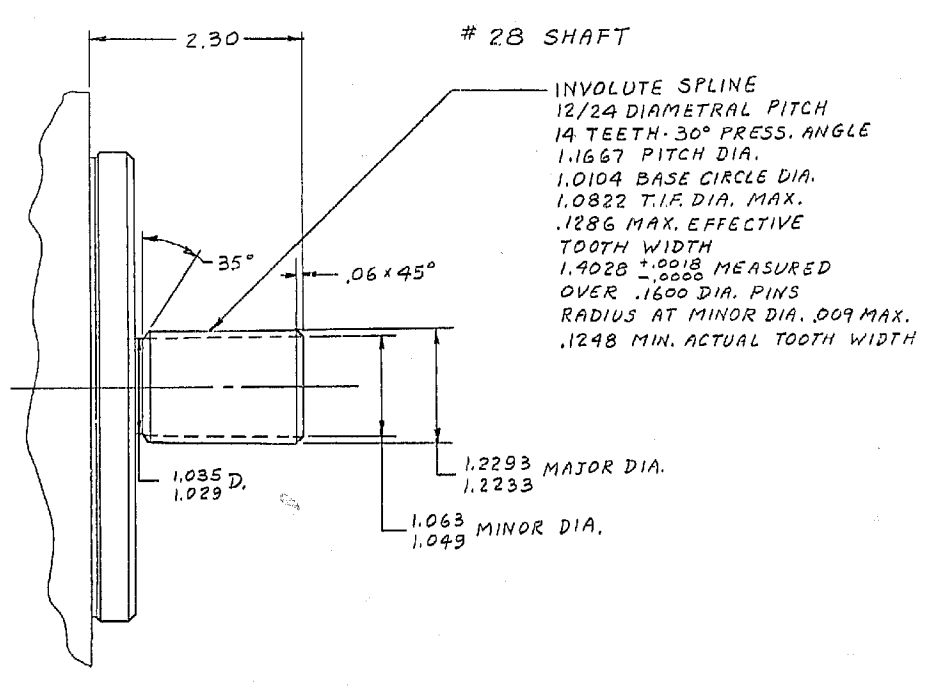
