



Bulletin PM1622-20-M1/USA

Parker Pumps Parts & Service

Effective: August 1998



PVP Series Variable Volume Piston Pump Service Bulletin

Model PVP23 **** 20
Model PVP33 **** 20



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Rear Ported Pump	4
Side Ported Pump	5
Control Options	6
Thru Shaft Options	7
Exploded View	8 & 9
Parts List	10 & 11
Service Notes	12
Basic Troubleshooting	13
Offer of Sale	15

Introduction:

The PVP23 or 33 **** 20 series piston pumps are designed to provide long life while operating with Hydraulic Oil. Refer to catalog 1550/USA for limits. However, should maintenance be required, the following instructions should be used for disassembly, replacement of parts, cleaning and assembly.

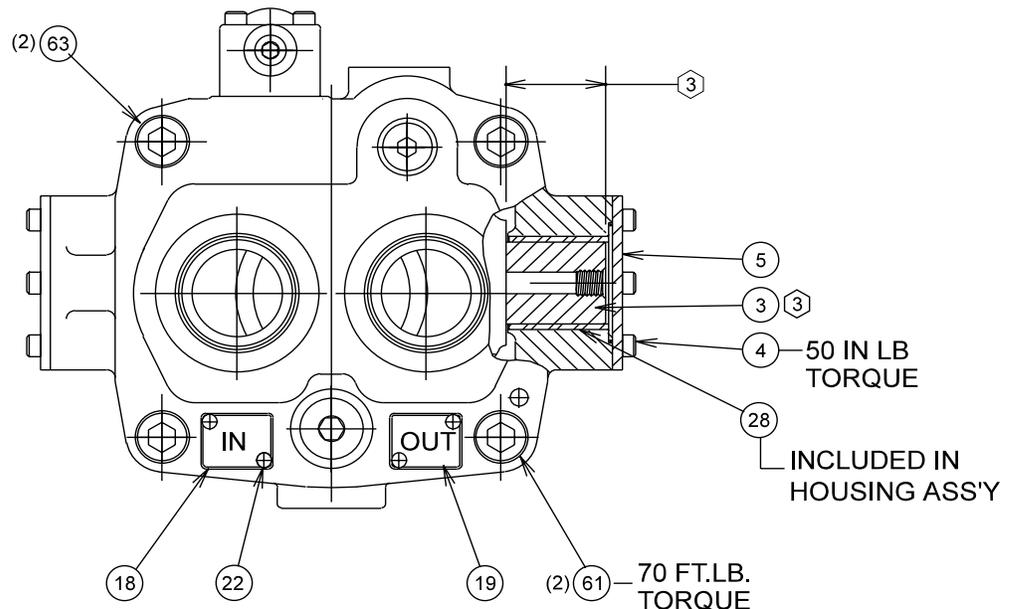
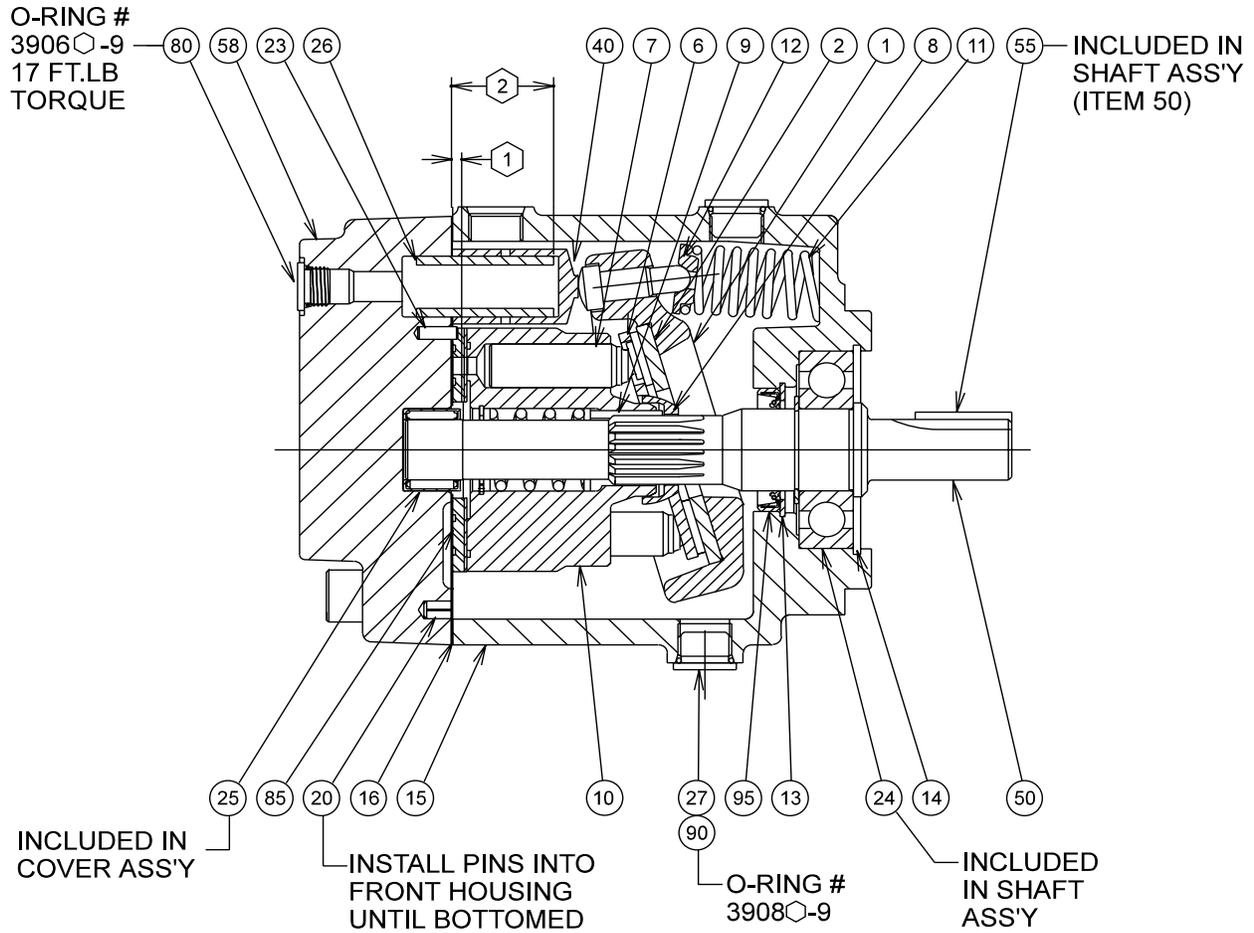
Note:

