

**PEOPLE STEEL MILLS LIMITED**  
Manghopir, Karachi

**REQUEST FOR QUOTATION**



PSM/FP-88/PR-21421/2162/2023

26-OCT-23

M/S

**SUBJECT: PURCHASE OF AXIAL PISTON VARIABLE DISPLACEMENT PUMP**

Dear Sirs,

We intend to purchase the following as per detail given below.

S.NO	DESCRIPTION	QUANTITY
1	AXIAL PISTON VARIABLE DISPLACEMENT PUMP: TYPE SERIES 20 :MAX DISPLACEMENT 89 CM CUBE: MIN SPEED 500 RPM :RATED SPEED 2900 RPM HYDRAULIC OIL: CLOCK WISE ROTATION FROM INPUT SHAFT. MAKE: SAUFER DANFOSS	2 NOS

Please submit your most competitive offer indicating **C&F Karachi** prices inclusive of all ancillary charges with minimum delivery period. Shipment must be made through **PSM** designated shipping lines (list attached). Offer must remain valid for **30** days and the same may be faxed on No: 0092-21-6770112 latest by **02-NOV-23** and original to be sent by courier.

Payment will be made through irrevocable Letter of Credit against shipping documents at sight or Cash Against Document (CAD). All bank charges inside Pakistan to be borne by PSM while all bank charges outside Pakistan as well as charges for additional confirmation of L/C if desired will be on your Principal/Account.

Performance Bond equal to 10% of the total order value will be required from a scheduled bank operation in Pakistan if the value exceeds US\$10,000.00

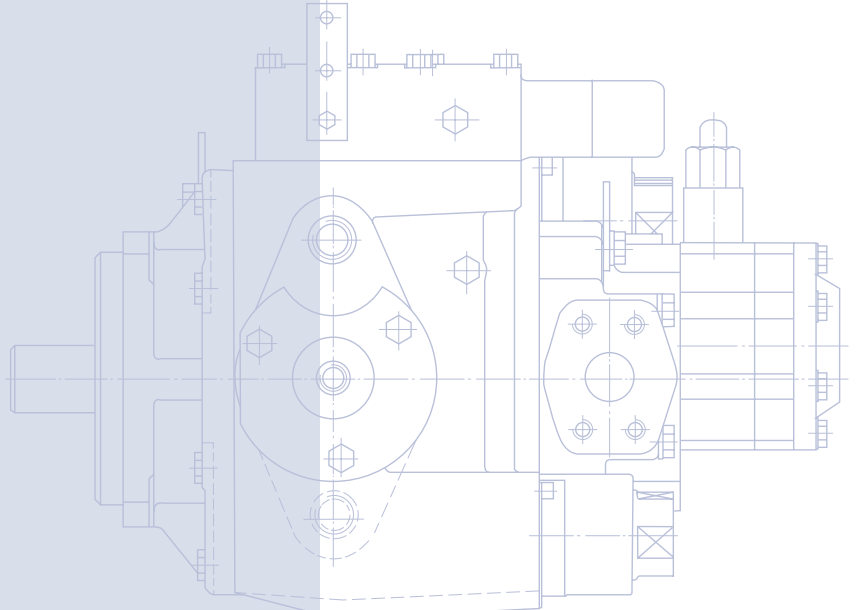
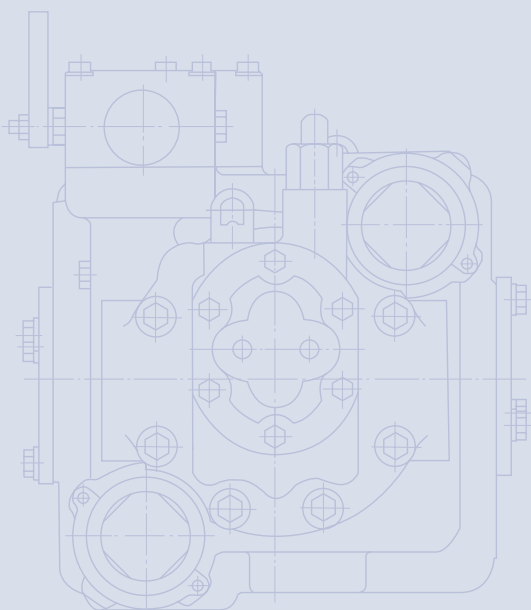
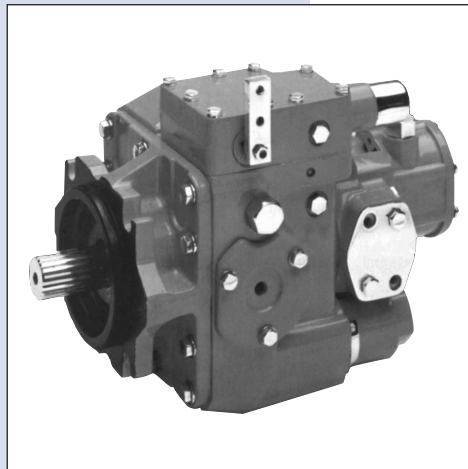
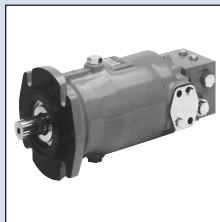
Regards,  
Your Sincerely,

  
SALEEM AHMED  
HEAD PROCUREMENT



Series 20  
Axial Piston Pumps

Technical  
Information



## INTRODUCTION

Sauer-Danfoss a world leader in hydraulic power systems has developed a family of axial piston pumps.

## DESCRIPTION

Sauer-Danfoss axial piston variable displacement pumps are of swash plate design with variable flow capability suitable for hydrostatic transmissions with closed loop circuit. Tilting the swash plate to the opposite side of the neutral or zero displacement position reverses flow direction.

Sauer-Danfoss axial piston variable displacement pumps are well engineered and easy to handle.

The full-length shaft with a highly efficient tapered roller bearing arrangement offers a high loading capacity for external radical forces.

The hydro-mechanical servo displacement control maintains the selected swash plate position and hence pumps displacement.

Upon release of the control handle, the swash plate automatically returns to zero position and the flow reduces to zero.

High case pressures can be achieved without leakage even at the lowest temperatures by using suitable shaft seals.

The servo valve arrangement offers the facility to incorporate function regulators and remote control systems.

Axial piston units are designed for easy servicing. Complete dismantling and reassembly can be carried out with standard hand tools, and all components or sub-assemblies are replaceable.

Axial piston variable displacement pumps of the Sauer-Danfoss pattern are made by licensed producers worldwide, providing consistent service and fully interchangeable parts.