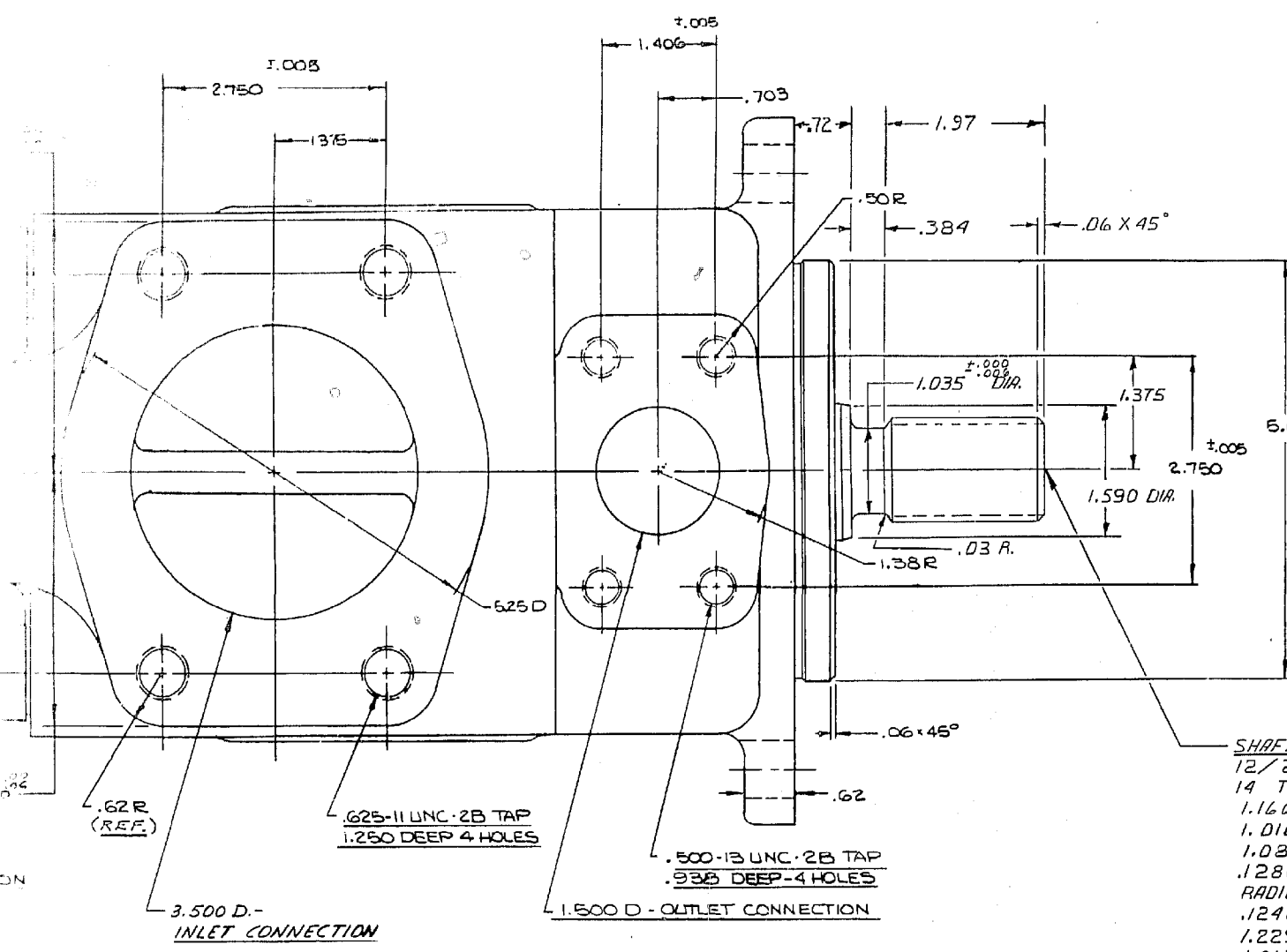
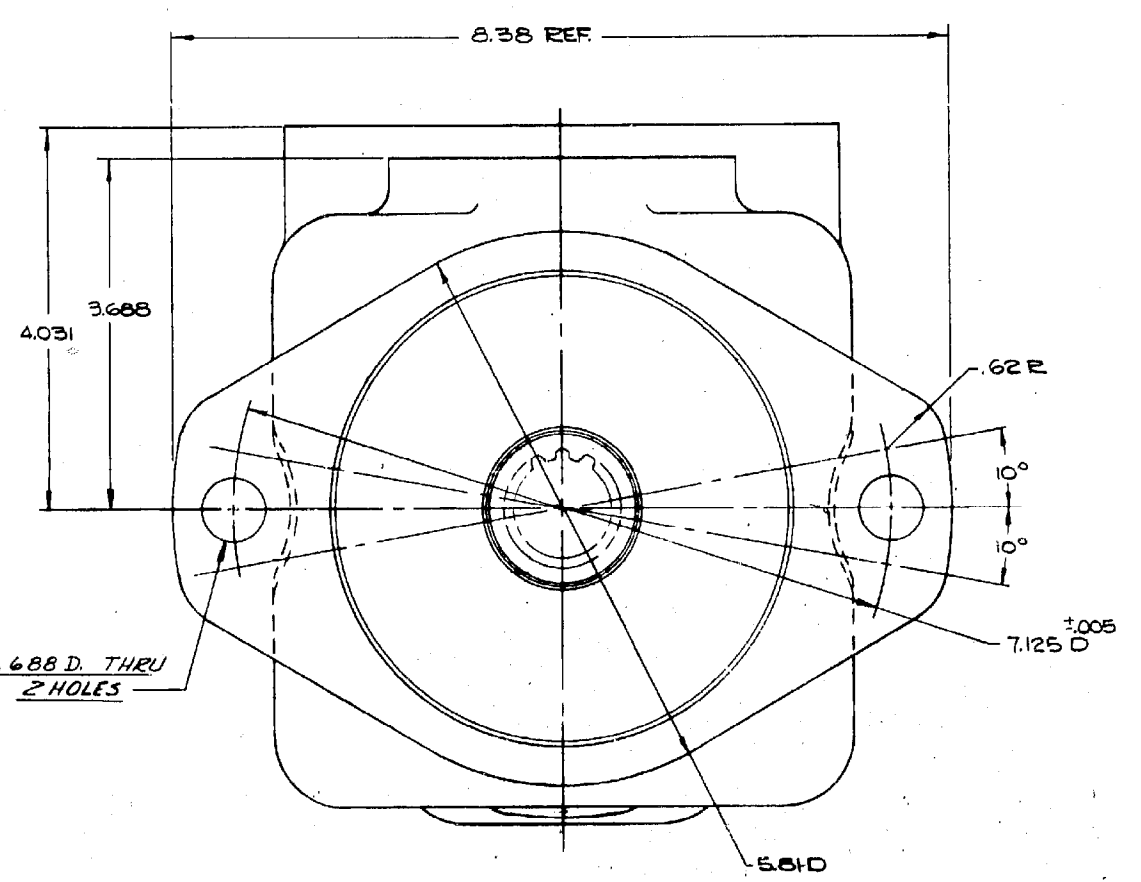