Prior to any pump disassembly, plug the open ports and clean all dirt from the outside of the pump.

Prior to assembly all parts should be cleaned and then lightly coated with oil.

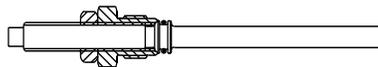
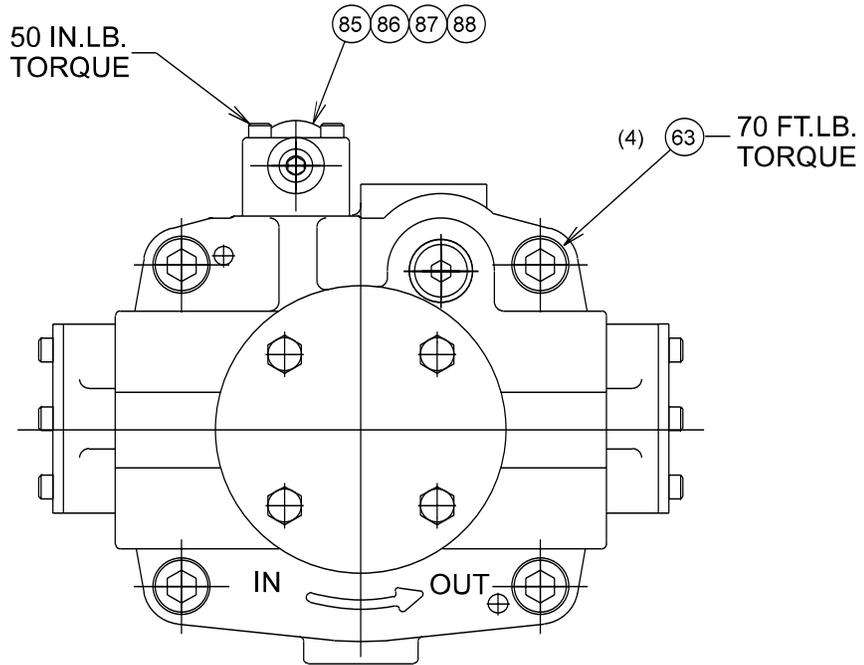
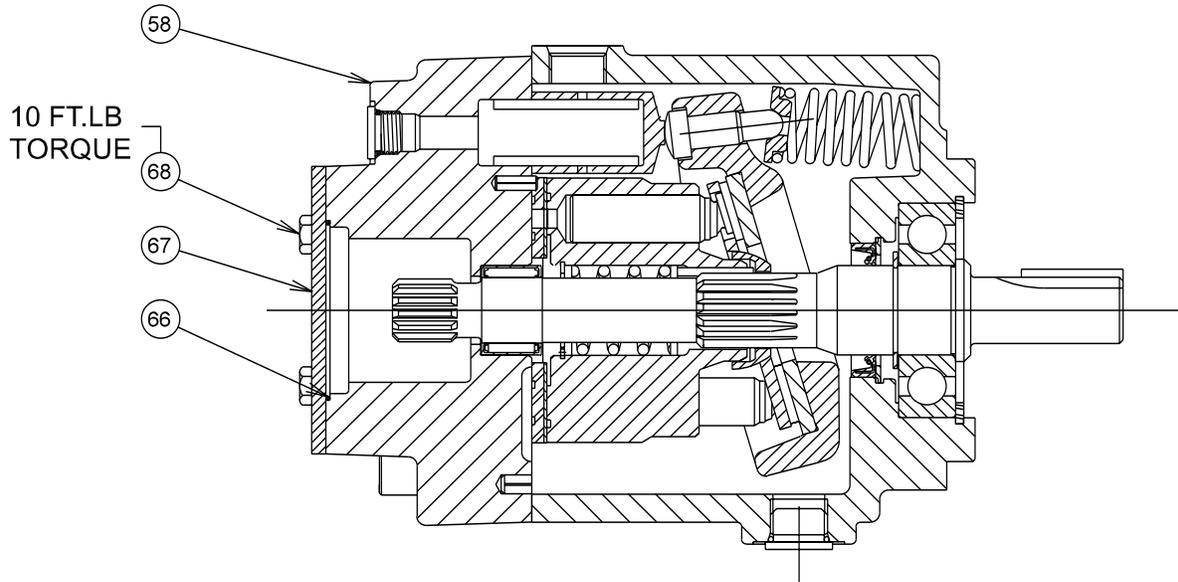
Warning:

Protective eye wear should be worn during all maintenance procedures.