## TYPICAL MARKETS

- Industrial
- Mining
- Transit Mixer
- Utility Vehicles

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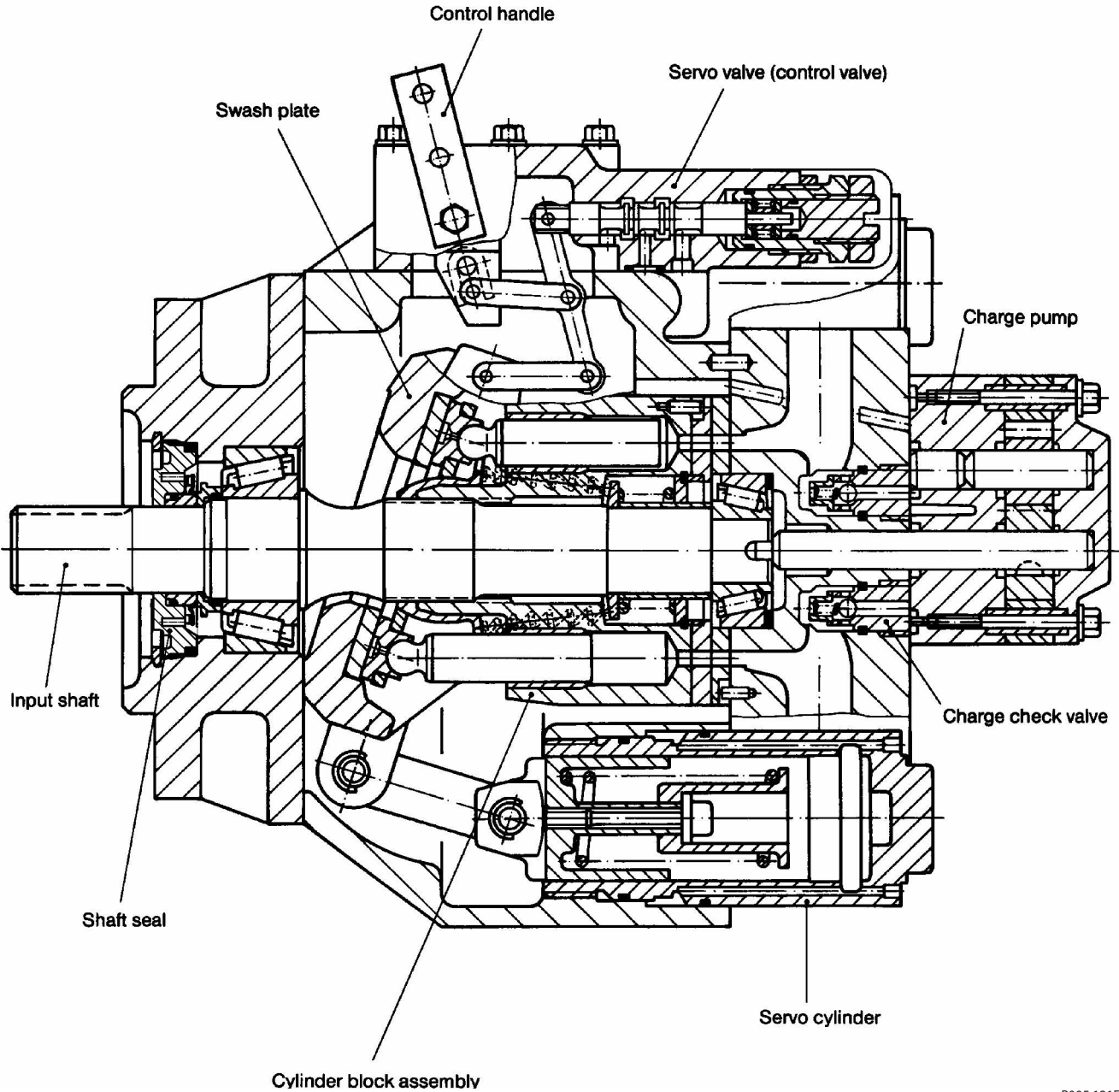
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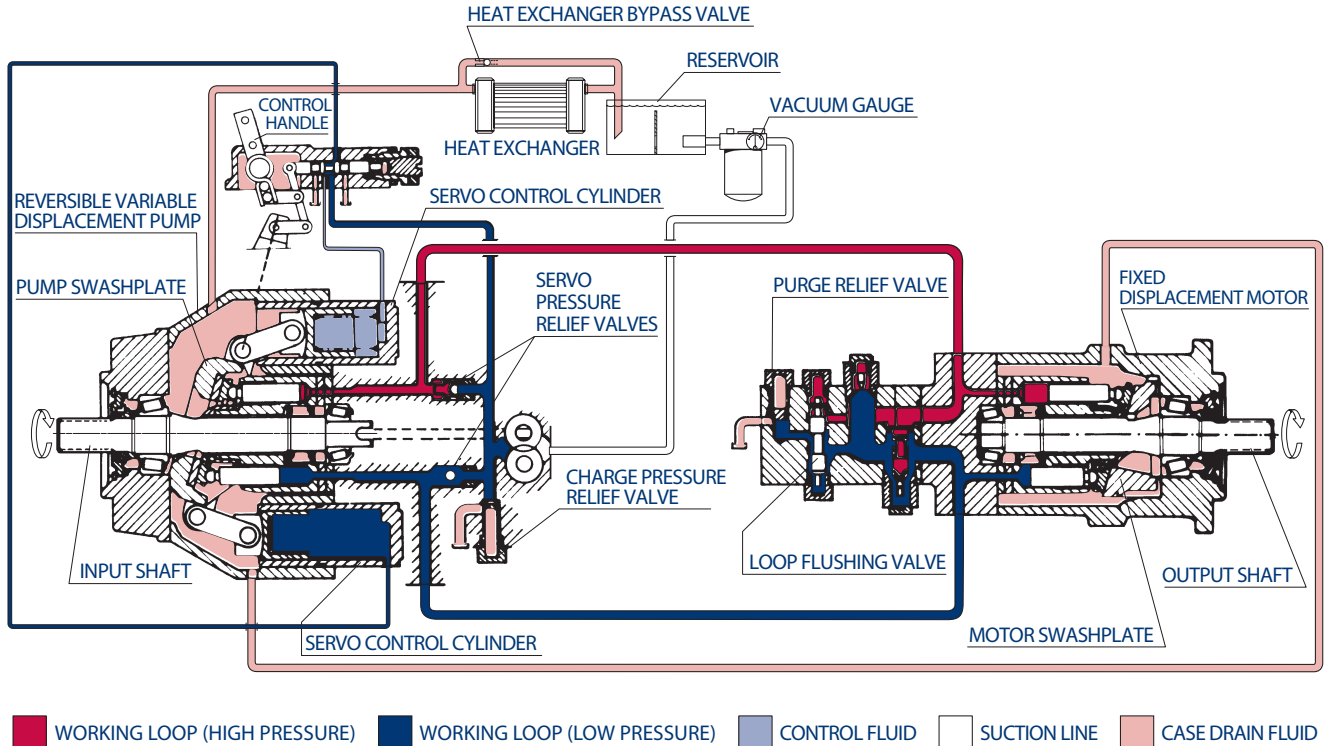
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**AXIAL PISTON VARIABLE DISPLACEMENT PUMP**



