Double Thru-drive Vane Pumps

3525VQT and 3625VQT Series (-20 Design)
NOTE: Parts prefixed with symbols are available only in kits.

- Included in standard seal kit. See table for standard and F3 kits.
- Included in cartridge kit. See table.
- Included in coupling kit. See table.
- Included in adapter kit. See table. “O” ring in adapter kit is 262413 (F3).
- Included in spacer kit (BP models only).
Model Code

(F3) - 3*25 VQT * S - ** A * ** (S) - 2 297 ** (*) - 20 *

1. **F3** – Viton seals
   Omit if not required.

2. **Series designation**
   3525VQT (standard bearing)
   3625VQT (heavy duty bearing)

3. **Thru-drive (rear) 2-bolt mounting flange**
   A – SAE “A” flange
   B – SAE “B” adapter flange
   BP – SAE “B” flange with spacer for Vickers PVE12, 19, or 21 pump

4. **Front mounting flange**
   S – SAE J-744 (127-2)

5. **Geometric displacement, front pump**
   Code = SAE rating (USgpm) at 1200 rpm and 6.9 bar (100 psi)
<table>
<thead>
<tr>
<th>Code</th>
<th>cm³/r</th>
<th>in³/r</th>
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<tbody>
<tr>
<td>12</td>
<td>40</td>
<td>2.45</td>
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<tr>
<td>14</td>
<td>45</td>
<td>2.77</td>
</tr>
<tr>
<td>17</td>
<td>55</td>
<td>3.37</td>
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<tr>
<td>21</td>
<td>68</td>
<td>4.12</td>
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</tbody>
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6. **Port connections**
   A – SAE 4-bolt flange
   AM – Metric 4-bolt flange (Flange pads stamped “M” for metric threads)

7. **Geometric displacement, rear pump**
   Code = SAE rating (USgpm) at 1200 rpm and 6.9 bar (100 psi)
<table>
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8. **Shaft seal assembly**
   S – Double seal
   Omit for single seal.

9. **Thru-drive coupling**
   2 – With spline for tandem pump

10. **Shaft**
    297 – Split “C” size per SAE J744C.
    32-4 per SAE J744 Oct 83

11. **Port position**
    (Viewed from rear end of pump)
    With no. 1 outlet opposite inlet
    AA – No. 2 outlet 135° CCW from inlet
    AB – No. 2 outlet 45° CCW from inlet
    AC – No. 2 outlet 45° CW from inlet
    AD – No. 2 outlet 135° CW from inlet
    With no. 1 outlet 90° CCW from inlet
    BA – No. 2 outlet 135° CCW from inlet
    BB – No. 2 outlet 45° CCW from inlet
    BC – No. 2 outlet 45° CW from inlet
    BD – No. 2 outlet 135° CW from inlet

12. **Thru-drive (rear) mounting flange position**
    (Viewed from rear end of pump)
    A – In line with no. 2 outlet port in all cases
    B – 90° from no. 2 outlet port in all cases
    Omit for 3*25VQTA models.

13. **Design**

14. **Rotation**
    (Viewed from front end of pump)
    L – Left hand (counterclockwise)
    R – Right hand (clockwise)

Standard right-hand shaft rotation cartridges are shown at right. To reverse rotation, remove two screws and reverse the location of the inlet and outlet support plates. Re-align all sections of the cartridge, then re-install and hand-tighten the two screws. Tighten screws to recommended torque.

When ordering spare cartridge parts, it is recommended they be obtained in kits. Kits are assembled and tested for either right or left hand rotation. If left hand rotation is required, specify on parts order by adding suffix “L” to cartridge kit number.

Sharp edge of vane must lead in direction of rotation.