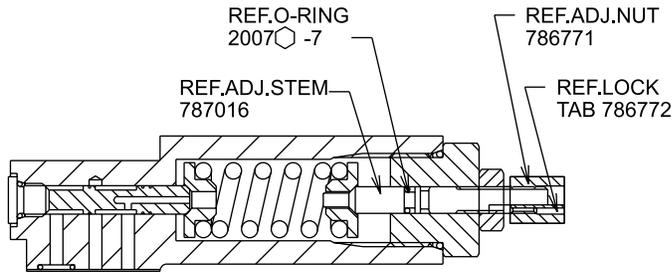


Notes:

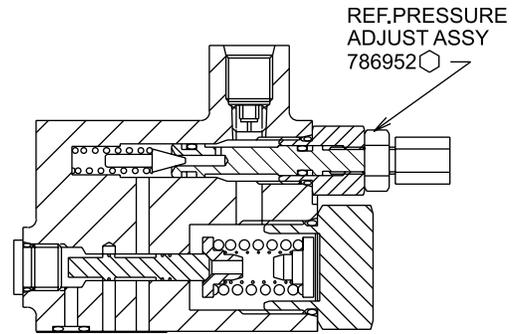
- ① Installed height of item 25 (needle bearing) into item 58 (rear cover) to be .125/.150.
- ② Installed height of item 26 (servo post) into item 58 (rear cover) to be 1.465/1.470.
- ③ Item 3 (trunnion pin) to be pressed in until shoulder bottoms on swashplate.
4. Illustration shows righthand (CW) rotation pump. Lefthand (CCW) pumps will have the inlet, outlet ports and the rotation arrow reversed.



ADJUSTABLE MAX. VOLUME STOP
 VOLUME STOP OPTION "2"
 O-RING 2011 \square -9
 ITEM #48

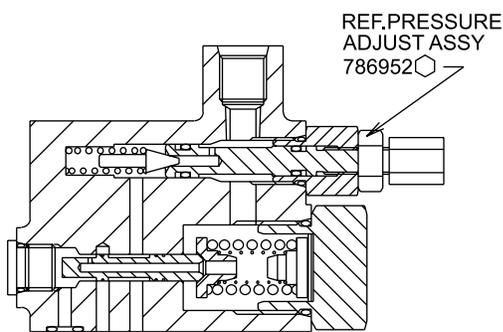
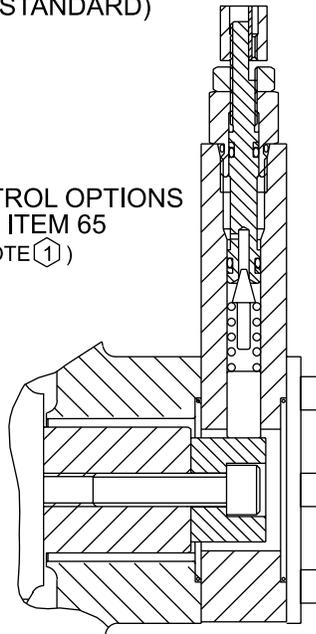


"OMIT" COMPENSATOR (STANDARD)
ITEM 85

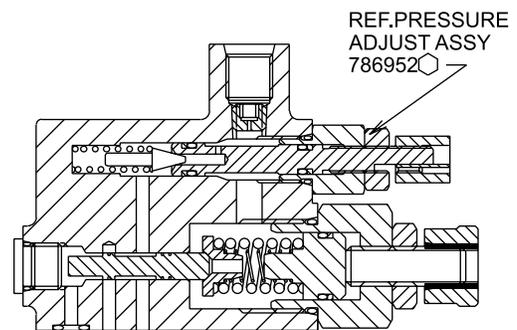


"ME" COMPENSATOR
(REMOTE W/EXTERNAL SENSE)
ITEM 87

POWER CONTROL OPTIONS
"H" & "C" ITEM 65
(SEE NOTE 1)



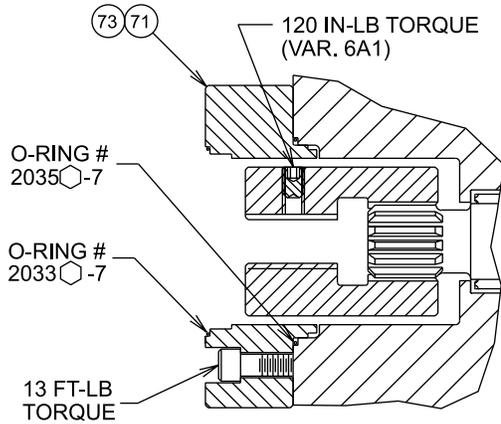
REMOTE CONTROL OPTION "M"
REQUIRED W/POWER OPTION "H"
ITEM 86



LOAD SENSE OPTION "A"
REQUIRED W/POWER OPTION "C"
ITEM 88

Notes:

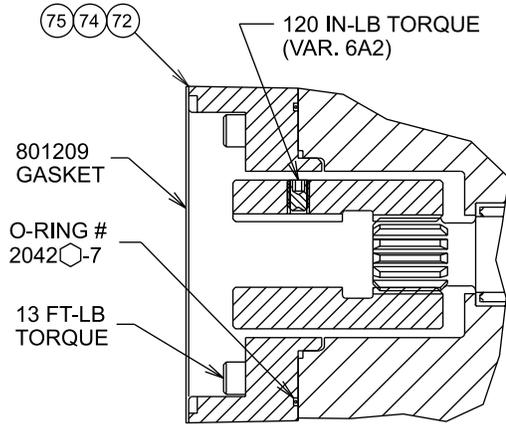
1. Must be used with proper compensator assembly. Horsepower (torque) control assembly does not include pressure compensator assembly. For "H" option use "M" compensator. For "C" option use "A" compensator.