P005 121E

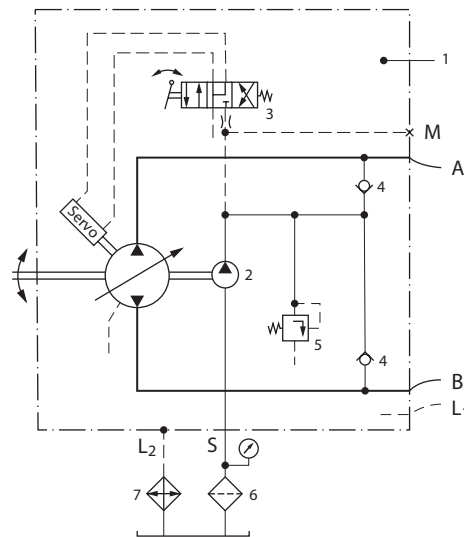
**PUMP AND MOTOR CIRCUIT DESCRIPTION**



P000 027E

Above figure shows schematically the function of a hydrostatic transmission using an axial piston variable displacement pump and a fixed displacement motor.

**PUMP CIRCUIT SCHEMATIC**



Designation:

- 1 = Variable displacement pump
- 2 = Charge pump
- 3 = Servo control valve
- 4 = Charge check valve
- 5 = Charge relief valve
- 6 = Filter
- 7 = Heat exchanger

Ports:

- A, B = Main pressure ports (working loop)
- S = Suction port - charge pump
- L1, L2 = Drain ports
- M = Gauge port - charge pressure

P000 012

**TECHNICAL PARAMETERS Design**

Axial piston pump of swash plate design, with variable displacement.

**Type of mounting**

SAE four bolt flanges.

**Pipe connections**

Main pressure ports: SAE split flange  
 Remaining ports: SAE O-ring boss

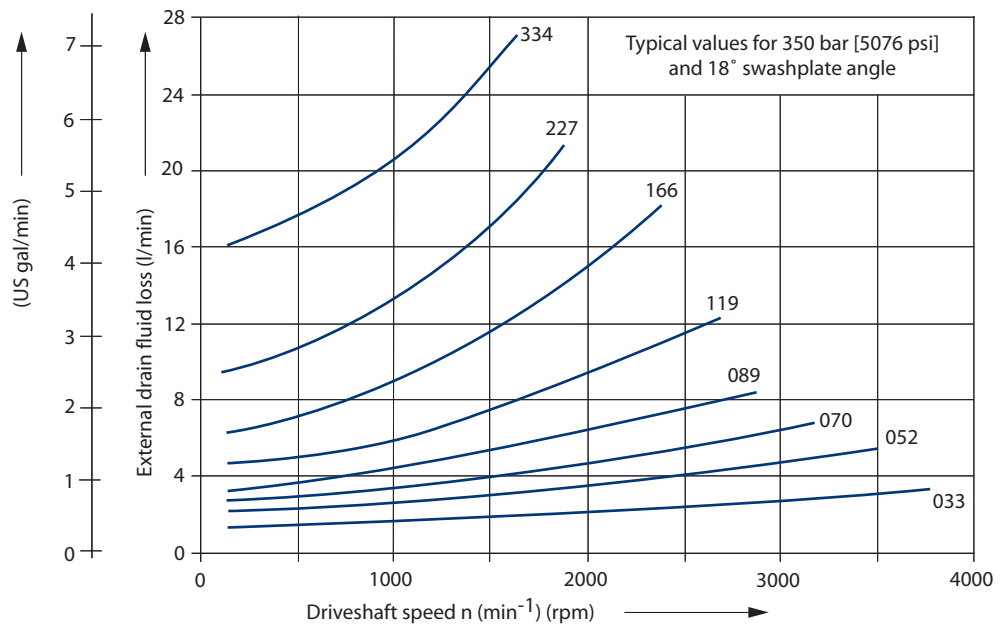
**Direction of rotation**

Clockwise or counterclockwise (viewing from the input shaft).

**Installation position**

Optional; pump housing must be always filled with hydraulic fluid.

**External drain fluid loss**



P005 105E

## HYDRAULIC PARAMETERS

### System pressure range, input $p_1$

Variable displacement pump:

Charge pressure nominal: 13 bar [189 psi] above case pressure

Charge pressure minimum: 8 bar [116 psi], intermittent only

Charge pump input pressure:

Min. allowable pressure, continuous = 0.75 bar [10.9 psi] absolute

Min. allowable pressure, intermittent = 0.50 bar [7.3 psi] absolute (for cold start)

Charge pump output pressure:

Max. operating pressure = 35 bar [508 psi] above case pressure

### System pressure range, output $p_2$

Pressure on port A or B: Max. operating pressure  $\Delta p = 420$  bar [6092 psi]

Max. high pressure setting  $\Delta p = 460$  bar<sup>1</sup> [6672 psi]

<sup>1</sup>only with POR-valve

### Case pressure

Max. rated pressure = 2.5 bar [36.3 psi]

Intermittent = 5.0 bar [72.5 psi]

### Hydraulic fluid

Refer to Sauer-Danfoss publications *Hydraulic Fluids and Lubricants and Experience with Bio Fluids for biodegradable hydraulic fluids.*

### Hydraulic fluid temperature range

$\vartheta_{\min} = -40$  °C [-40 °F]

$\vartheta_{\max} = 95$  °C [203 °F]

### Viscosity range

$\nu_{\min} = 7$  mm<sup>2</sup>/s [49 SUS\*]

$\nu_{\max} = 1000$  mm<sup>2</sup>/s [4630 SUS\*] (intermittent cold start)

Recommended viscosity range: 12 - 60 mm<sup>2</sup>/s [66 - 280 SUS\*]

\*SUS (Saybolt Universal Second)

### Filtration

Required cleanliness level: ISO 4406 - 1999 Code 22/18/13 or better. Refer to Sauer-Danfoss publication *Hydraulic Fluids and Lubricants and Design Guideline for Hydraulic Fluid Cleanliness.*

### Shaft load

The pump will accept radial and axial loads on its shaft, the maximum capacity being determined by direction and point of application of the load. Please contact your Sauer-Danfoss representative.



