Vane Type Double Pump

3525VQ Series –20 Design
**NOTE**

Install 419673 sealing ring into body, then install cartridge kit.

<table>
<thead>
<tr>
<th>USgpm</th>
<th>Ring</th>
<th>STD. Cartridge Kit</th>
<th>F3 Cartridge Kit</th>
</tr>
</thead>
<tbody>
<tr>
<td>12</td>
<td>326984</td>
<td>421244</td>
<td>421576</td>
</tr>
<tr>
<td>14</td>
<td>326985</td>
<td>421235</td>
<td>421577</td>
</tr>
<tr>
<td>17</td>
<td>326986</td>
<td>421236</td>
<td>421578</td>
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<td>19</td>
<td>326987</td>
<td>421237</td>
<td>421579</td>
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<tr>
<td>21</td>
<td>326988</td>
<td>421238</td>
<td>421580</td>
</tr>
</tbody>
</table>

**NOTE**

When ordered individually, flex side plate kit includes (4) F3 seal pak subassemblies.
Included in flex side plate kit; bronze face of plate must be installed toward the rotor. Kit contains two flex side plates & four seal packs.

Install 419674 sealing ring into body, then install cartridge kit.

NOTE
Assemble seal flush with pilot face with spring loaded sealing member facing inward as shown. Seals to be completely wetted with oil prior to assembly.

NOTE
Assemble seal with spring loaded sealing member towards bearing. Seals to be completely wetted with oil prior to assembly.

Mounting bracket

Typical cutaway view
(F3) - 3×25 VQ ** A ** * * 1 ** 20 (**) - 28*

1 2 3 4 5 6 7 8 9 10 11 12

1 Viton seals
(Omit if not required.)

2 Series designation
3525VQ, Double Pump
3625VQ, Double Pump

3 Intra–vane pump

4 US GPM capacity
(Shaft end pump)
SAE rating 1200 rpm–100 psi (7 bar)
21 – 21 USgpm 35 – 35 USgpm
30 – 30 USgpm

5 SAE port connections

<table>
<thead>
<tr>
<th>Code</th>
<th>Inlet</th>
<th>Outlet #1</th>
<th>Outlet #2</th>
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</thead>
<tbody>
<tr>
<td>A</td>
<td>4 bolt</td>
<td>4 bolt</td>
<td>4 bolt</td>
</tr>
<tr>
<td></td>
<td>flange</td>
<td>flange</td>
<td>flange</td>
</tr>
<tr>
<td>E</td>
<td>4 bolt</td>
<td>4 bolt</td>
<td>SAE ST.</td>
</tr>
<tr>
<td></td>
<td>flange</td>
<td>flange</td>
<td>THD.</td>
</tr>
</tbody>
</table>

5 US GPM capacity
(Cover end pump)
SAE rating 1200 rpm–100 psi (7 bar)
12 – 12 USgpm 19 – 19 USgpm
14 – 14 USgpm 21 – 21 USgpm
17 – 17 USgpm

NOTE
Standard right hand shaft rotation cartridges shown. Reverse for left hand rotation; refer to note.

Cover end cartridge R. H. Rotation

Shaft end cartridge R. H. Rotation

NOTE
To reverse cartridge kit rotation, remove the two screws and reverse the location of the inlet support plate and the outlet support plate. Reinstall the two screws hand tight. Use pump cover to align all sections of the cartridge. Carefully remove the cover and tighten the screws.

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