

REPAIR PARTS

Variable Volume Silentvane Pump,
Flange Mounted, Combination Capability

Model SV-80,
1500 PSI 60 gpm
Model SV-100,
1000 PSI 75 gpm

Industrial Hydraulics

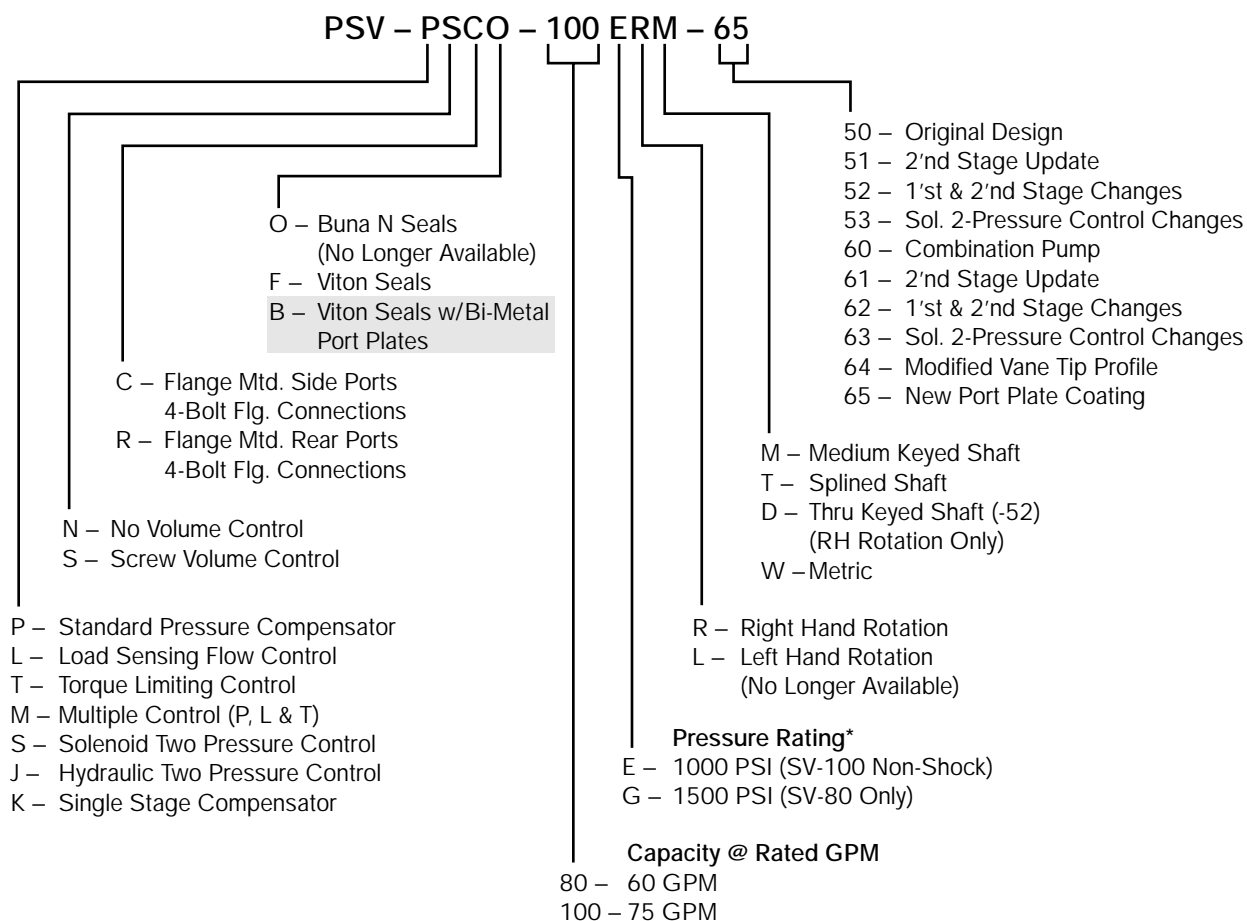
Rexroth
Bosch Group



When ordering parts, please include complete code number, parts required and shipping instruction. Contact factory for nearest authorized parts and service center.