**HYDRAULIC PARAMETERS (continued)**

Technical data										
		Dimension	Frame size							
			033	052	070	089	119	166	227	334
Max. displacement		cm <sup>3</sup> [in <sup>3</sup> ]	33.3 [2.03]	51.6 [3.15]	69.8 [4.26]	89.0 [5.43]	118.7 [7.24]	165.8 [10.12]	227.3 [13.87]	333.7 [20.36]
Charge pump displacement	options	cm <sup>3</sup> [in <sup>3</sup> ]	12.30 [0.75]		18.03 [1.10]		18.85 [1.15]	32.80 [2.00]		65.50 [4.00]
			18.03 [1.10]		12.30 [0.75]		32.80 [2.00]	65.50 [4.00]		-
Minimum speed		min <sup>-1</sup> (rpm)	500							
Rated speed 1		min <sup>-1</sup> (rpm)	3800	3500	3200	2900	2700	2400	2100	1900
Maximum swash plate angle		degree	±18							
Mass moment of inertia of rotating group (without charge pump)		kg m <sup>2</sup> · 10 <sup>-3</sup> [lbf ft <sup>2</sup> · 10 <sup>-3</sup> ]	4.34 [103.0]	8.14 [193.2]	12.34 [292.8]	17.77 [421.7]	29.11 [690.8]	50.19 [1191.0]	86.80 [2059.8]	161.40 [3830.0]
Weight		kg [lb]	45 [99]	55 [121]	63 [139]	78 [172]	124 [273]	164 [362]	212 [467]	270 [595]

<sup>1</sup> for higher speeds contact your Sauer–Danfoss representative

**Determination of nominal pump size**

Unit:	Metric system:	Inch system
Pump output flow	$Q = \frac{V_g \cdot n \cdot \eta_v}{1000}$ l/min	$Q = \frac{V_g \cdot n \cdot \eta_v}{231}$ [gpm]
Input torque	$M = \frac{V_g \cdot \Delta p}{20 \cdot \pi \cdot \eta_m}$ Nm	$M = \frac{V_g \cdot \Delta p}{2 \cdot \pi \cdot \eta_m}$ [lbf·in]
Input power	$P = \frac{V_g \cdot n \cdot \Delta p}{600\,000 \cdot \eta_t}$ kW	$P = \frac{V_g \cdot n \cdot \Delta p}{396\,000 \cdot \eta_t}$ [hp]

Efficiency characteristic curves available on request.

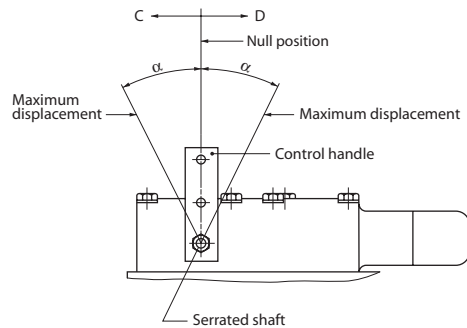
$V_g$	= Pump displacement per revolution	cm <sup>3</sup> [in <sup>3</sup> ]
$n$	= Pump speed	min <sup>-1</sup> (rpm)
$\Delta p$	= Hydraulic pressure differential	bar [psi]
$\eta_v$	= Pump volumetric efficiency	
$\eta_m$	= Pump mechanical efficiency	
$\eta_t$	= Pump total efficiency	

**SERVO DISPLACEMENT CONTROL (LINEAR RESPONSE)**

Regulated by the control handle on the servo valve, the swash plate can be infinitely varied in both directions with the help of the servo system. The pump displacement resulting from any control handle position can be established using the figures on this page. The angle of the control handle for stroke initiation and for the final position of the stroke can vary from unit to unit within the range of the tolerance band. The inter-relationship of flow direction, rotation of the pump and the control handle movement is shown below.

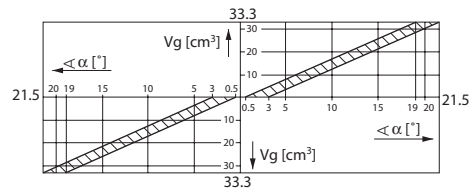
**Pump flow direction**

Flow direction changes with the direction of rotation and the control handle movement (see above).



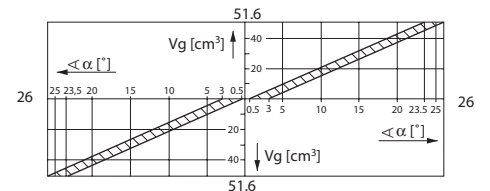
P000 013E

Pump rotation	Movement of control handle in direction	Pressure port OUT	Pressure port IN
Counter-clockwise (L)	C	B	A
	D	A	B
Clockwise (R)	C	A	B
	D	B	A



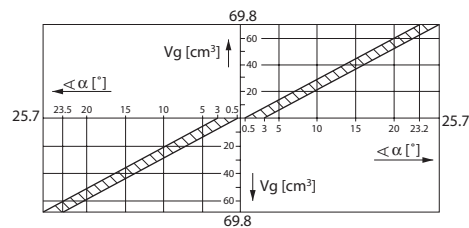
SPV 2/033

P000 014



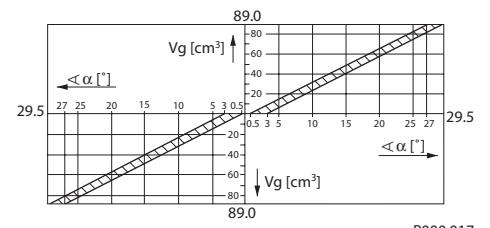
SPV 2/052

P000 015



SPV 2/070

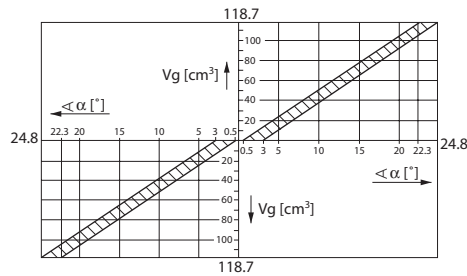
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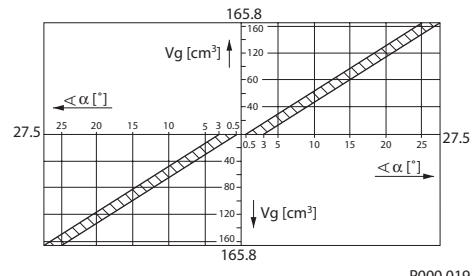
SPV 2/089

P000 017

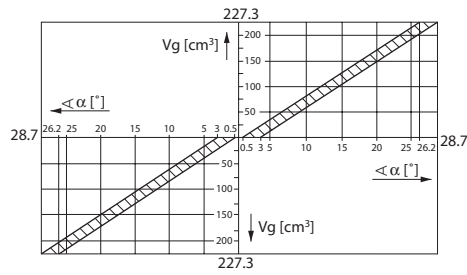
**SERVO DISPLACEMENT CONTROL (LINEAR RESPONSE) (continued)**



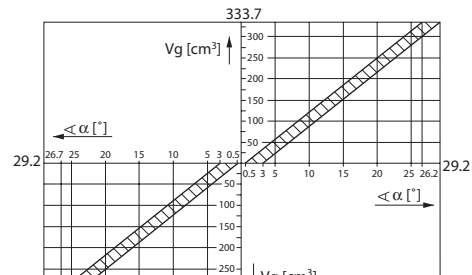
SPV 2/119 P000 018



SPV 2/166 P000 019



SPV 2/227 P000 020



SPV 2/334 P000 021

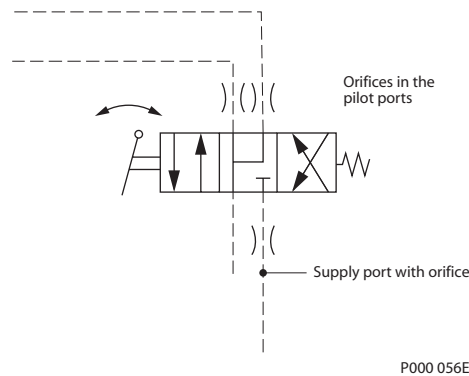
**Reversing time**

Time for the directional change of the flow from  $Q_{max}$ , across zero to  $Q_{max}$ , depending on the size of the control orifice fitted in the supply port to the servo valve (see below). The values given assume movement of the control handle directly from one end position to the other.