**THRU SHAFT VARIATIONS
"6A1"&"6A3"**

REAR PUMP CONFIGURATION:

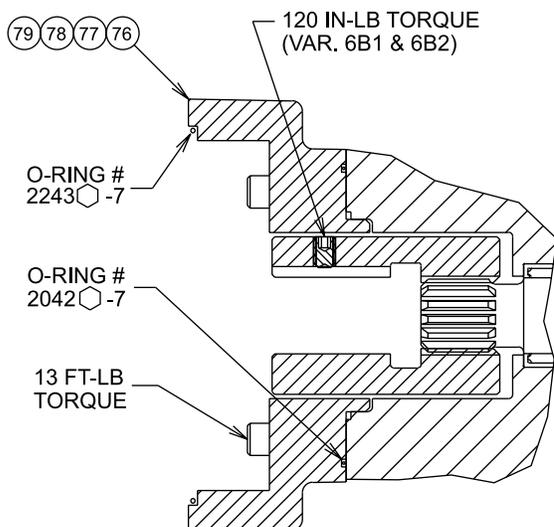
- SAE AA 2 BOLT
- 2.000 PILOT DIAMETER
- SHAFT SIZES:
 - 6A1 - .500 X.125 KEY - KIT# 787233
 - 6A3 - 9 TOOTH 20/40 PITCH SPLINE - KIT# 787235



**THRU SHAFT VARIATIONS
"6A2", "6A4", "6A5"
"9A4", "9A5"**

REAR PUMP CONFIGURATION:

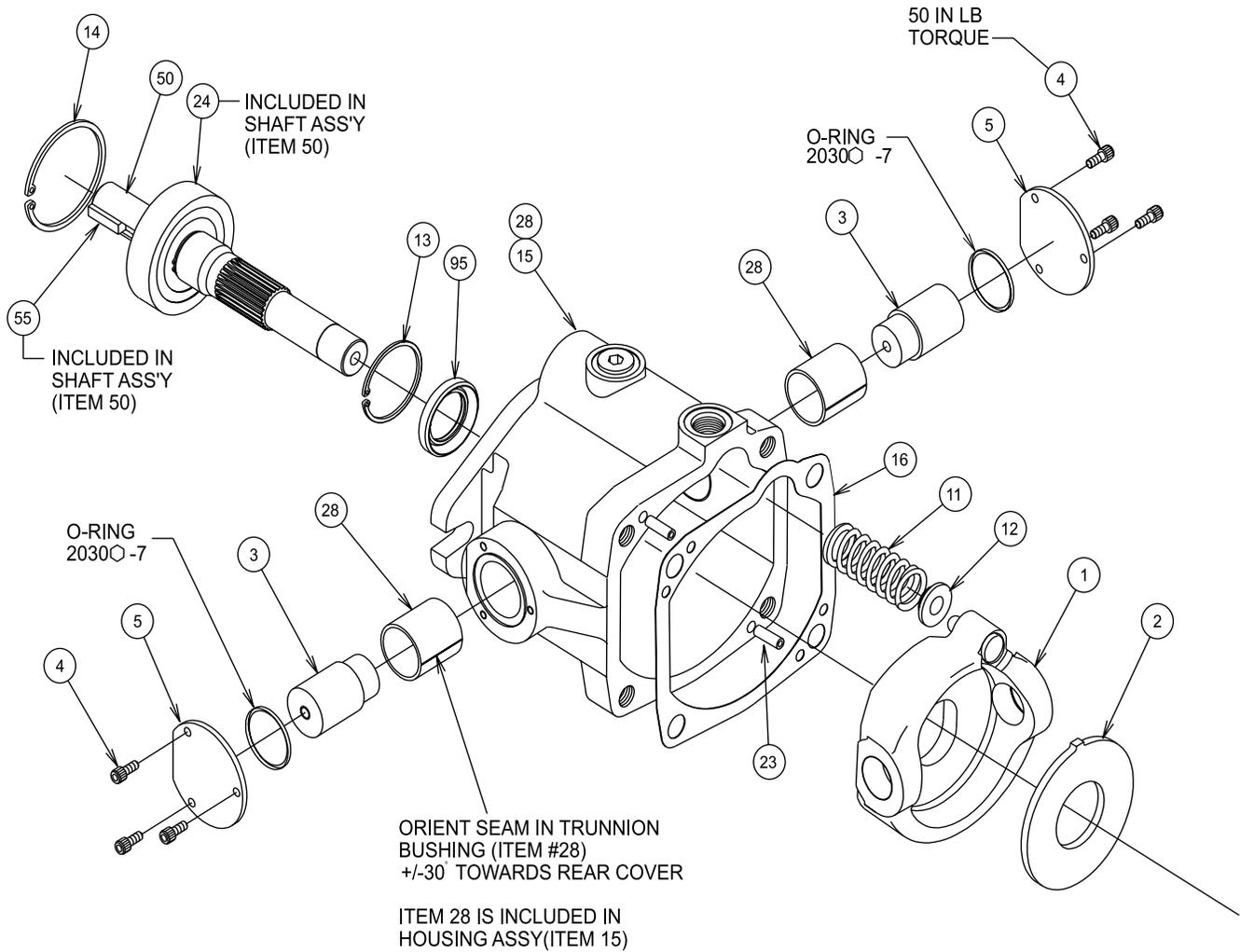
- SAE A 2 BOLT
- 3.250 PILOT DIAMETER
- SHAFT SIZES:
 - 6A2 - .750 X.188 KEY - KIT# 787234
 - 6A4 - 9 TOOTH 16/32 PITCH SPLINE - KIT# 787236
 - 6A5 - 11 TOOTH 16/32 PITCH SPLINE - KIT# 787392
 - 9A4 - 9 TOOTH 16/32 PITCH SPLINE - KIT# 788208
 - 9A5 - 11 TOOTH 16/32 PITCH SPLINE - KIT# 788209