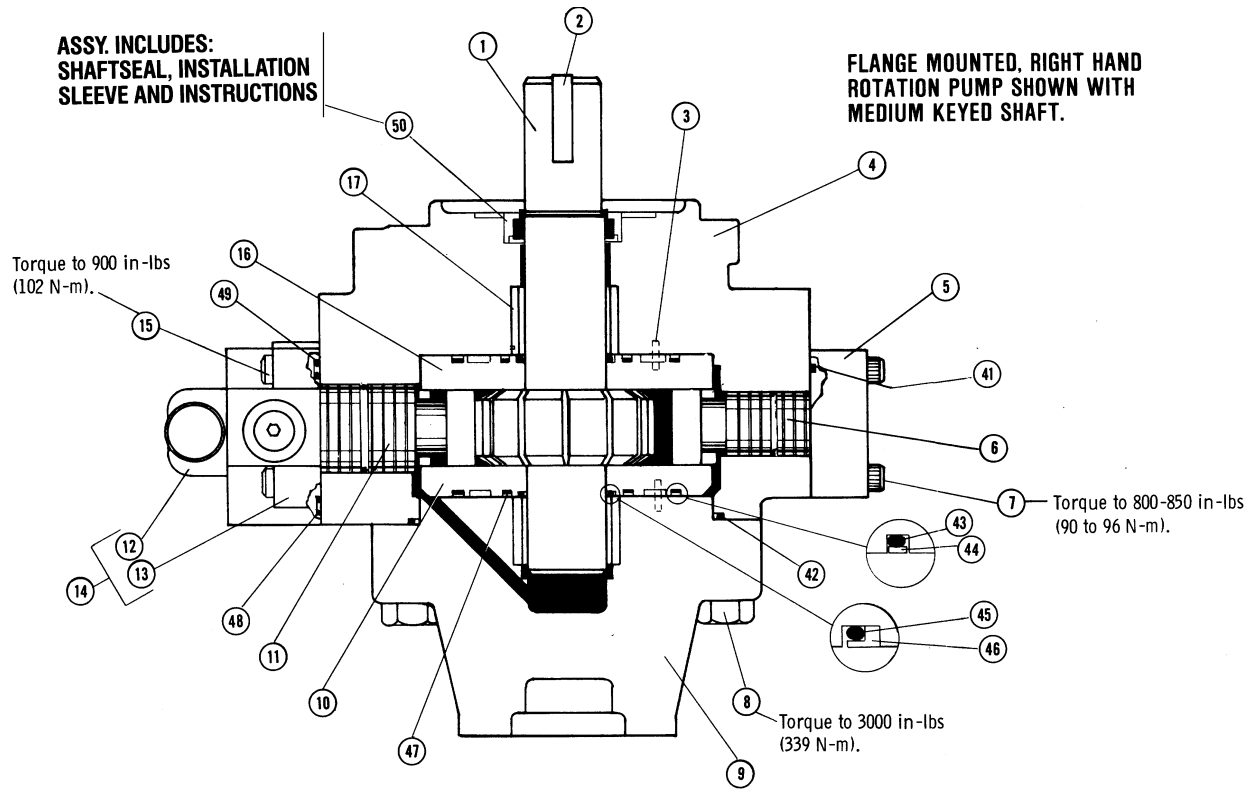
Pump Coding

– 50 Series is no longer available

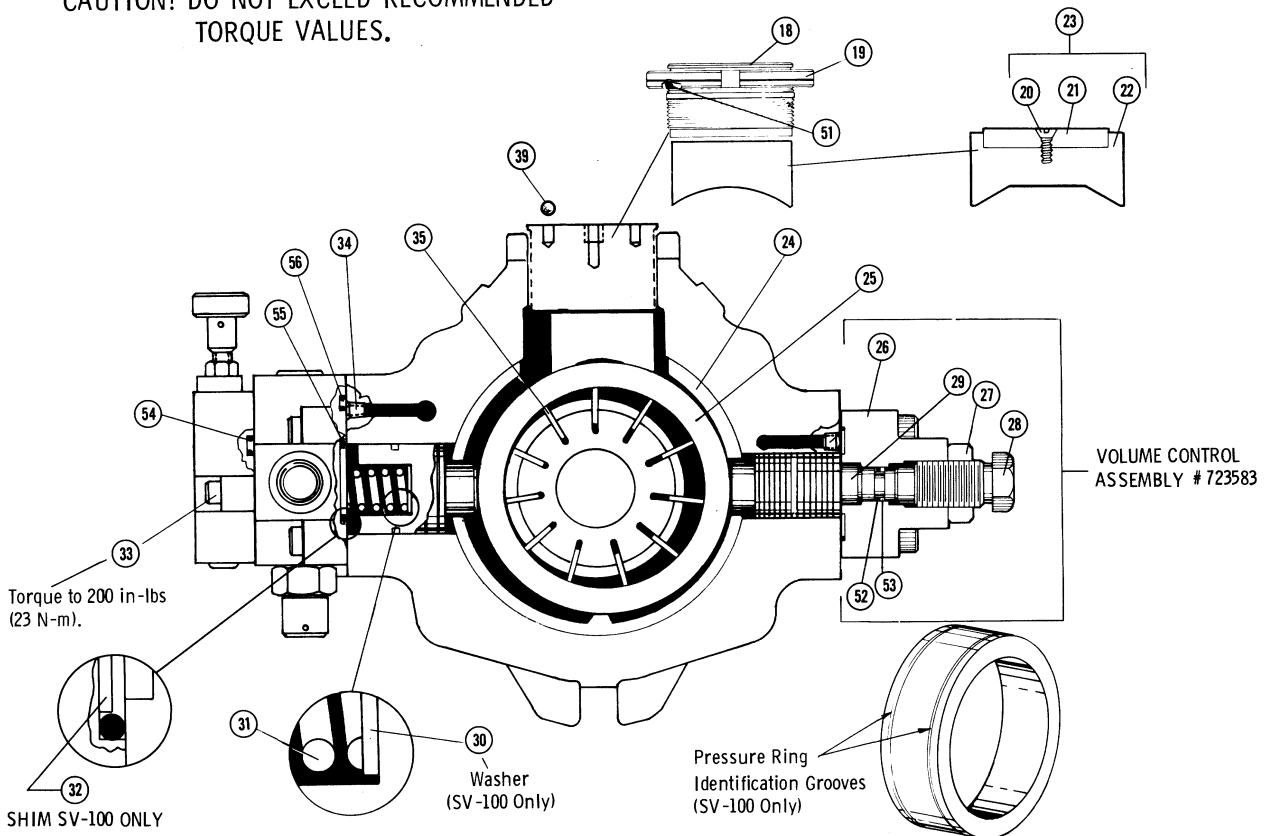


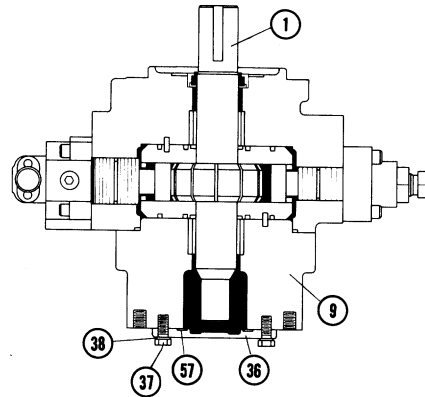
* These pumps are sound tunable to any circuit pressure after it has been set. Instructions are on the installation page shipped with each pump. For settings below 350 psi, consult the factory.

-65 Design



**CAUTION! DO NOT EXCEED RECOMMENDED
TORQUE VALUES.**





FLANGE MOUNTED
R. H. ROTATION SHOWN
WITH MEDIUM COMBINATION SHAFT.

Ref No.	Part No.	Description	Qty.
1	308417	Rotor Shaft, Keyed (For Rear Port Covers Only)	1
1	308530	Rotor Shaft, Splined	1
1	308567	Rotor Shaft, Thru (-52)	1
1	308988	Rotor Shaft, Combination (-65)	1
2	490965	Key	1/2
3	401717	Roll Pin	4
4	222804	Body, RH Rotation	1
5	222601	Bias Cover	1
6	308421	Bias Piston	1
7	408892	Screw, 7/16-14 x 2	4
8	405198	Screw, 3/4-10 x 3 1/4	4
9	222939	Cover, Rear Ported (-65)	1
9	222959	Cover, Combination (-65)	1
10	223228	Port Plate, RH Cover, LH Body	1
11	308422	Control Piston	1
12	956120	Second Stage Assembly (SV-100)	1