- Adjustment time of handle: < minimum reserving time
- Operating pressure:  $\Delta p_2 = 210 \text{ bar [3046 psi]}$
- Speed:  $n = 1450 \text{ min}^{-1} \text{ (rpm)}$
- System temperature:  $50 \text{ °C [122 °F]}$
- Viscosity:  $35 \text{ mm}^2/\text{s [164 SUS]}$

Frame size	Minimum reversing time (s) without orifice	Maximum reversing time (s) with orifice $\varnothing 0.66$ in supply port
033	0.7	5.6
052	0.7	5.6
070	1.0	9.3
089	1.1	9.0
119	1.8	15.7
166	1.8	15.3
227	3.7	42.0
334	5.6	43.8

**SERVO DISPLACEMENT CONTROL (LINEAR RESPONSE) (continued)**



**Schematic diagram of servo valve with alternative orifice positions**

**Reset time**

Time for reducing the flow from either flow direction from  $Q_{max}$  to 0 releasing the control handle.

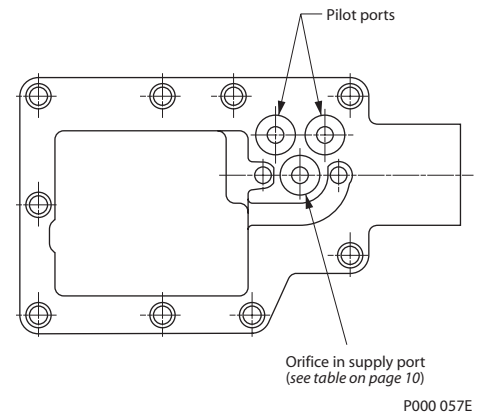
Assuming no mechanical blockage of the control handle's free return and assuming no orifices in the pilot ports:

Operating pressure:  $\Delta p_2 = 210 \text{ bar [3046 psi]}$

System temperature:  $50 \text{ }^\circ\text{C [122 }^\circ\text{F]}$

Viscosity:  $35 \text{ mm}^2/\text{s [164 SUS]}$

Frame size	Minimum reset time (s)
033	
052	
070	3.0
089	
119	
166	4.2
227	
334	5.4



**Servo valve counter bored recesses for orifice insert**

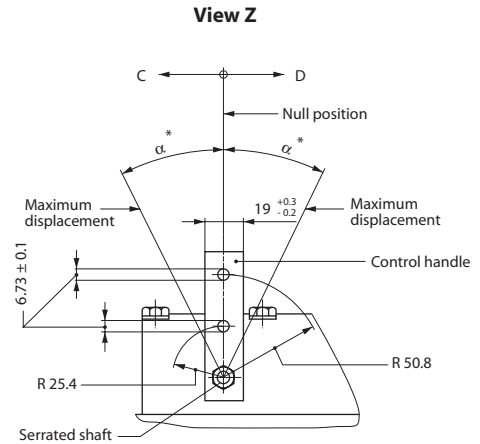
**Changing reversing and reset time**

Inserting one orifice in each of the pilot ports can extend the reversing time. The reset time will also be extended.

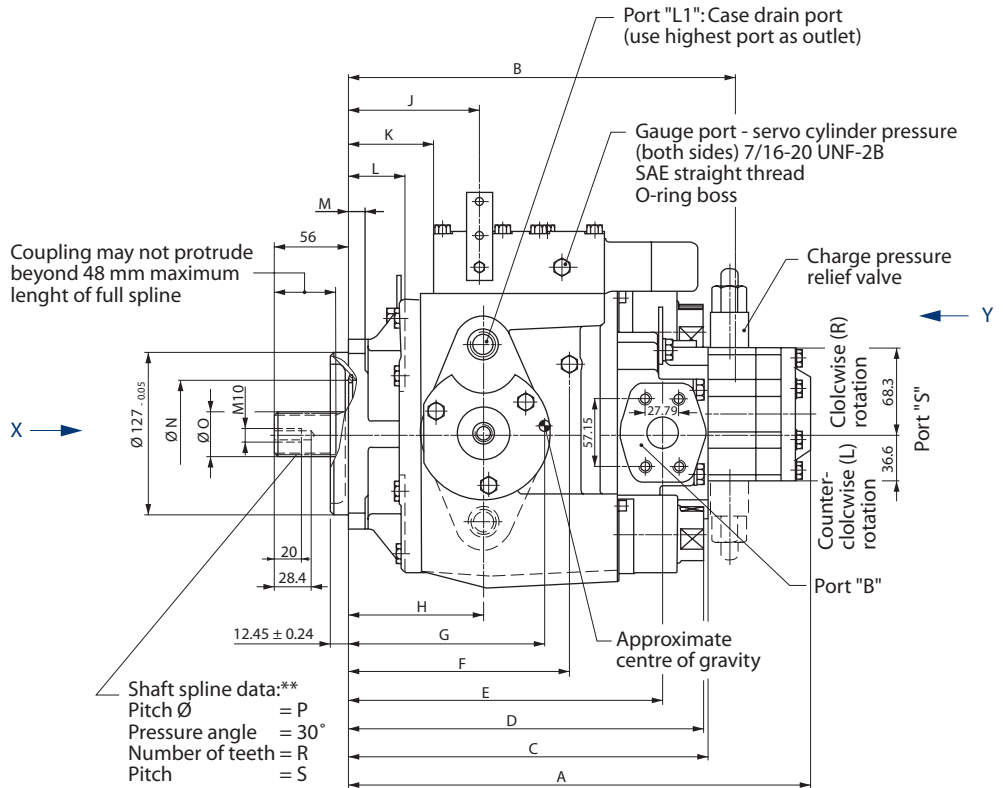
Inserting an orifice in one of the pilot ports only can extend the reversing time in one flow direction. The reset time will be extended only for this flow direction.

**OUTLINE DRAWING,  
CONFIGURATION PS,  
DISPLACEMENT  
CONTROL VML 1**

- \* Minimum and maximum angle  $\alpha$ , (see section servo displacement control).
- \*\* Shaft spline data: spline shaft with involute spline, according to SAE handbook, 1963, class 1, fillet root side fit.

