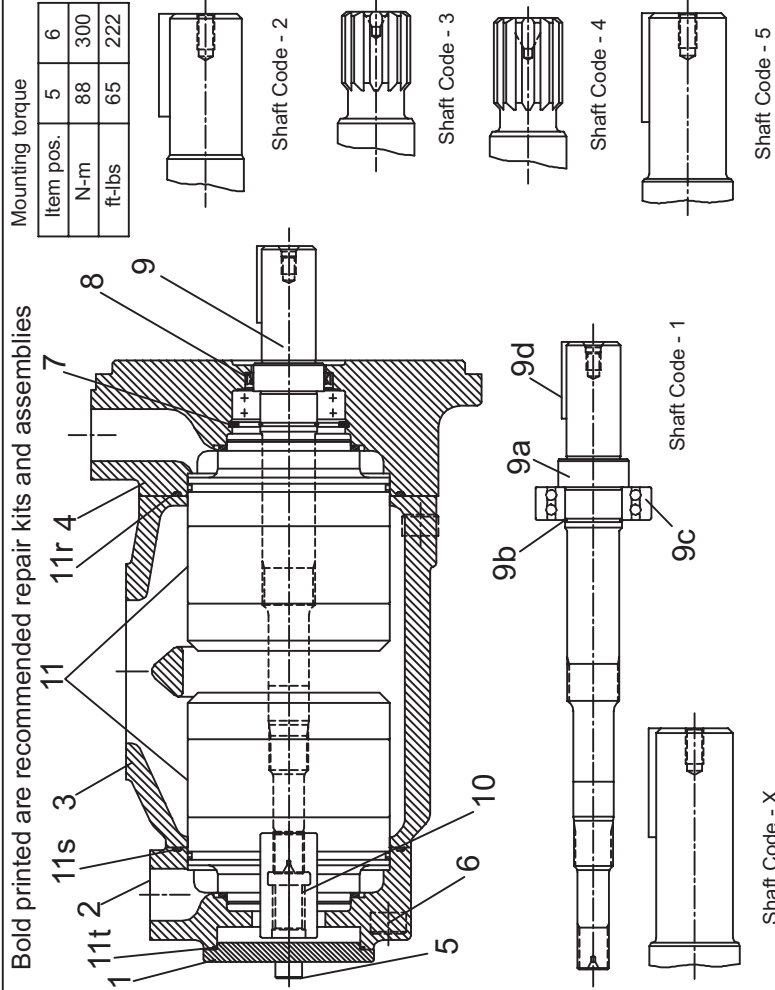
SS4 - 00128

VT6EE-VT6EES

Double vane pump

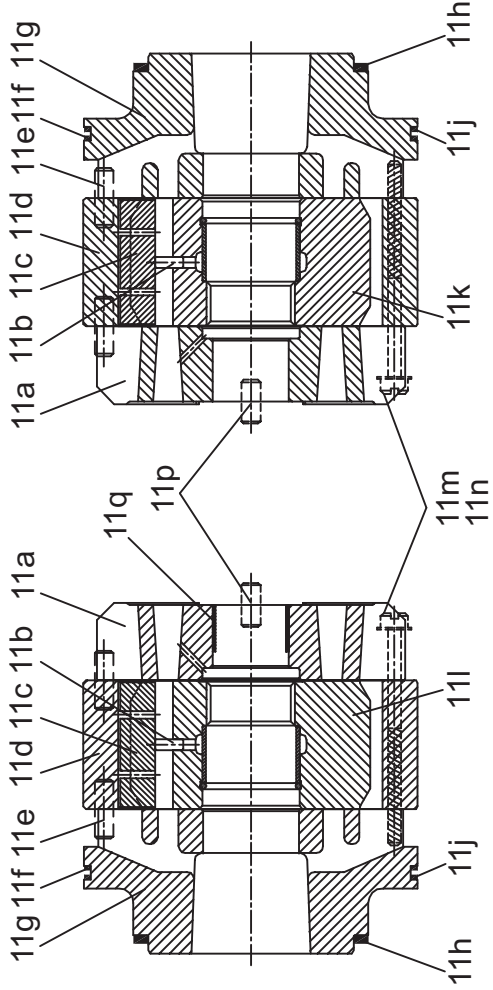


Bold printed are recommended repair kits and assemblies



P2
ITEM 11s, 11t INCLUDED

P1
ITEM 11r INCLUDED



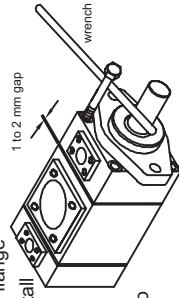
Item pos.	Description	Part No.	
			Qty
1	Cover plate	VT6EE-VT6EES	1
2	End cap (UNC) (VT6EES)	H-034-67313	1
3	End cap (Metric) (VT6EE - VT6EES)	H-034-67307	1
4	Housing (UNC) (VT6EES)	H-034-67306	1
5	Housing (Metric) (VT6EE - VT6EES)	H-034-67303	1
6	Mounting flange (UNC) (VT6EES)	H-034-66809	1
7	Mounting flange (Metric) (VT6EES)	H-034-67314	1
8	Mounting flange (Metric) (VT6EE)	H-034-66781	1
9	Mounting Screw	V361-12230-3	2
10	Mounting Screw	V361-14324-3	8
11	Retaining ring	V356-30315	1
12	Shaft seal (S1-0.7 bar)	V620-00018-3	1
13	Shaft seal (S4-S5-7 bar)	V620-00019-3	1
14	Shaft and bearing assy (Code-1)	VS24-69070	1
15	Shaft and bearing assy (Code-2) (VT6EE)	VS24-69071	1
16	Shaft and bearing assy (Code-3)	VS24-69072	1
17	Shaft and bearing assy (Code-4)	VS24-69761	1
18	Shaft and bearing assy (Code-5)	VS24-69762	1
19	Shaft and bearing assy (Code-X)	C-S14-72172	1
20a	Shaft keyed (Code-1)	H-034-67308	1
21	Shaft keyed (Code-2) (VT6EE)	H-034-67309	1
22	Shaft splined (Code-3)	H-034-67310	1
23	Shaft splined (Code-4)	H-034-67311	1
24	Shaft splined (Code-5)	H-034-67312	1
25	Shaft keyed (Code-X)	C-034-03252	1
26	Round section ring	V034-70866	1
27	Ball bearing	V230-90018-3	1
28	Key code-1	H-034-66981	1
29	Key code-2 (VT6EE)	H-034-66786	1
30	Key code-5	H-034-66978	1
31	Coupling (SAE-B)	H-034-66541	1
32	Coupling (SAE-BB)	H-034-66544	1
33	Cartridge assembly 042 C.W. (P1)	VS24-49390	1
34	Cartridge assembly 042 C.C.W. (P1)	VS24-49391	1
35	Cartridge assembly 045 C.W. (P1)	VS24-10205	1
36	Cartridge assembly 045 C.C.W. (P1)	VS24-10206	1
37	Cartridge assembly 050 C.W. (P1)	VS24-40769	1
38	Cartridge assembly 050 C.C.W. (P1)	VS24-40770	1
39	Cartridge assembly 052 C.W. (P1)	VS24-10207	1