12	956121	Second Stage Assembly (SV-80)	1
13	-	First Stage Assembly	1
14	956113	2-Stage Compensator Assy. (SV-80) Complete	1
14	956114	2-Stage Compensator Assy. (SV-100) Complete	1
15	406309	Screw, 7/16-14 x 1 3/4	4
16	223230	Port Plate, RH Body, LH Cover	1
17	723135	Bearing Assembly	2
18	309041	Stationary Plug	1

Ref No.	Part No.	Description	Qty.
19	309044	Lock Ring	1
20	401215	Screw, 8-32 x 3/8	2
21	309042	Plastic Disc	1
22	778490	Thrust Block (-65)	1
23	778449	Thrust Block Assembly (-65)	1
24	308418	Spacer Ring	1
25	308419	Pressure Ring (SV-80)	1
25	308803	Pressure Ring (SV-100)	1
26	222600	Body, Volume Control	1
27	401019	Hex Nut	1
28	308412	Adjusting Screw	1
29	308414	Piston	1
30	408757	Washer (SV-100 Only)	1
31	490977	Spring	1
32	308998	Shim (SV-100 Only)	1
33	400779	Screw, 1/4-20 x 1 1/4	3
34	400925	Plug 1/16 NPTF	2
35	778279	Vane Set (11 pcs of 308429)	1
36	222975	End Cover	1
37	400721	Screw, 3/8-16 x 7/8	2
38	407799	Washer	2
-	491854	Nameplate (Not Shown) SV Standard	1
-	491865	Rivet (Not Shown)	2
39	492143	Acetal Ball	2

