Vickers®
Hydraulic Vane Pump

Parts and Repair Information

Quiet Intra-Vane Double Pump
3525V*****-***-20(L)-28*
Hydraulic Vane Pump

Quiet Intra-Vane Double Pump

Note: Seals must be completely wetted at time of assembly with an SAE 10W motor oil of "SE" quality or an industrial hydraulic oil equivalent. Assemble seal with lip toward the bearing.

Capacity

<table>
<thead>
<tr>
<th>Cover</th>
<th>End</th>
<th>Pump</th>
<th>(USGPM)</th>
<th>● Ring</th>
<th>Cartridge Kit</th>
<th>(Includes Buna-N rings)</th>
<th>F3 Cartridge Kit</th>
<th>(Includes Viton rings)†</th>
</tr>
</thead>
<tbody>
<tr>
<td>3525V*12</td>
<td>584610</td>
<td>591091</td>
<td>591109</td>
<td></td>
<td></td>
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<td>3525V*14</td>
<td>584612</td>
<td>591092</td>
<td>591110</td>
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<td>3525V*17</td>
<td>584614</td>
<td>591093</td>
<td>591111</td>
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<td>3525V*21</td>
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<td>591094</td>
<td>591112</td>
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</tbody>
</table>

†Viton ring part numbers not shown

Note: Seals must be completely wetted at time of assembly with an SAE 10W motor oil of "SE" quality or an industrial hydraulic oil equivalent. Assemble seal with lip toward the bearing.
Individual cartridge parts are not interchangeable with similar parts of the previous design. Complete cartridges are interchangeable with the previous design.

CAUTION

<table>
<thead>
<tr>
<th>Type</th>
<th>Shaft</th>
<th>Key</th>
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</thead>
<tbody>
<tr>
<td>1</td>
<td>243448</td>
<td>88678</td>
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<tr>
<td>86</td>
<td>394036</td>
<td>393536</td>
</tr>
</tbody>
</table>

See Parts Drawing I-3963-S for Port Range data.
Hydraulic Vane Pump

Quiet Intra-Vane Double Pump

(F3) 3525V   *  *  *   *  *  *   20  (*)  28*

1  2  3  4  5  6  7  8  9  10  11

1 Seal Material
F3 - Viton®
Viton is a registered trademark of E.I. DuPont
Omitted - buna-N

2 Model Series
3525V - Vane Pump

3 Capacity - Shaft end pump
(Rating at 1200 RPM - 100 PSI)
(See inside for capacities.)

4 Port Connections
A - SAE 4-bolt flange
E - SAE Std. thread at #2 outlet port

5 Capacity - Cover end pump
(Rating at 1200 RPM - 100 PSI)
(see inside for capacities.)

6 Shaft Type
1 - Straight with square key (standard)
86 - Straight with square key
(heavy duty)

Outlet Port Positions
(Viewed From Cover End)

Outlet Cover

Outlet Body

Inlet Housing

In Line With Inlet

#1 Outlet Port

#2 Outlet Port

#1 Outlet Port Position

#2 Outlet Port Position

7 Design

8 Rotation
(Viewed from shaft end)
L - Left hand (CCW rotation)
Omitted - Right hand rotation

9 Mounting
282 - SAE 2-bolt mounting
283 - Foot mounting

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, 591091-L.

For satisfactory service life of these components in industrial applications, use full flow filtration to provide fluid which meets ISO cleanliness code 20/18/15 or cleaner. Selections from Vickers OFP, OFR, and OFRS series are recommended.