40	Cartridge assembly 052 C.C.W. (P1)	VS24-10208	1
41	Cartridge assembly 057 C.W. (P1)	C-S14-72204	1

Item pos.	Description	Part No.	
		VT6EE-VT6EES	Qty
	Cartridge assembly 057 C.C.W. (P1)	C-S14-72205	
	Cartridge assembly 062 C.C.W. (P1)	VS24-10209	
	Cartridge assembly 062 C.C.W. (P1)	VS24-10210	
	Cartridge assembly 066 C.C.W. (P1)	VS24-10211	
	Cartridge assembly 066 C.C.W. (P1)	VS24-10212	
	Cartridge assembly 072 C.C.W. (P1)	VS24-40375	
	Cartridge assembly 072 C.C.W. (P1)	VS24-40376	
	Cartridge assembly 085 C.C.W. (P1)	VS24-59352	
	Cartridge assembly 085 C.C.W. (P1)	VS24-68983	
	Cartridge assembly 042 C.C.W. (P2)	VS24-69054	1
	Cartridge assembly 042 C.C.W. (P2)	VS24-69055	
	Cartridge assembly 045 C.C.W. (P2)	VS24-69056	
	Cartridge assembly 045 C.C.W. (P2)	VS24-69057	
	Cartridge assembly 050 C.C.W. (P2)	VS24-69058	
	Cartridge assembly 050 C.C.W. (P2)	VS24-69059	
	Cartridge assembly 052 C.C.W. (P2)	VS24-69060	
	Cartridge assembly 052 C.C.W. (P2)	VS24-69061	
	Cartridge assembly 057 C.C.W. (P2)	C-S14-72206	
	Cartridge assembly 057 C.C.W. (P2)	C-S14-72207	
	Cartridge assembly 062 C.C.W. (P2)	VS24-69062	
	Cartridge assembly 062 C.C.W. (P2)	VS24-69063	
	Cartridge assembly 066 C.C.W. (P2)	VS24-69064	
	Cartridge assembly 066 C.C.W. (P2)	VS24-69065	
	Cartridge assembly 072 C.C.W. (P2)	VS24-69066	
	Cartridge assembly 072 C.C.W. (P2)	VS24-69067	
	Cartridge assembly 085 C.C.W. (P2)	VS24-69068	
	Cartridge assembly 085 C.C.W. (P2)	VS24-69069	
11a	Port plate - rear C.W. (P1)	V034-59082	1
	Port plate - rear C.C.W. (P1)	V034-59083	
	Port plate - rear C.W. (P2)	V034-59083	
	Port plate - rear C.C.W. (P2)	V034-59082	
11b	Pin vane holdout	V034-59161	24
11c	Vane	V034-59162	24
11d	Cam ring - 042	V034-66899	2
	Cam ring - 045	V034-59164	
	Cam ring - 050	V034-66744	
	Cam ring - 052	V034-59165	
	Cam ring - 057	C-034-03202	
	Cam ring - 062	V034-59166	
	Cam ring - 066	V034-59167	
	Cam ring - 072	V034-66736	
11e	Cam ring - 085	V034-67030	4
	Dowel pin	V324-22016	