Seal Kits

Viton Seal Kits:
Single End Shaft & Combination 723733
Double End Shaft 794119

Ref No.	Part No.	Description	Qty.
41	406130	O-ring, -141 Viton 75	1
42	491031	O-ring, -261 Viton 75	1
43	491032	O-ring, -250 Viton 75	2
44	490983	Back-Up Ring	2
45	407109	O-ring, -137 Viton 75	2
46	490979	Back-Up Ring	2
47	409146	O-ring, -147 Viton 75	2
48	406565	O-ring, -013 Viton 75	1
49	406265	O-ring, -008 Viton 75	1
50	457926	Shaft Seal	1/2
51	406978	O-ring, -233 Viton 75	1
52	406518	O-ring, -113 Viton 75	2
53	491354	Back-Up Ring	1
54	406797	O-ring, -011 Viton 75	3
55	406800	O-ring, -139 Viton 75	1
56	406636	O-ring, -110 Viton 75	1
57	482568	Gasket	1

Note: Double ended seal kits consist of one standard kit & one shaft seal.

Repair Kits

Description	SV-80	SV-100
*Medium Length Keyed Shaft - Viton	794101	794105
Spline Shaft - Viton	794103	-
Thru Shaft - Viton (-52)	794126	794127
Combo Shaft - Viton (-65)	794405	794407
Combo Shaft - Viton - Bi-Metal Plates	794482	794483

* Used with -52 and all rear ported pumps.

Note: Each kit contains two bearings, one rotor, one set of vanes, one pressure ring, four roll pins, one or two keys, one seal kit and two port plates.

**Port Changes
-50 vs -60 Designs**

Pump Model (Pump Type)	-50 Design		-60 Design	
	Inlet	Outlet	Inlet	Outlet
SV-80/SV-100 (4-Bolt Flange)	2 1/2"	1 1/2"	2 1/2"	1 1/2"

The distance on -60 pumps from the pump mounting flange to the center of the port, decreased by 1/8" vs the -50 Series. A spacer (#492548) can be used to make up the lost distance.

Conversion Information

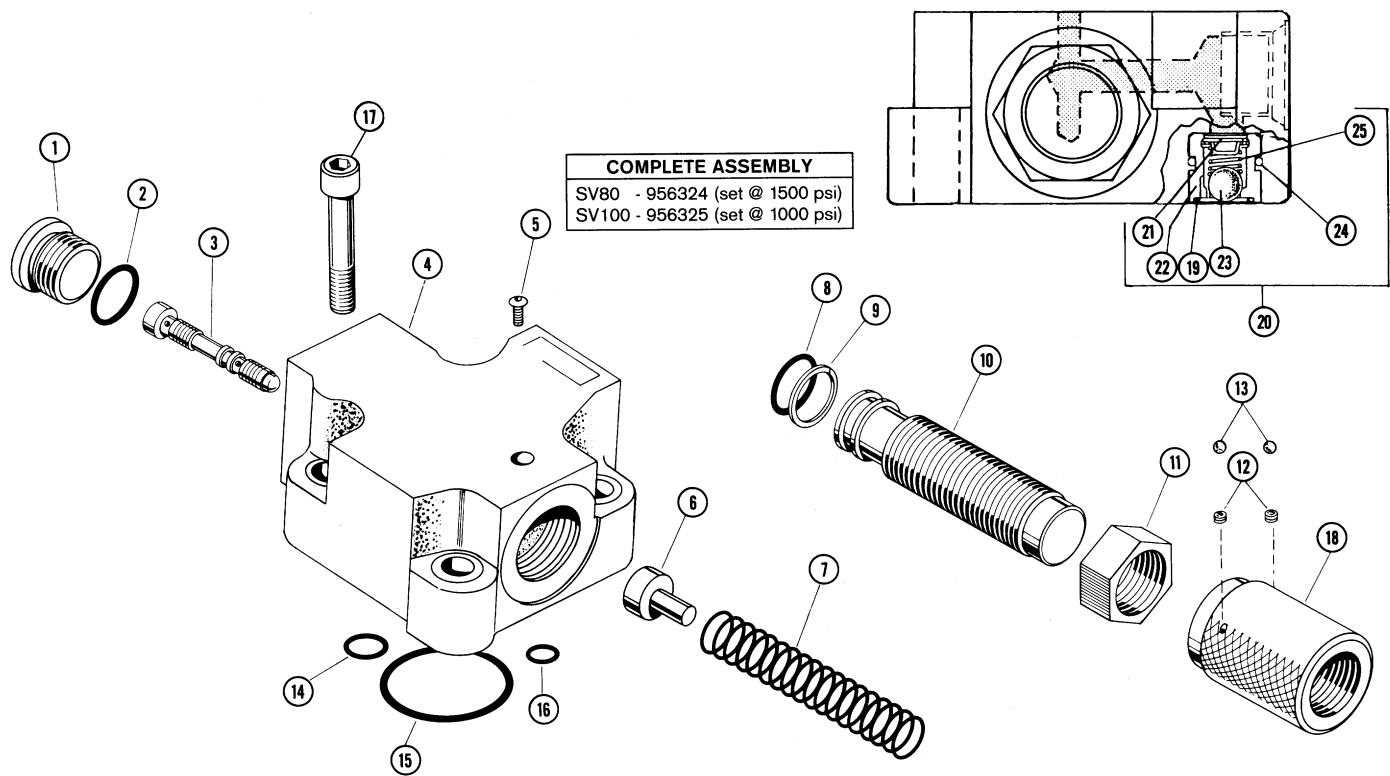
	SV-80		SV-100	
	Remove	308419 None	Replace With	308803 408757 308998
Pressure Ring				
Shim (Control Piston)				
Shim (Between Compensator & Pump Body)				

*When using a torque limiter control or an old style compensator (powdered metal with tear drop counterbore), use shim 492352.