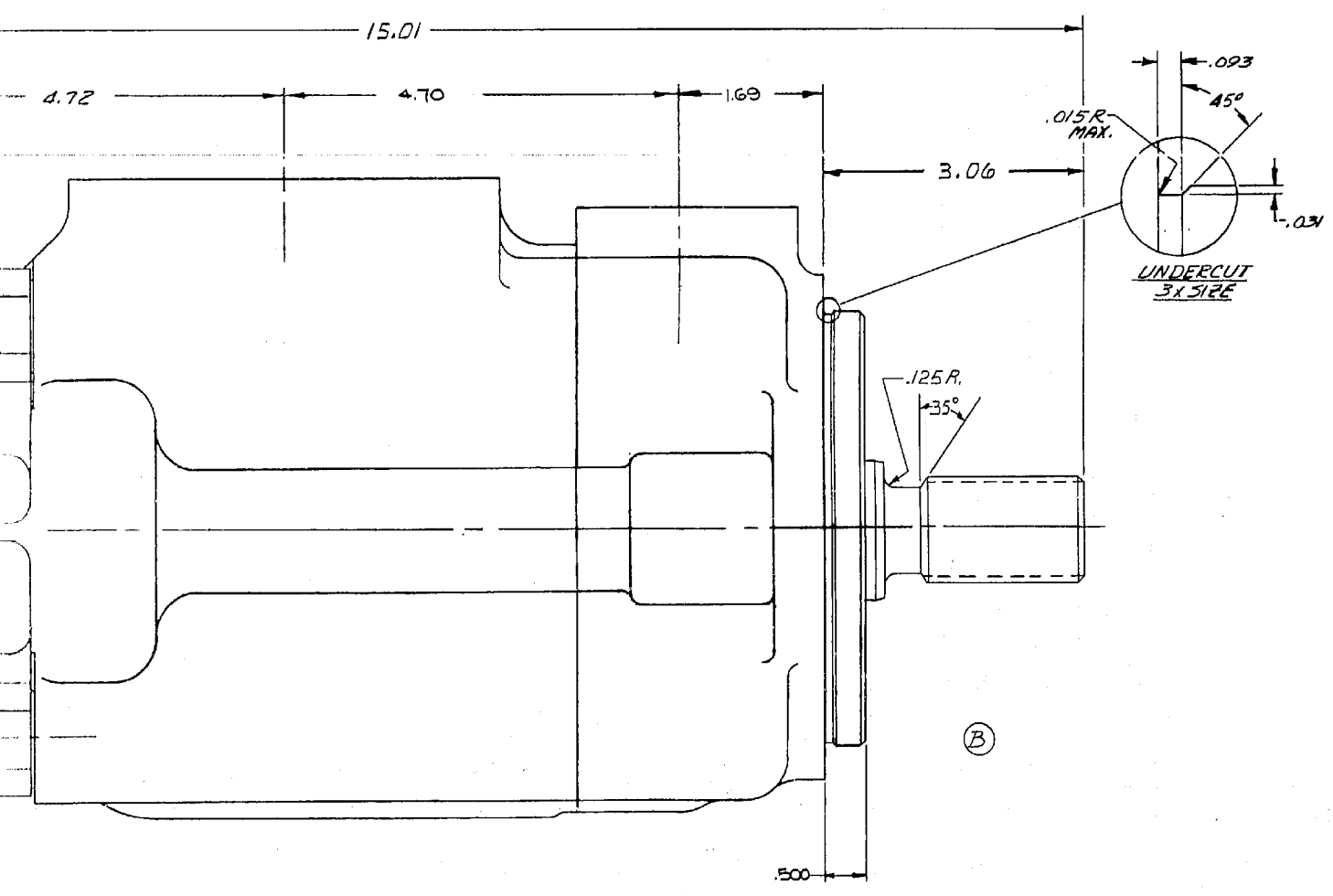


