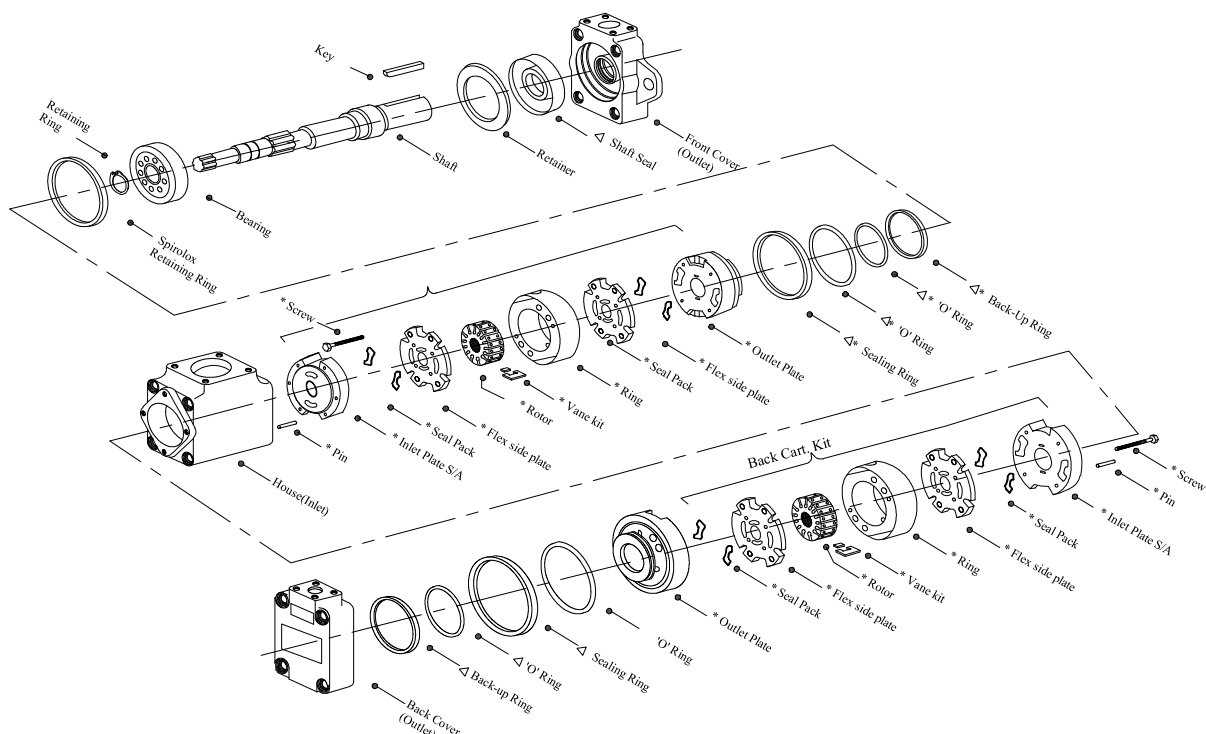
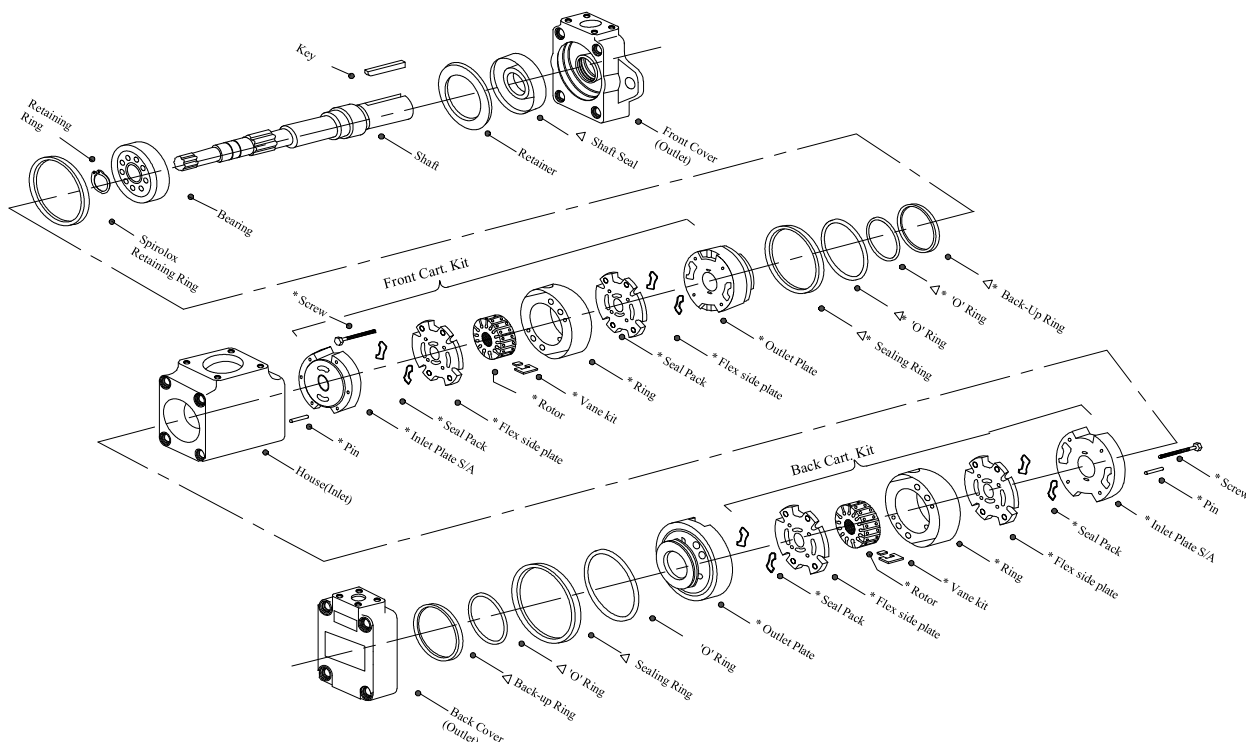