When making conversions, always remember to change the name tag coding.

Recalibrate pump according to specific pump size.

Single Stage



Ref No.	Part No.	Description	Qty.
1	491832	#8 SAE Hollow Plug	1
*2	407139	O-ring, -908 Viton	1
3	309298	Spool	1
4	223111	Body (SAE)	1
5	457603	Screw #8-32 UNC x .25	1
6	309299	Spring Seat	1
7	457642	Spring (Inner)	1
7	457602	Spring (Outer)	1
8	406707	O-ring (-020) 7/8 x 1 x 1/16	1
9	457626	Back-Up Ring	1
10	309300	Adjusting Barrel	1
11	309301	Lock Nut	1
12	457688	Set Screw 1/4-20 x 1/8	2
13	457689	Acetal Ball ø9/64	2

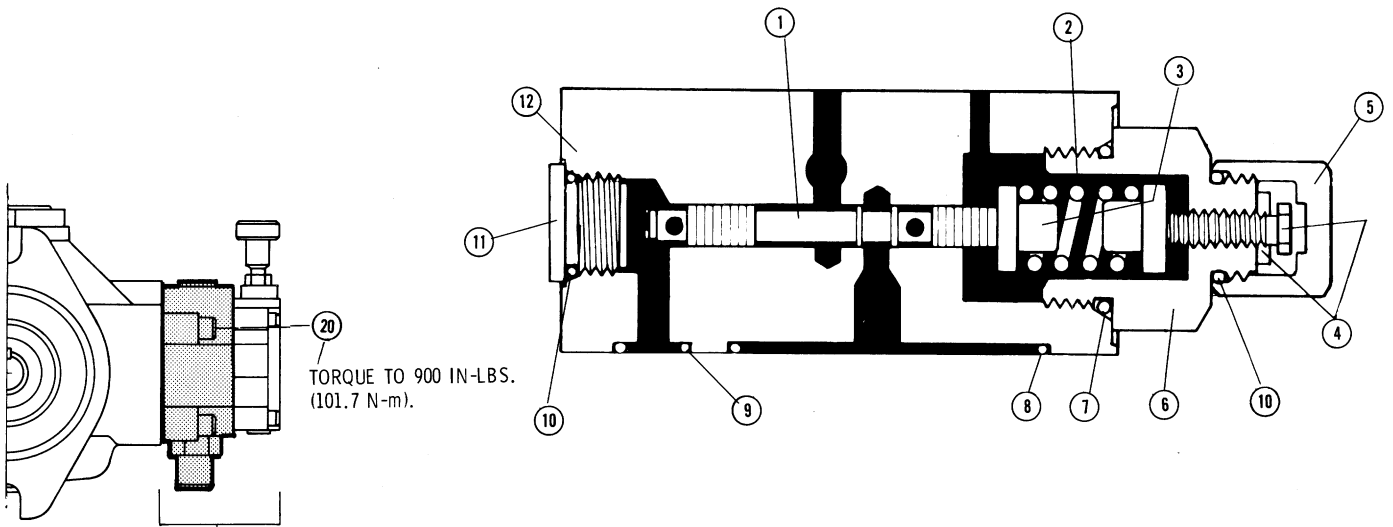
Ref No.	Part No.	Description	Qty.
*14	406636	O-ring (-110) 3/8 x 9/16 x 3/32	1
*15	406800	O-ring (-139) 2 3/16 x 2 3/8 x 3/32	1
*16	406265	O-ring (-008) 3/16 x 5/16 x 1/16	1
17	406309	Screw (Not included in complete assembly) 7/16-14 x 1 3/4	4
18	309302	Stop Nut & Knob	1
*19	406215	O-ring (-014) 1/2 x 5/8 x 1/16	1
20	778413	Body, Drain Check Assembly	1
-	723673	Installation Seal Kit (Included Ref. #14, 15, 16 & 19)	1
21	492394	Spring Retainer	1
22	309027	Body, Drain Check	1
23	490405	Steel Ball	1
24	406581	O-ring 3/32 x 9/16 x 3/4	1
25	492395	Spring	1

*Included in Seal Kit #723733 (Viton)

