Vane Type Single Pump

45VQ**A-86*-20(L)
NOTE

BRONZE FACES MUST BE INSTALLED TOWARD THE ROTOR.

WIPE O.D. OF SEAL WITH OIL BEFORE PRESSING INTO BODY. APPLY GREASE TO SEAL I.D. BEFORE INSTALLATION OF SHAFT.

61321 SCREW (4 REQ'D) (OIL & TORQUE TO 265 ± 10 LB. FT)

229633 COVER (INLET) TORQUE TO 105 ± 5 LB. IN

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**Assemble Seal With Spring Toward Bearing.**

**Assemble Seal Flush To Pilot Face With Spring Facing Inward As Shown.**

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**Diagram:**

- 131812 Bearing
- 102949 Snap Ring
- 158630 Snap Ring
- 588509 Back-IP Ring
- 154087 “O” Ring
- 419675 Ring Sealing (Assembly Note: Install in Body Before Installation of Cartridge Kit.)

---

**Table: Shafts**

<table>
<thead>
<tr>
<th>Single Seal Models</th>
<th>Double Seal Models</th>
<th>Key</th>
<th>Type</th>
</tr>
</thead>
<tbody>
<tr>
<td>Shaft No.</td>
<td>Part No.</td>
<td>Shaft No.</td>
<td>Part No.</td>
</tr>
<tr>
<td>1</td>
<td>233369</td>
<td>___</td>
<td>___</td>
</tr>
<tr>
<td>4</td>
<td>233370</td>
<td>___</td>
<td>___</td>
</tr>
<tr>
<td>11</td>
<td>242885</td>
<td>___</td>
<td>___</td>
</tr>
<tr>
<td>86</td>
<td>361760</td>
<td>___</td>
<td>___</td>
</tr>
</tbody>
</table>

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**Note:**

When ordered individually, Flex Side Plate Kit includes (4) F3 Seal Pack Sub Assy’s.

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**Diagram:**

- **Cover End L.H. Rotation**
- **Cover End R.H. Rotation**

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**Diagram:**

- 429282 Shaft Seal (Use On “S” Flange Mounted Models Only)
- 942356 Body S/A Kit (Outlet)
- 394974 Shaft Seal
- 194878 Washer
- Key (See Table)
- Screw (See Table)

---

**Diagram:**

- Mounting Assembly
  - 45VO***F-**-20(L)
  - Included in Mounting Kit FB-B-10
  - Screw (2 Req’d) 205533
  - Mounting Bracket 205077

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**Diagram:**

- 419675 Ring Sealing (Assembly Note: Install in Body Before Installation of Cartridge Kit.)
- 158087 O’Ring
- 588509 Back-IP Ring
- 102949 Snap Ring
- 154087 “O” Ring

---

**Diagram:**

- 429282 Shaft Seal (Use On “S” Flange Mounted Models Only)
- 942356 Body S/A Kit (Outlet)
- 394974 Shaft Seal
- 194878 Washer
- Key (See Table)
- Screw (See Table)
Model Code

1 Viton Seals  
(Omit if not required.)

2 Series

3 Vane Type

4 SAE Rated Capacity  
(Rating @ 1200 RPM - 100 psi)  
(See Inside for Capacities.)

5 Port Connections
A - SAE 4-Bolt Flange

6 Mounting & Shaft Seals Assembly
F - Foot (Single Shaft Seal Assy.)
S - Flange (Double Shaft Seal Assy.)
Omitted- Flange (Single Shaft Seal Assy.)

7 Shafts
See Tabulation, Exploded View.

8 Port Positions
See Chart Below

9 Design

10 Rotation  
(Viewed from Shaft End)  
L - Left Hand (CCW Rotation)  
Omitted - Right Hand Rotation

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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, 416439-L.

For satisfactory service life of these components, use full flow filtration to provide fluid which meets ISO cleanliness code 16/13 or cleaner. Selections from pressure, return, and in-line filter series are recommended.

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