Item pos.	Description	Part No.	
		VT6EE-VT6EES	Qty
11f	Back-up ring	V618-15018	2
11g	Pressure port plate C.W. (P1)	V034-59159	1
	Pressure port plate C.C.W. (P1)	V034-59160	
	Pressure port plate C.W. (P2)	V034-59160	
	Pressure port plate C.C.W. (P2)	V034-59159	
11h	Sq.section seal	V691-10237	2
11j	Sq.section seal	V691-10253	2
11k	Rotor-insert assy	H-S24-10185	1
11l	Rotor-insert assy	H-S24-69822	1
11m	Screw	V310-10340	4
11n	Lockwasher internal tooth	V348-10010	4
11p	Dowel pin	V323-82014	2
11q	Bearing bush	V034-59901	1
11r,11s	Sq.section seal	V691-10259	2
11t	Sq.section seal	V691-10155	1
11f,11h	Seal kit (S1 - 0.7 bar)	VS24-69073	1
11j, 8	Seal kit (S4 - 7 bar)	VS24-69073-4	
11r,11s	Seal kit (S5 - 7 bar)	VS24-69073-5	
11t			
11a,11p	Port plate - rear assy C.W. (P1)	VS24-10214	1
	Port plate - rear assy C.C.W. (P1)	VS24-10215	
11a,11p	Port plate - rear and bush assy C.W. (P2)	VS24-69074	1
11q	Port plate - rear assy C.C.W. (P1)	VS24-69075	
1, 5	Cover plate assy	VS24-69763	1

To change porting position, follow the steps below:

- Secure pump and remove 4 bolts from mounting flange. Move the mounting flange 1 to 2 mm away from housing. Insert one bolt halfway to mounting flange. Install a wrench between the shaft and bolt and turn in the desired way, so that the required position of P1 port with respect to Suction is obtained. Reinstall the bolts and tighten to corresponding mounting torque as provided on page 2.
- Follow similar procedure for changing P2 position. Use wrench between two bolts placed diagonally opposite.



Instruction : Do not remove mounting flange/end cap completely from the housing 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 into the gap to avoid leakage. If it is difficult to turn mounting flange/end cap put some hydraulic oil in to the pressure port to lubricate the pressure port seals.

MODEL CODE

Series VT6EE/VT6EES - 066 - 045 - 1 R 00 - A 1 0 00 -

VT6EE Series - 250 B4HW
 ISO 3019-2 mounting flange
 VT6EES Series - SAE 4 bolts
 Mounting flange J744c

Modifications
 Mounting w/connection variables
 SAE 4 bolt flange (J518c)

UNC METRIC	
VT6EE	M0
VT6EES	00

Cam ring	Displacement in ³ /rev (cm ³ /rev)	Cam ring	Displacement in ³ /rev (cm ³ /rev)
042	= 8.07 (132.3)	062	= 12.00 (196.7)
045	= 8.69 (142.4)	066	= 13.02 (213.3)
050	= 9.67 (158.5)	072	= 13.86 (227.1)
052	= 10.06 (164.8)	085	= 16.46 (269.8)
057	= 11.02 (180.7)		

Coupling adaptor
 0 = None
 2 = SAE 'B'
 3 = SAE 'BB'

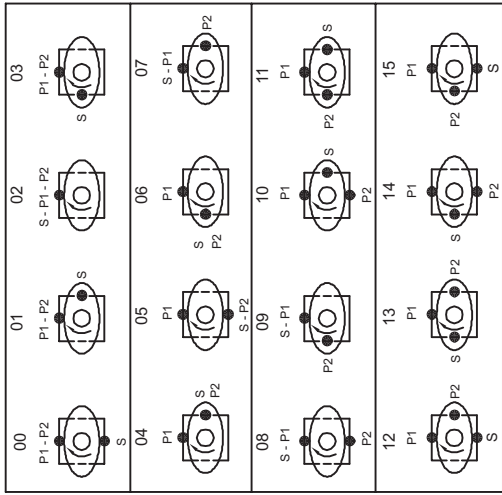
Seal class
 1 = S1 - BUNAN
 4 = S4 - EPDM
 5 = S5 - VITON

Design letter

Type of shaft _____ Type of shaft _____
 VT6EE VT6EES
 2 - keyed G45N (ISO 3019-2) 1 - keyed (SAE CC)
 3 - splined (SAE CC)
 4 - splined (SAE D&E)
 5 - keyed (SAE D&E)

Direction of rotation (view on shaft end)
 R - clockwise
 L - counter-clockwise

Porting combination



S - Suction port P - Pressure port

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