Standard Two-Stage Compensator – First Stage

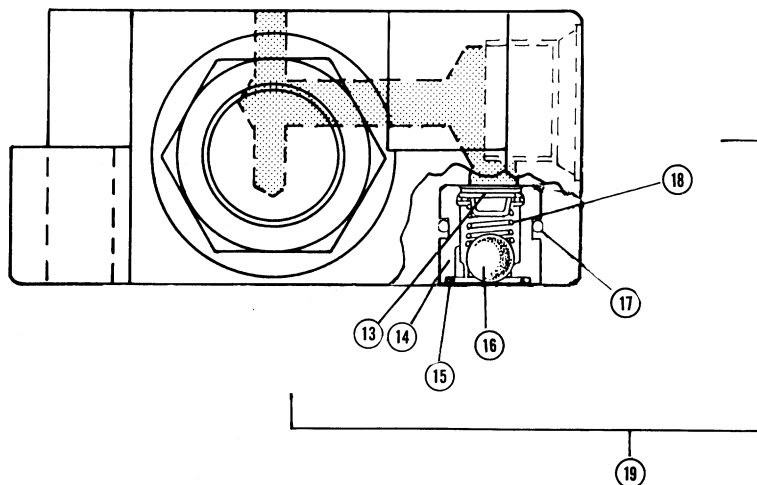
Ref No.	Part No.	Description	Qty.
1	308747	Spool	1
2	491833	Spring	1
3	308744	Spring Set	2
4	778459	Lock Nut – Adjusting Screw	1
5	308936	Safety Cap	1
6	309053	Adapter, Adjusting Screw	1
*7	407102	O-ring, #14 SAE (-914)	1
*8	406800	O-ring, $\frac{3}{32} \times 2\frac{3}{16} \times 2\frac{3}{8}$	1
*9	406636	O-ring, $\frac{3}{32} \times \frac{5}{16} \times \frac{7}{16}$	1
*10	407139	O-ring, #8 SAE (-908)	2
11	491832	Plug, #8 SAE	1
12	223053	Body, 1st Stage	1
13	492394	Spring Retainer	1
14	309027	Body, Drain Check	1
*15	406215	O-ring, $\frac{1}{16} \times \frac{1}{8} \times \frac{5}{8}$	1
16	490405	Steel Ball	1
*17	406518	O-ring, $\frac{3}{32} \times \frac{9}{16} \times \frac{3}{4}$	1
18	492395	Spring	1
19	778413	Drain Check Assembly	1
20	406309	Spring, $\frac{7}{16}-14 \times 1\frac{3}{4}$	4

* Included in Seal Kit #723733 (Viton).