**THRU SHAFT VARIATIONS
"6B1", "6B2", "6B3", "6B4"
"9B3", "9B4"**

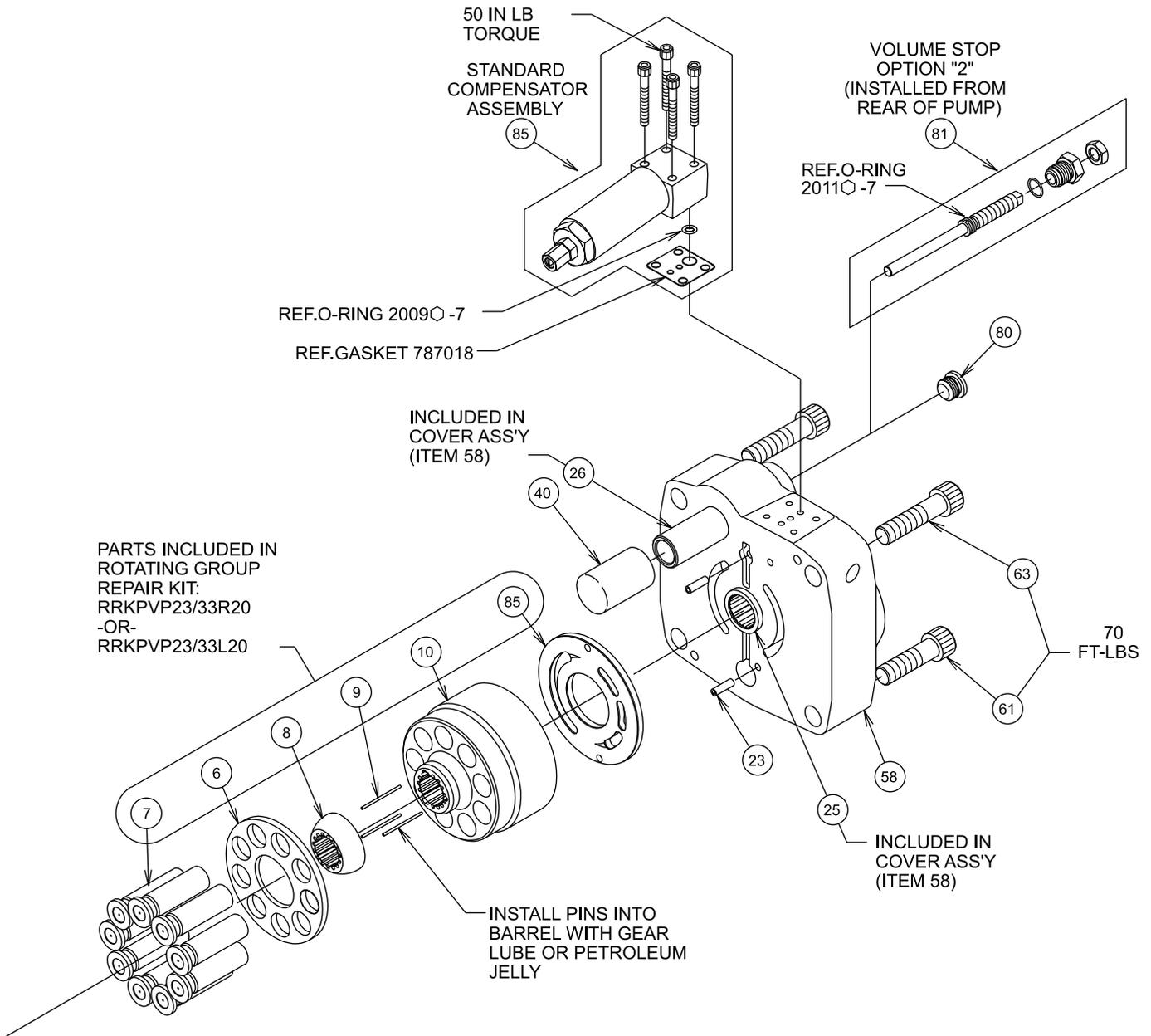
REAR PUMP CONFIGURATION:

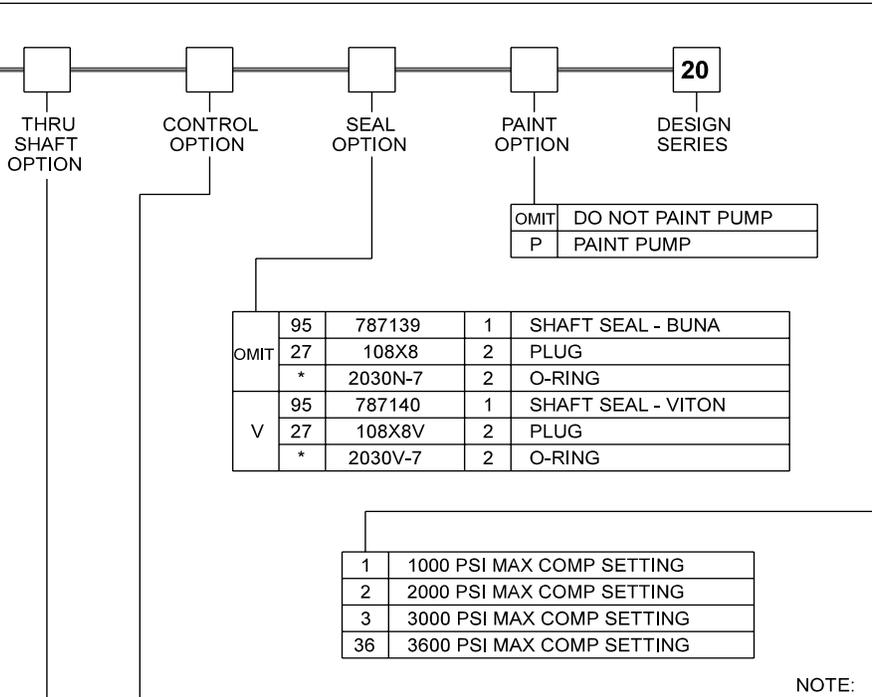
- SAE B 2 BOLT
- 4.000 PILOT DIAMETER
- SHAFT SIZES:
 - 6B1 - .875 X.250 KEY - KIT# 787237
 - 6B2 - 1.00 X.250 KEY - KIT# 787238
 - 6B3 - 13 TOOTH 16/32 PITCH SPLINE - KIT# 787239
 - 6B4 - 15 TOOTH 16/32 PITCH SPLINE - KIT# 787240
 - 9B3 - 13 TOOTH 16/32 PITCH SPLINE - KIT# 788210
 - 9B4 - 15 TOOTH 16/32 PITCH SPLINE - KIT# 788211



Notes:

1. Illustration shows righthand (CW) rotation pump. Lefthand (CCW) pumps will have the compensator on opposite side, and port plate kidneys reversed.
2. Seal kit (SKPVP23/33□20) consists of all O-rings, gaskets and shaft seal.





OMIT	85	787010	⊖ - *	1	STANDARD COMP. ASSY
M	86	787028	⊖ - *	1	REMOTE COMP ASSY (INT)
ME	87	787029	⊖ - *	1	REMOTE COMP ASSY (EXT)
A	88	787027	⊖ - *	1	LOAD SENSE COMP ASSY
H	86	787028	⊖ - *	1	REMOTE COMP ASSY (INT)
	89	788055	⊖	1	HORSEPOWER ASSEMBLY
C	88	787027	⊖ - *	1	LOAD SENSE COMP ASSY
	89	788055	⊖	1	HORSEPOWER ASSEMBLY
VO	-	SEE ABOVE		1	USE STD 'OMIT' CONTROL
VM	-	SEE ABOVE		1	USE 'M' CONTROL
VA	-	SEE ABOVE		1	USE 'A' CONTROL
VH	-	SEE ABOVE		1	USE 'H' CONTROL
VC	-	SEE ABOVE		1	USE 'C' CONTROL

NOTE:
 WHEN ORDERING CONTROLS FOR METRIC
 VERSION PUMPS(OPTIONS 8 & 9)
 ADDITIONAL METRIC SCREWS ARE REQUIRED.

CONTROL	PART NUMBER	QTY	DESCRIPTION
OMIT	210X105	1	CAPSCREW-M5X35MM
ALL OTHER	210X108	1	CAPSCREW-M5X50MM

NOTE:
 WHEN ORDERING CONTROLS M,ME,A,C,H FOR
 METRIC VERSION PUMPS(OPTIONS 8 & 9)AN
 ADDITIONAL ADAPTOR FITTING IS REQUIRED.

PORTING	PART NUMBER	QTY	DESCRIPTION
8	788517	1	FITTING(ISO6149)
9	788157	1	FITTING(1/4BSPP)

OMIT	70				
6	A1	71	787233	1	"A" PILOT,1/2 KEYED
	A2	72	787234	1	"A" PILOT,3/4 KEYED
	A4	74	787236	1	"A" PILOT,9T SPLINE
	A5	75	787392	1	"A" PILOT,11T SPLINE
	B1	76	787237	1	"B" PILOT,7/8 KEYED
	B2	77	787238	1	"B" PILOT,1" KEYED
	B3	78	787239	1	"B" PILOT,13T SPLINE
	B4	79	787240	1	"B" PILOT,15T SPLINE
9	A4	-	788208		METRIC - 'A' 9T
	A5	-	788209		METRIC - 'A' 11T
	B3	-	788210		METRIC - 'B' 13T
	B4	-	788211		METRIC - 'B' 15T

Notes:

- ⊖ O-Ring compound designation
 ⊖ =Nitrile, ⊖ = Viton.
- For proper operation of "H" control, it must be used with a remote compensator assembly.
- For proper operation of "C" control, it must be used with a load sense compensator assembly.
- Seal Kit P/N SKPVP 23/33 ⊖ 20

Rotation Group Kit P/N:
 RRPVP23/33 ⊖ 20

— R - CW
 — L - CCW

Service Notes:

- Use a clean lubricant (compatible with the working fluid) on all pump components during assembly.
- Most premature pump failures occur when contaminants from a previous failure have not been removed from the system, or cause for previous failure is still present (i.e. water in oil, filter bypassing, etc.)
- Thoroughly clean the reservoir, suction lines, suction strainer, drain lines, etc. before re-installing the pump.
- Always fill the pump case with clean fluid before starting a new or serviced pump for flooded suction, purge air from suction lines by cracking the inlet fitting or vent plug on pump. This should prevent an airlock condition and allow for faster priming.
- Starting the pump slowly by jogging (or turning over engine without allowing it to start) will help the pump prime and make it easier to determine when priming has occurred.
- Start pump with an open circuit whenever possible. Reduce the compensator to its minimum setting during start-up. Cycle the pump on and off stroke while increasing the compensator to its required setting.

This will assist in break-in of new components and help purge air from the case.

Basic Troubleshooting:

Pump Will Not Prime

- △ Pump should prime within 30 seconds. If it does not, **STOP**.
- △ Check for proper drive rotation.
- △ Make sure pump shaft is turning (i.e. key at coupling hubs is engaged).
- △ Make sure reservoir is full.
- △ Check for major sources of a suction leak (vent plug open, shaft seal missing (PAVC), flange not tight, pinched O-Ring at flange or pump housing).

Cannot Build Any Pressure

- △ Make sure pump is primed.
- △ Check alignment, especially on PAVC pumps without "9" option.
- △ Make sure systems is not an open circuit. A pump produces flow, not pressure. It can only limit pressure when the system requirement is higher than the pump compensator setting.

Can Only Build A Few Hundred PSI

- △ Compensator is backed all the way out.
- △ The remote or load sense line is vented.
- △ Control orifice or spool is plugged.
- △ Incorrect compensator spool (PVP).
- △ Pressure control dart is lodged open.
- △ Torque control plug is missing (PAVC).

Pump Will Not Compensate

- △ Differential spring over-compressed (i.e. spring guide dislocated).
- △ Control drain line blocked (PAVC).
- △ Pressure control stem vent hole is plugged.
- △ Control spool travel is hindered.
- △ Control orifice is missing (PAVC).
- △ Saturation orifice is missing in load sense circuit.

Notes:

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2. Payment: Payment shall be made by Buyer net 30 days from the date of delivery of the items purchased hereunder. Amounts not timely paid shall bear interest at the maximum rate permitted by law for each month or portion thereof that the Buyer is late in making payment. Any claims by Buyer for omissions or shortages in a shipment shall be waived unless Seller receives notice thereof within 30 days after Buyer's receipt of the shipment.

3. Delivery: Unless otherwise provided on the face hereof, delivery shall be made F.O.B. Seller's plant. Regardless of the method of delivery, however, risk of loss shall pass to Buyer upon Seller's delivery to a carrier. Any delivery dates shown are approximate only and Seller shall have no liability for any delays in delivery.

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6. Changes, Reschedules and Cancellations: Buyer may request to modify the designs or specification for items sold hereunder as well as the quantities and delivery dates thereof, or may request to cancel all or part of this order, however, no such requested modification or cancellation shall become part of the contract between buyer and Seller unless accepted by Seller in written amendment to this Agreement. Acceptance of any such requested modification or cancellation shall be at Seller's discretion, and shall be upon such terms and conditions as Seller may require.

7. Special Tooling: A tooling charge may be imposed for any special tooling, including without limitation, dies, fixtures, molds and patterns, acquired to manufacture items sold pursuant to this contract. Such special tooling shall be and remain Seller's property notwithstanding payment of any charges by Buyer, in no event will Buyer acquire any interest in apparatus belonging to Seller which is utilized in the manufacture of the items sold hereunder, even if such apparatus has been specially converted or adapted for such manufacture and notwithstanding any charges paid by Buyer. Unless otherwise agreed, Seller shall have the right

to alter, discard or otherwise dispose of any special tooling or other property in its sole discretion at any time.

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9. Taxes: Unless otherwise indicated on the face hereof, all prices and charges are exclusive of excise, sales, use, property, occupational or like taxes which may be imposed by any taxing authority upon the manufacture, sale or delivery of the items sold hereunder. If any such taxes must be paid by Seller or if Seller is liable for the collection of such tax, the amount hereof shall be in addition to amounts for the items sold. Buyer agrees to pay all such taxes or to reimburse Seller therefore upon receipt of its invoice. If Buyer claims exemption from any sales, use or other tax imposed by any taxing authority, Buyer shall save Seller harmless from and against any such tax together with any interest or penalties thereon which may be assessed if the items are held to be taxable.

10. Indemnity For Infringement of Intellectual Property Rights: Seller shall have no liability for infringement of any patents, trademarks, copyrights, trade dress, trade secrets or similar rights except as provided in this Part 10. Seller will defend and indemnify Buyer against allegations of infringement of U.S. patents, U.S. Trademarks, copyrights, trade dress and trade secrets (hereinafter "Intellectual Property Rights"). Seller will defend at its expense and will pay the cost of any settlement or damages awarded in an action brought against Buyer based on an allegation that an item sold pursuant to this contract infringes the Intellectual Property Rights of a third party. Seller's obligation to defend and indemnify Buyer is contingent on Buyer notifying Seller within ten (10) days after Buyer becomes aware of such allegations of infringement, and Seller having sole control over the defense of any allegations or actions including all negotiations for settlement or compromise. If an item sold hereunder is subject to a claim that it infringes the Intellectual Property Rights of a third party, Seller may, at its sole expense and option, procure for Buyer the right to continue using said item, replace or modify said item so as to make it noninfringing, or offer to accept return of said item and return the purchase price less a reasonable allowance for depreciation. Notwithstanding the foregoing, Seller shall have no liability for claims of infringement based on information provided by Buyer, or directed to items delivered hereunder for which the designs are specified in whole or part by Buyer, or infringements resulting from the modification, combination or use in a system of any item sold hereunder. The foregoing provisions of this Part 10 shall constitute Seller's sole and exclusive liability and buyer's sole and exclusive remedy for infringement of Intellectual Property Rights.