# IFP MOBILE DOUBLE VANE PUMP SERVICE PARTS INFORMATION



**2520VQ/3520VQ/4520VQ/3525VQ/4525VQ**



**4535VQ**

△ INCLUDE IN SEAL KIT  
\* INCLUDED IN CARTRIDGE KIT

# IFP MOBILE DOUBLE VANE PUMP SERVICE PARTS INFORMATION



## CARTRIDGE CHART

| PUMP SE | FRONT C. KIT | ROTOR   | VANE    | RING    | FLEX PLATE | BACK C. KIT | ROTOR   | VANE    | RING    | FLEX PLATE | SHAFTS      |
|---------|--------------|---------|---------|---------|------------|-------------|---------|---------|---------|------------|-------------|
| 2520VQ  | 12 416439N   | 270597N | 922710N | 326984N | 923956N    | 2 417052N   | 402690N | 922741N | 388683N | 923955N    | 1 254964N   |
|         | 14 416440N   |         |         | 326985N |            | 5 417053N   |         |         | 333624N |            | 11 254848N  |
|         | 17 416441N   |         |         | 326986N |            | 8 417054N   |         |         | 333625N |            | 25 293360N  |
|         | 19 421232N   |         |         | 326987N |            | 9 423096N   |         |         | 374799N |            |             |
|         | 21 416442N   |         |         | 326988N |            | 1 416427N   |         | 403539N | 922743N | 333626N    |             |
| 3520VQ  |              | 262154N | 922700N | 394961N | 923953N    | 12 416428N  |         |         | 353901N | 923955N    |             |
|         | 21 413420N   |         |         | 319396N |            | 14 416429N  |         |         | 353902N |            |             |
|         | 25 413421N   |         |         | 319397N |            | 2 417052N   |         | 402690N | 922741N |            | 1 258249N   |
|         | 30 413422N   |         |         | 319398N |            | 5 417053N   |         |         | 333624N |            | 11 258250N  |
|         | 35 413418N   |         |         | 319399N |            | 8 417054N   |         |         | 333625N |            | 86 394517N  |
| 3525VQ  | 38 413419N   |         |         |         |            | 9 423096N   |         |         | 374799N |            | 113 413022N |
|         |              | 262154N | 922700N | 394961N | 923953N    | 11 416427N  | 403539N | 922743N | 333626N | 923956N    | 14 413434N  |
|         |              |         |         | 319396N |            | 12 416428N  |         |         | 353901N |            |             |
|         |              |         |         | 319397N |            | 14 416429N  |         |         | 353902N |            |             |
|         |              |         |         | 319398N |            | 12 421244N  |         | 270597N | 922710N |            | 1 243448N   |
| 4520VQ  |              |         |         | 319399N |            | 14 421235N  |         |         | 326985N |            | 11 243449N  |
|         | 21 413420N   | 283871N | 922701N | 297510N | 923954N    | 17 421236N  |         |         | 326986N | 923956N    | 19 247019N  |
|         | 25 413421N   |         |         | 297511N |            | 21 421238N  |         |         | 326988N |            | 86 394036N  |
|         | 30 413422N   |         |         | 297512N |            |             |         |         |         |            | 111 413023N |
|         | 35 413418N   |         |         | 297513N |            |             |         |         |         |            |             |
| 4525VQ  | 38 413419N   |         |         | 297514N |            |             |         |         |         |            |             |
|         |              | 283871N | 922701N | 297515N | 923954N    |             | 402690N | 922741N | 388683N | 923955N    | 1 255533N   |
|         |              |         |         | 297516N |            |             |         |         | 333624N |            | 11 255536N  |
|         |              |         |         | 297517N |            |             |         |         | 333625N |            | 86 361761N  |
|         |              |         |         | 297518N |            |             |         |         | 374799N |            | 14 413436N  |
| 4535VQ  |              |         |         | 297519N |            |             |         |         | 333626N |            |             |
|         | 42 416435N   | 238871N | 922701N | 297520N | 923954N    |             | 270597N | 922710N | 326984N | 923956N    | 1 233524N   |
|         | 47 421234N   |         |         | 297521N |            |             |         |         | 326985N |            | 11 233527N  |
|         | 50 416436N   |         |         | 297522N |            |             |         |         | 326986N |            | 86 361762N  |
|         | 57 421233N   |         |         | 297523N |            |             |         |         | 326988N |            | 14 413024N  |
|         | 60 416437N   |         |         | 297524N |            |             |         |         |         |            |             |
| 4535VQ  |              | 238871N | 922701N | 297525N | 923954N    |             | 262154N | 922700N | 394961N | 923953N    | 1 289083N   |
|         | 42 416435N   |         |         | 297526N |            |             |         |         | 319396N |            | 11 289084N  |
|         | 47 421234N   |         |         | 297527N |            |             |         |         | 319397N |            | 86 361763N  |
|         | 50 416436N   |         |         | 297528N |            |             |         |         | 319398N |            | 114 413027N |
|         | 57 421233N   |         |         | 297529N |            |             |         |         | 319399N |            |             |
|         | 60 416437N   |         |         | 297530N |            |             |         |         |         |            |             |