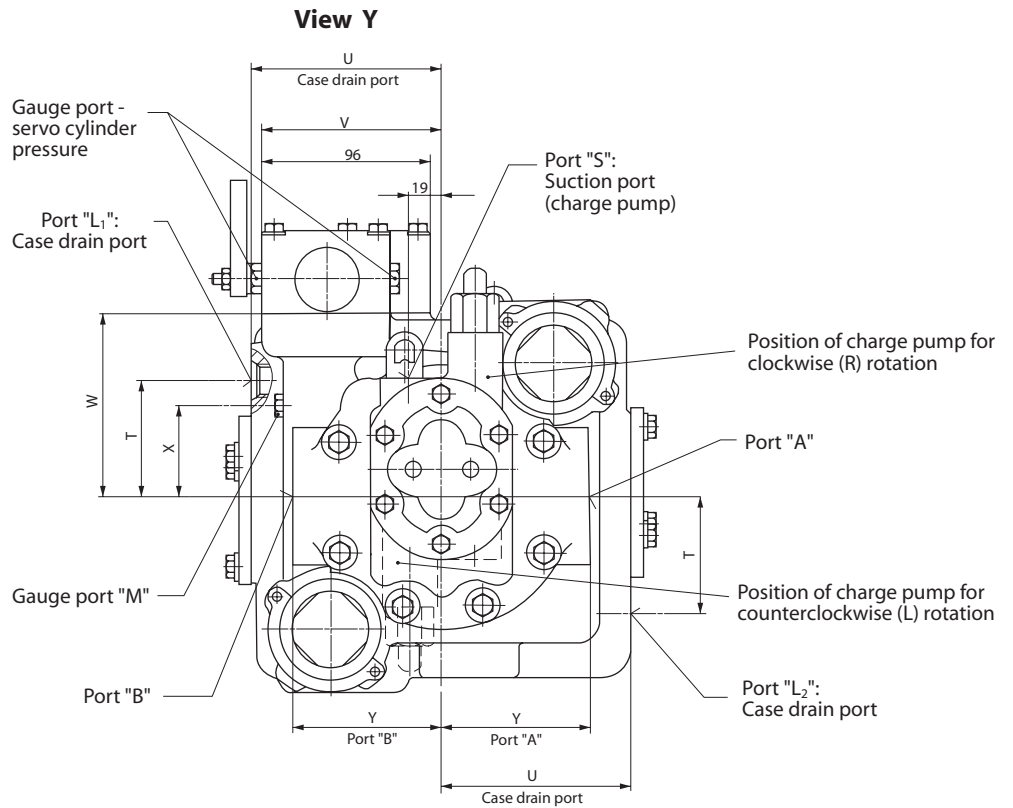


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P005 106E

**OUTLINE DRAWING,  
CONFIGURATION PS,  
DISPLACEMENT  
CONTROL VML 1  
(continued)**



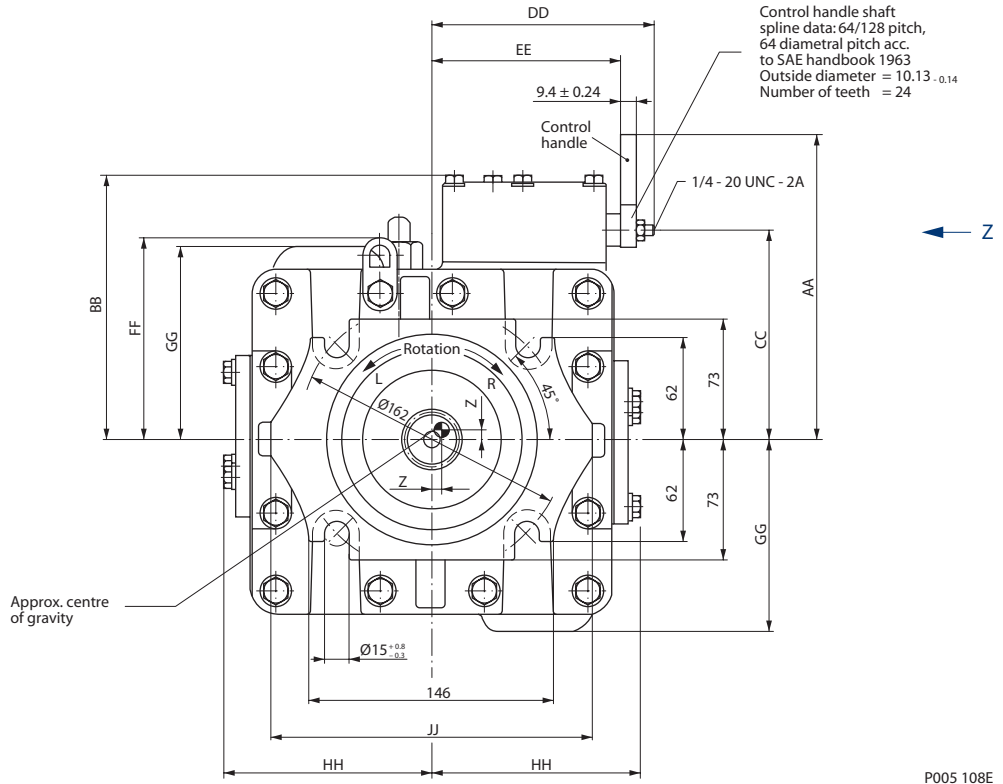
P005 107E

Max. torque for charge pump inlet port (7/8 -14 UNF - 2B) is 22 - 28 Nm [195 - 248 lbf·in].

Frame size	Port <b>A</b> and <b>B</b>	Port <b>L<sub>1</sub></b> and <b>L<sub>2</sub></b>	Port <b>S</b>	Port <b>M</b>
033	SAE flange, size 1	7/8-14 UNF-2B SAE straight thread O-ring boss	7/16-20 UNF-2B SAE straight thread O-ring boss	7/16-20 UNF-2B SAE straight thread O-ring boss
052	SAE split flange boss 5000 psi			
070	4 threads 3/8-16 UNC-2B			
089	18 deep			