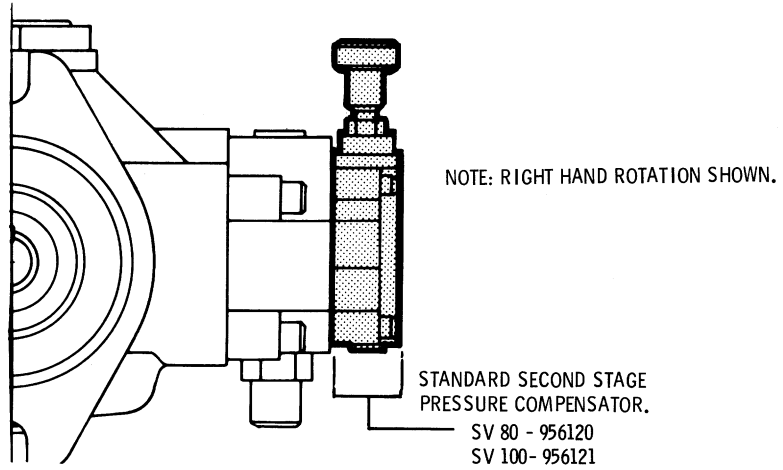


COMPLETE TWO-STAGE
PRESSURE COMPENSATOR
(1st & 2nd STAGES)
SV- 80 956113
SV- 100 956114

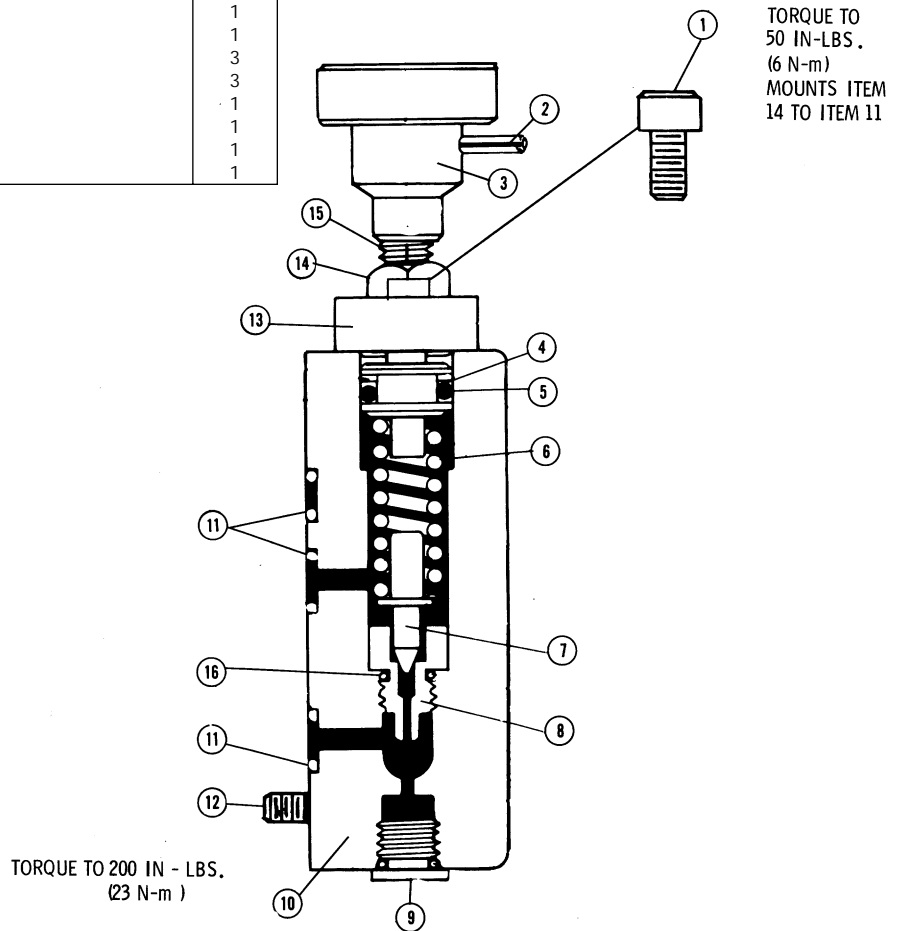
NOTE: THE FIRST STAGE CANNOT BE PURCHASED BY ITSELF. YOU HAVE TO PURCHASE THE COMPLETE COMPENSATOR TO GET THE FIRST STAGE.



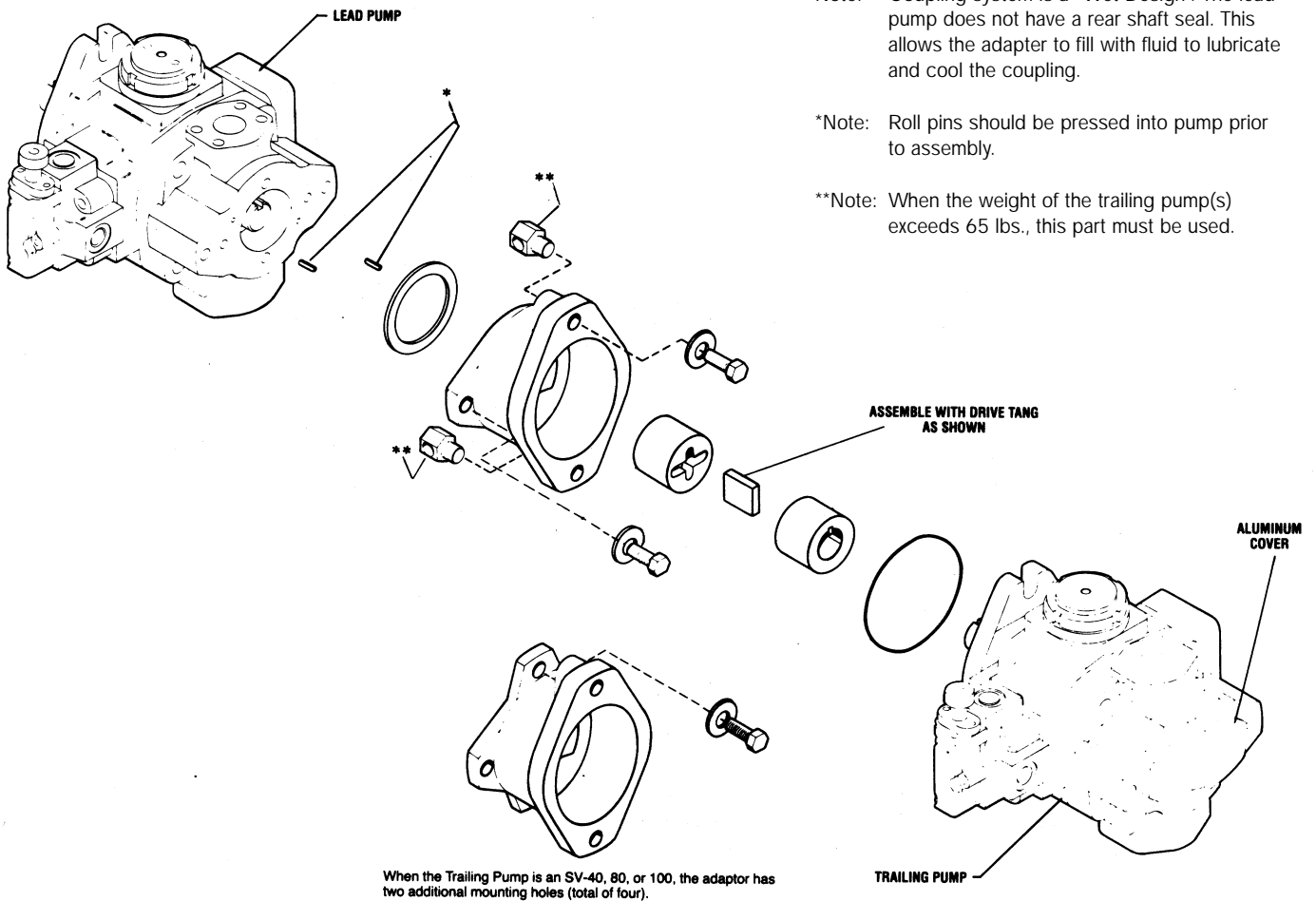
Standard Two-Stage Compensator – Second Stage