- All Cartridge assemblies are factory tested before shipping -

| PUMP SE | BUNA SEAL KIT | VITON SEAL KIT | BUNA SHAFT SEAL | VITON SHAFT SEAL | SECONDARY SHAFT SEAL | BEARING | FRONT COVER | MIDDLE COVER | BACK COVER |
|---------|---------------|----------------|-----------------|------------------|----------------------|---------|-------------|--------------|------------|
| 2520VQ  | 920040N       | 920042N        | 394976N         | 429286N          | 429283N              | 001705N | 942353N     | 251263N      | 250824N    |
| 3520VQ  | 920048N       | 920050N        | 394973N         | 429284N          | 429281N              | 038441N | 942355N     | 250818N      | 250824N    |
| 3525VQ  | 920056N       | 920058N        | 394973N         | 429284N          | 429281N              | 038441N | 942355N     | 230189N      | 231532N    |
| 4520VQ  | 920060N       | 920062N        | 394974N         | 429285N          | 429282N              | 131812N | 942356N     | 252283N      | 250824N    |
| 4525VQ  | 920068N       | 920070N        | 394974N         | 429285N          | 429282N              | 131812N | 942356N     | 370071N      | 231532N    |
| 4535VQ  | 920072N       | 920074N        | 394974N         | 429285N          | 429282N              | 131812N | 942356N     | 379585N      | 270679N    |

## BOLT TORQUES

|                       | 2520VQ | 3520VQ | 3525VQ | 4520VQ | 4525VQ | 4535VQ |
|-----------------------|--------|--------|--------|--------|--------|--------|
| FRONT HOUSING FT. LB. | 75     | 150    | 150    | 275    | 275    | 275    |
| REAR COVER FT. LB.    | 50     | 50     | 75     | 50     | 75     | 75     |
| FRONT C. KIT IN. LB.  | 45     | 100    | 100    | 105    | 105    | 105    |
| BACK C. KIT IN. LB.   | 30     | 30     | 45     | 30     | 45     | 100    |

## Cartridge Kit Rotation

To change Cartridge Kit rotation, reverse the location of the inlet and the outlet support plates. Hand tighten the cartridge screws and use pump cover to align all the parts. Remove the cover and tighten the cartridge screws to the designated value. Sharp edge of vanes must lead in direction of rotation.

## Filtration

For satisfactory service life, use full flow filtration to provide fluid which meets ISO cleanliness code 16/13 or better.