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11. Force Majeure: Seller does not assume the risk of and shall not be liable for delay or failure to perform any of Seller's obligations by reason of circumstances beyond the reasonable control of Seller (hereinafter "Events of Force Majeure"). Events of Force Majeure shall include without limitation, accidents, acts of god, strikes or labor disputes, acts, laws, rules or regulations of any government or government agency, fires, floods, delays or failures in delivery of carries or suppliers, shortages of materials and any other cause beyond Seller's control.

12. Entire Agreement/Governing Law: The terms and conditions set forth herein, together with any amendments, modifications and any different terms or conditions expressly accepted by Seller in writing, shall constitute the entire Agreement concerning the items sold, and there are no oral or other representation or agreements which pertain thereto. This Agreement shall be governed in all respects by the law of the State of Ohio. No actions arising out of the sale of the items sold hereunder or this Agreement may be brought by either party more than two (2) years after the cause of action accrues.

FPG 9-91-P



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8/98 DB Hess 5000



PVP23/33 DESIGN SERIES 20 CHANGES

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Design Series 20 Changes.

1. Larger diameter trunnion pins to support higher loads at 3600 PSI.
2. Larger Teflon trunnion bearings to match larger diameter pins.
3. Change housing machining to match larger diameter trunnion bearings and pins.
4. Change swashplate machining to use integral hardened wear pin versus flame hardening process.
5. Change geometry on servo piston to match new swashplate contact point.
6. Change geometry on swashplate bias spring retainer to match hardened wear pin.
7. Change swashplate bias spring to match retainer.
8. New horsepower control assembly (788055) to match housing and trunnion pin changes.
9. Incorporate "6T" variation (thru-shaft with cover plate) into all pumps with side porting.

Rules for Interchangeability of Design 20 and Design 10.

1. Design 20 swashplate assembly (788016) will fit in design 10 pump, but will require replacing all the following components:
 - Swashplate bias spring (788039)
 - Bias spring retainer (787769)
 - Servo piston
PVP23 (788052)
PVP33 (787939)

NOTE: When repairing a design 10 PVP23/33 with any one of the above components, all four pieces must be replaced as a set.

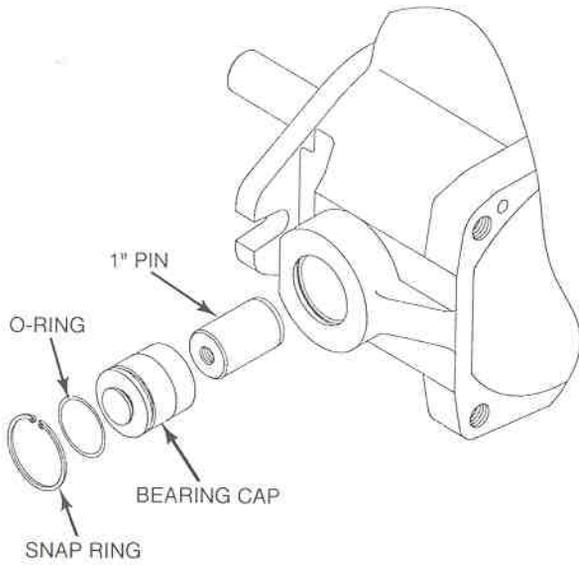
2. Design 20 housing assembly (788056) can be used to rebuild a design 10 pump, but will require replacing all the following components:
 - Trunnion pins – 2 (787978)
 - Cover plate – 2 (787986)
 - Screws – 6 (10 x 209)
 - Horsepower assembly* – 1 (788055)

NOTE: When repairing a design 10 PVP23/33 with any one of the above components all the components, must be replaced as a set.

3. The seal kit for a design 20 PVP23/33 is fully compatible with a design series 10 PVP23/33.

PVP23/33 DESIGN 10	PVP23/33 DESIGN 20	PART NAME	DESCRIPTION OF CHANGE
787142	788056	Housing	Change size of trunnion bearing
787061	788041	Trunnion Bearing Assembly Teflon Bearing	Match trunnion pin changes
2026*-7	2030*-7	O-ring	
787123	787978	Trunnion Pin	1" dia. to 1.181" dia. (30mm)
56 x 318	787986 10 x 209	Snap Ring, Cover Plate	Change from snap ring retainer to bolt on cover plate
787121	788016	Swashplate Assembly	Change from flame heat treated swashplate to installing hardened wear pin
787145	787769	Swashplate Bias Spring Retainer	Change due to wear pin (male to female joint)
787144	788039	Swashplate Bias Spring	ID different to match spring retainer
787200	788052	23cc Servo Piston	Match change to swashplate
787146	787939	33cc Servo Piston	Match change to swashplate
787357	788055	HP Assembly	Matches housing and trunnion pin changes

PVP23/33 Design Series 10



PVP23/33 Design Series 20