REVISIONS				
ZONE	LTR	DESCRIPTION	DATE	APPROVED
2D	A	ADDED #28 SHAFT DIMENSIONS	8-26-77	
3B	B	NOTE REMOVED	(-C)	

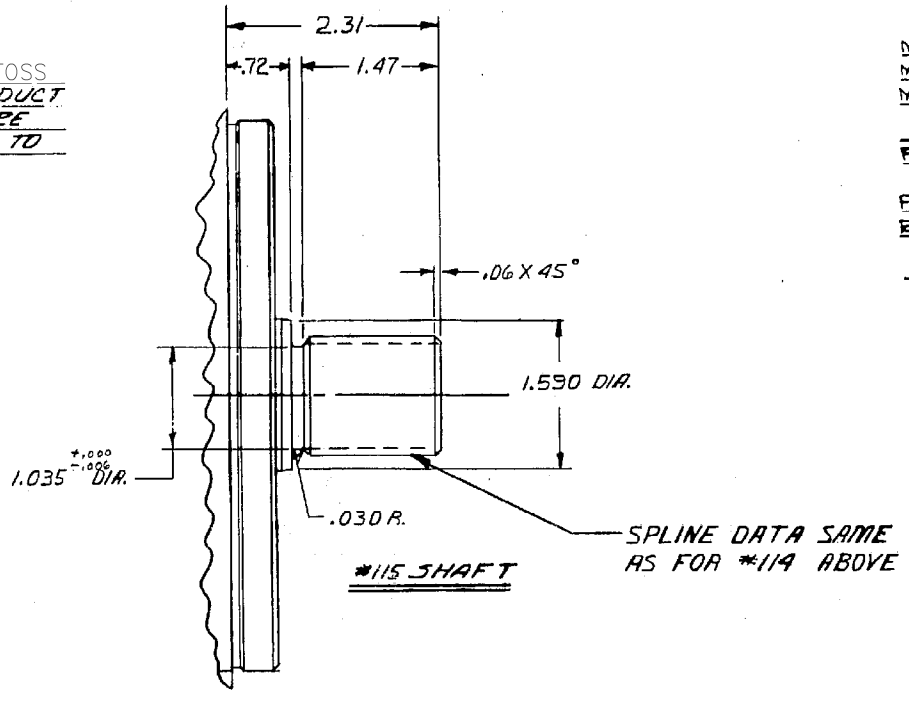


SHAFT #114 INVOLUTE SPLINE (SIDE TOOTH FIT)  
 12/24 DIAMETRAL PITCH  
 14 TEETH - 30° PRESSURE ANGLE  
 1.1667 PITCH DIA.  
 1.0104 BASE CIRCLE DIA.  
 1.0822 T.I.F. DIA. MAX.  
 .1286 MAX. EFFECTIVE TOOTH WIDTH  
 RADIUS AT MINOR D. .009 MAX.  
 .1248 MIN. ACTUAL TOOTH WIDTH  
 1.2293 ±.0018 MAJOR DIA.  
 1.063 ±.0018 MINOR DIA.  
 1.4028 ±.0018 MEASURED OVER  
 .1600 DIA. PINS  
 .1600 DIA. PINS



FOR THIS PRODUCT TO QUALIFY UNDER DANFOSS WARRANTY, THIS HIGH PERFORMANCE PRODUCT MUST BE USED ONLY IN CIRCUITS THAT ARE INITIALLY AND CONTINUOUSLY FILTERED TO 65 MICRONS OR LESS.

RING CAPACITY @ 1200 R.P.M. - 100 PSI	COVER END	SHAFT END
5 G.P.M.	42 G.P.M.	
8 "	47 G.P.M.	
11 "	50 G.P.M.	
12 G.P.M.	60 G.P.M.	
14 "		



MAXIMUM RECOMMENDED SPEED ----- 2200 RPM  
 MAXIMUM RECOMMENDED PRESSURE (SHAFT END) ----- 2500 PSI  
 MAXIMUM RECOMMENDED PRESSURE (COVER END) ----- 3000 PSI  
 CAUTION: DANFOSS ENGINEERING APPROVAL MUST BE OBTAINED FOR HIGHER SPEEDS OR PRESSURES.  
 PUMP IS ASSEMBLED FOR RIGHT HAND ROTATION, FOR LEFT HAND ROTATION ADD SUFFIX 'L' TO MODEL NUMBER, EXAMPLE: 4520V\*\*A\*\*L\*\*OL\*\*  
 FLUID RECOMMENDATION:  
 SEE REF. DATA SHEET M-2950-S



415680

UNLESS OTHERWISE SPECIFIED INTERPRET PER VS 1-3-3-1 ANGULAR DIMENSIONS ± 2° SURFACE ROUGHNESS 3.2 μm (125) TOLERANCES ON DECIMALS		THIRD ANGLE PROJECTION	MODEL 4520V**A**X-114*11-211*4520VQ SERIES	REV 255531	DR. L. PATTERSON 1-30-74	DATE 3/14/74	TITLE INSTALLATION-VANE
1 PLACE ± 0.1	2 PLACE ± 0.05	3 PLACE ± 0.03	REMOVE BURRS	BREAK EDGES 0.25mm (0.010) MAX.	DUAL DIMENSION POSITIONS	SCALE 1/1	WT
DRAWING NO. 415680		ACT. CALC. SHEET					