Ref No.	Part No.	Description	Qty.
1	402396	Screw, #10-24 x 1/2	2
2	401714	Roll Pin	1
3	308730	Knob	1
*4	490418	Back-Up Ring	1
*5	406579	O-ring, 3/32 x 7/16 x 5/8	1
6	407846	Spring (-51/52 & -61/62)	1
7	309057	Poppet (-52/62 Only)	1
8	309058	Seat (-52/62 Only)	1
*9	406618	Plug, #4 SAE with O-ring	1
10	222962	Body (-51/52 & -61/62)	1
*11	406797	O-ring, 1/16 x 5/16 x 7/16	3
12	400779	Screw, 1/4-24 x 1 1/4	3
13	221777	Retaining Cap	1
14	401044	Lock Nut	1
15	309028	Adjusting Screw	1
*16	407123	O-ring, #3 SAE (-903)	1



Adapter/Coupling System

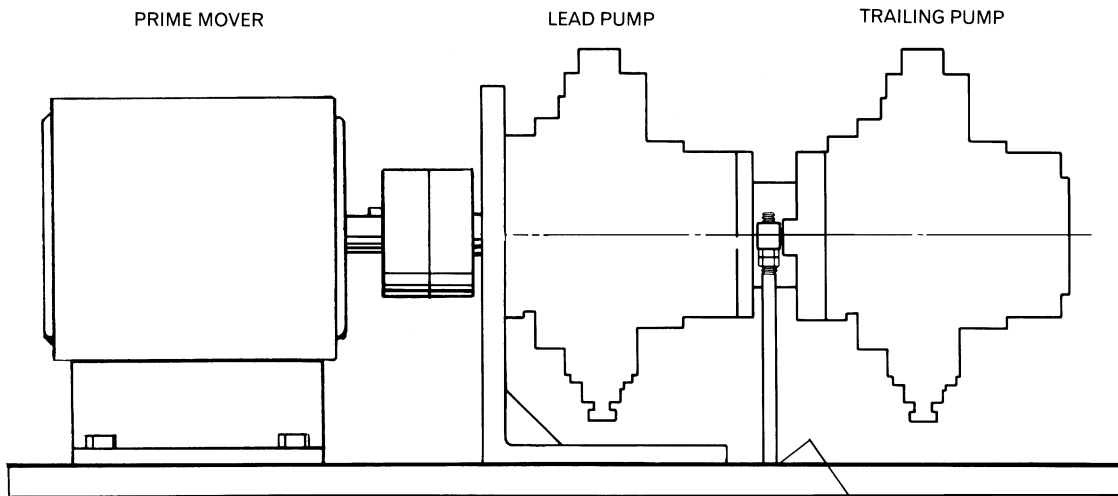


Adaptor Kits		
Lead Pump	Trailing Pump	Kit #
SV-80/100	SV-10/15 & PSQ	956109
SV-80/100	SV-20/25	956110
SV-80/100	SV-40	956106
SV-80/100	SV-80/100	956105
SV-80/100	EO55	956183
SV-80/100	20L, 20H	956184
SV-80/100	80L, 80M, 80H	956185

**VOID PRODUCT
NOT ALL
PARTS AVAILABLE**

Support Rods

Bosch Rexroth includes support guides in each tandem mounting kit. Because of the varying height differences for each application, it is the customers responsibility to provide the actual support rods and lock nuts. Listed below are the support guide diameters and some mounting requirements.



The support rod must be attached to the same mounting surface as the pump & motor. Alignment must be within .003" total indicator variance.

Support Rod Guide SV-80/100

IMPORTANT NOTES

1. Support rods are required when a trailing pump or pumps exceed 65 lbs. in weight.
2. The support rod must be mounted with the bottom of the rod attached to the same mounting surface as the electric motor and pump flange bracket (see above picture).