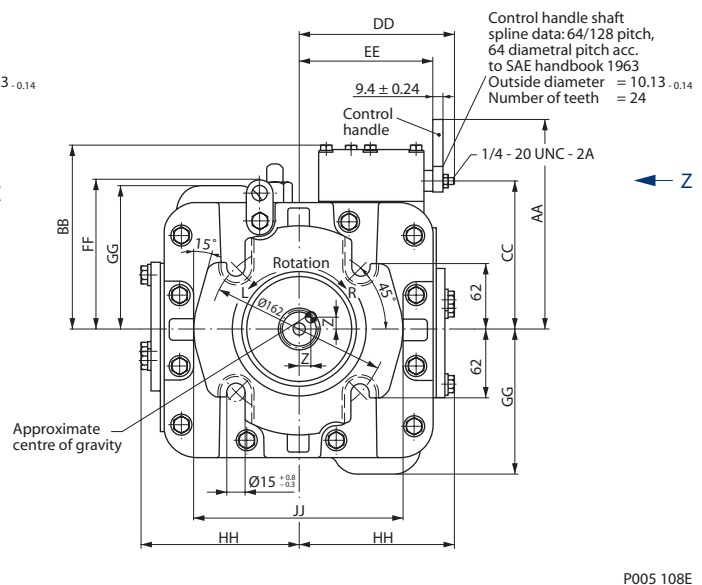
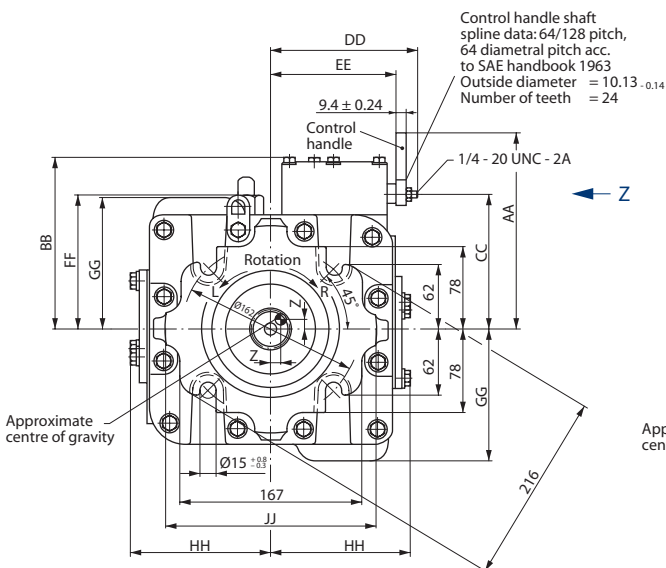
**OUTLINE DRAWING,  
CONFIGURATION PS,  
DISPLACEMENT  
CONTROL VML 1  
(continued)**

**View X (for SPV 2/033 - 2/052 only)**



**View X (for SPV 2/033 - 2/052 only)**

**View X (for SPV 2/033 - 2/052 only)**



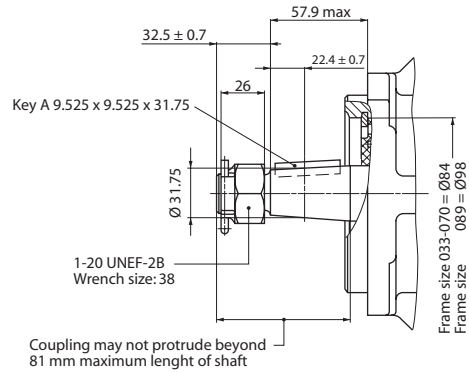
**OUTLINE DRAWING, CONFIGURATION PS, DISPLACEMENT CONTROL VML 1 (Continued)**

Dimensions												
Frame size	B mm [in]	C mm [in]	D mm [in]	E mm [in]	F mm [in]	G mm [in]	H mm [in]	J mm [in]	K mm [in]	L mm [in]	M mm [in]	∅ N mm [in]
033	284 [11.181]	263 [10.354]	270 [10.630]	225 [8.858]	162 [6.378]	159 [6.260]	100 [3.937]	94 [3.701]	58 [2.283]	48 [1.890]	16 [0.630]	84 [3.307]
<b>052</b>	<b>301</b> [11.850]	<b>280</b> [11.024]	<b>282</b> [11.102]	<b>246</b> [9.685]	<b>174</b> [6.850]	<b>152</b> [5.984]	<b>107</b> [4.213]	<b>106</b> [4.173]	<b>70</b> [2.756]	<b>48</b> [1.890]	<b>16</b> [0.630]	<b>84</b> [3.307]
070	315 [12.402]	294 [11.575]	305 [12.008]	259 [10.197]	188 [7.402]	146 [5.748]	112 [4.409]	120 [4.724]	84 [3.307]	48 [1.890]	16 [0.630]	84 [3.307]
089	328 [12.913]	307 [12.087]	312 [12.283]	271 [10.669]	195 [7.677]	140 [5.512]	118 [4.646]	129 [5.079]	91 [3.583]	49 [1.929]	17.5 [0.689]	98 [3.858]
Frame size	T mm [in]	U mm [in]	V mm [in]	W mm [in]	X mm [in]	Y mm [in]	Z mm [in]	AA mm [in]	BB mm [in]	CC mm [in]	DD mm [in]	EE mm [in]
033	62 [2.441]	95.7 [3.768]	92 [3.622]	95 [3.740]	51 [2.008]	81 [3.189]	3 [0.118]	174.9 [6.886]	150 [5.906]	115.9 [4.563]	120 [4.724]	100 [3.937]
<b>052</b>	<b>68</b> [2.677]	<b>108.7</b> [4.280]	<b>102</b> [4.016]	<b>108</b> [4.252]	<b>53.2</b> [2.094]	<b>85.8</b> [3.378]	<b>6.35</b> [0.250]	<b>187.6</b> [7.386]	<b>162</b> [6.378]	<b>128.6</b> [5.063]	<b>131</b> [5.157]	<b>110</b> [4.331]
070	71.4 [2.811]	112.7 [4.437]	105 [4.134]	108 [4.252]	60.5 [2.382]	85.8 [3.378]	9.5 [0.374]	187.6 [7.386]	162 [6.378]	128.6 [5.063]	133 [5.236]	113 [4.449]
089	77.7 [3.059]	128.7 [5.067]	115 [4.528]	119 [4.685]	65 [2.559]	95.2 [3.748]	12.7 [0.500]	198.6 [7.819]	173 [6.811]	139.6 [5.496]	144 [5.669]	123 [4.843]
Frame size	FF mm [in]	GG mm [in]	HH mm [in]	JJ mm [in]	A <sup>1</sup> mm [in]		Shaft spline				Bore diameter for shaft coupling mm [in]	
					Charge pump cm <sup>3</sup> [in <sup>3</sup> ]		∅ O mm [in]	∅ P mm [in]	R mm [in]	S		
					12 [0.732]	18 [1.098]						
033	117 [4.606]	113 [4.449]	108 [4.252]	190 [7.480]	341 [13.425]	350 [13.780]	34.50 <sup>-0.17</sup> <sub>-0.0067</sub> [1.358]	33.338 [1.313]	21 [0.827]	16/32	31.75 <sup>+0.062</sup> <sub>[1.250 + 0.0024]</sub>	
<b>052</b>	<b>122</b> [4.803]	<b>116</b> [4.567]	<b>124</b> [4.882]	<b>191</b> [7.520]	<b>358</b> [14.094]	<b>367</b> [14.449]	<b>34.50</b> <sup>-0.17</sup> <sub>-0.0067</sub> [1.358]	<b>33.338</b> [1.313]	<b>21</b> [0.827]	<b>16/32</b>	<b>31.75</b> <sup>+0.062</sup> <sub>[1.250 + 0.0024]</sub>	
070	126 [4.961]	123 [4.843]	130 [5.118]	194 [7.638]	372 [14.646]	381 [15.000]	34.50 <sup>-0.17</sup> <sub>-0.0067</sub> [1.358]	33.338 [1.313]	21 [0.827]	16/32	31.75 <sup>+0.062</sup> <sub>[1.250 + 0.0024]</sub>	
089	140 [5.512]	134 [5.276]	148 [5.827]	194 [7.638]	358 [14.094]	394 [15.512]	37.68 <sup>-0.17</sup> <sub>-0.0067</sub> [1.483]	36.513 [1.438]	23 [0.906]	16/32	34.95 <sup>+0.062</sup> <sub>[1.376 + 0.0024]</sub>	

<sup>1</sup> Short version available on request. Please contact your local Sauer-Danfoss representative.



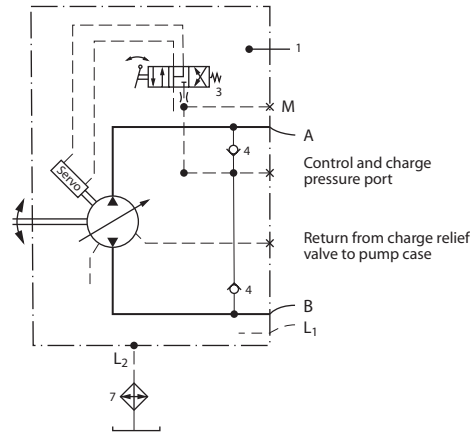
**TAPERED SHAFT END**



P000 006E

Depth, keygroove: 5,7 + 0,1  
Shaft, cone: 1 : 8

**PUMP CONFIGURATION  
AA 010, DISPLACEMENT  
CONTROL VML 1**



P000 058E

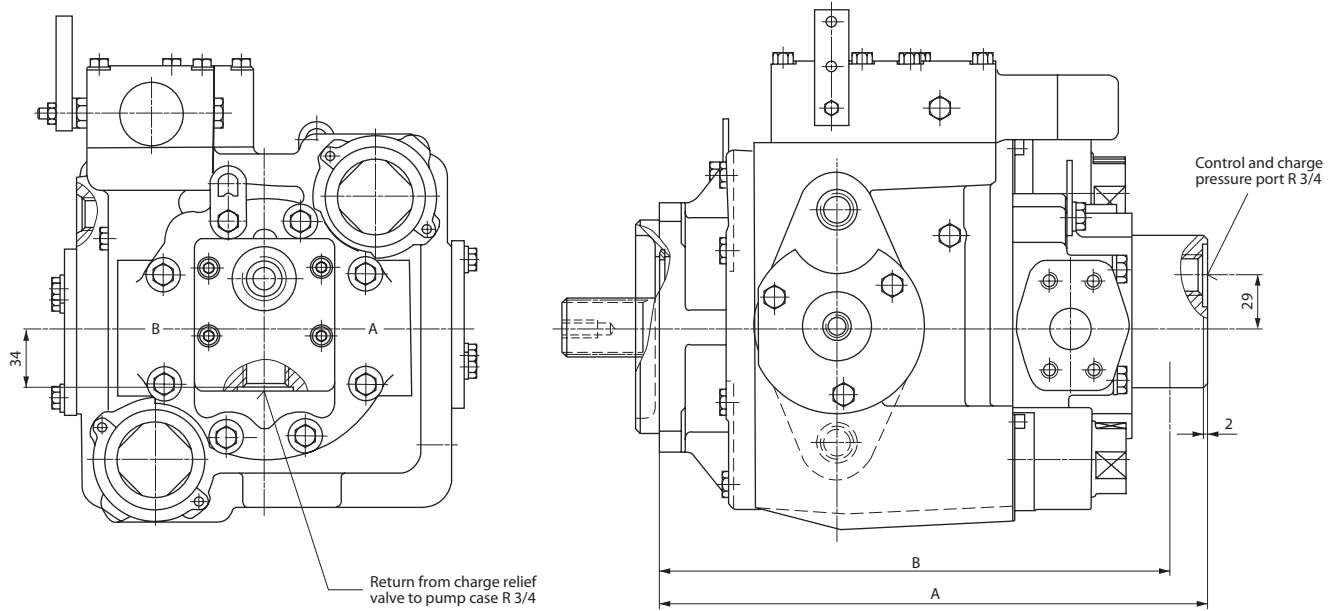
**Designation:**

- 1 = Variable Displacement pump
- 3 = Servo control valve
- 4 = Charge check valve
- 7 = Heat exchanger

**Ports:**

- A, B = Main pressure ports (working loop)
- L1, L2 = Drain ports
- M = Gauge port - charge pressure

**PUMP CONFIGURATION AA 010, DISPLACEMENT CONTROL VML 1 (continued)**

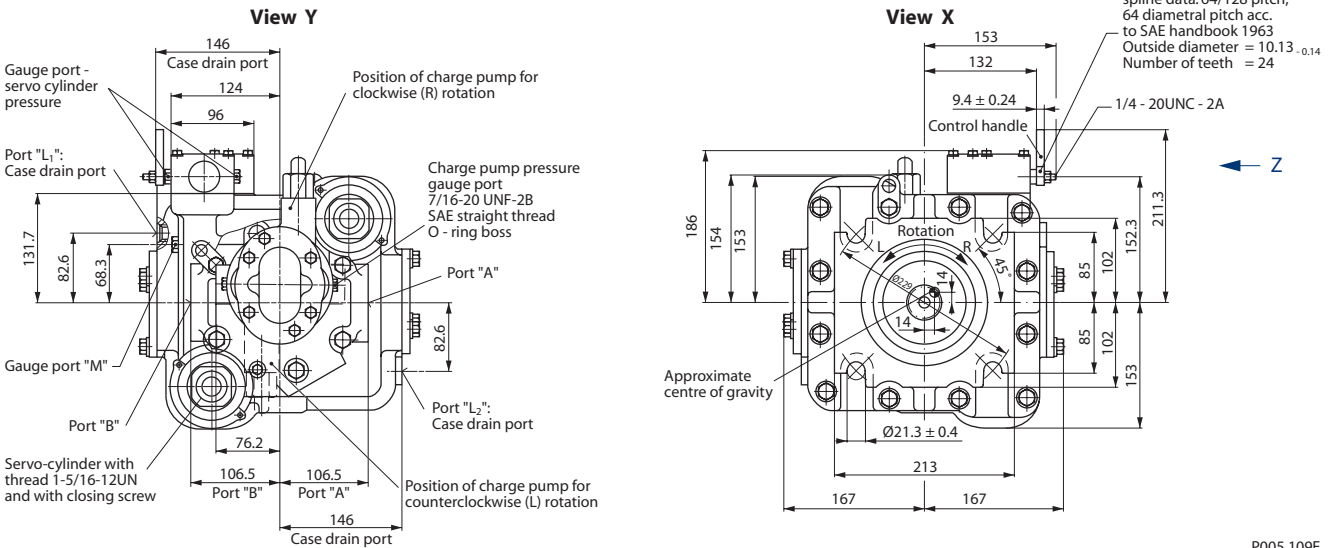
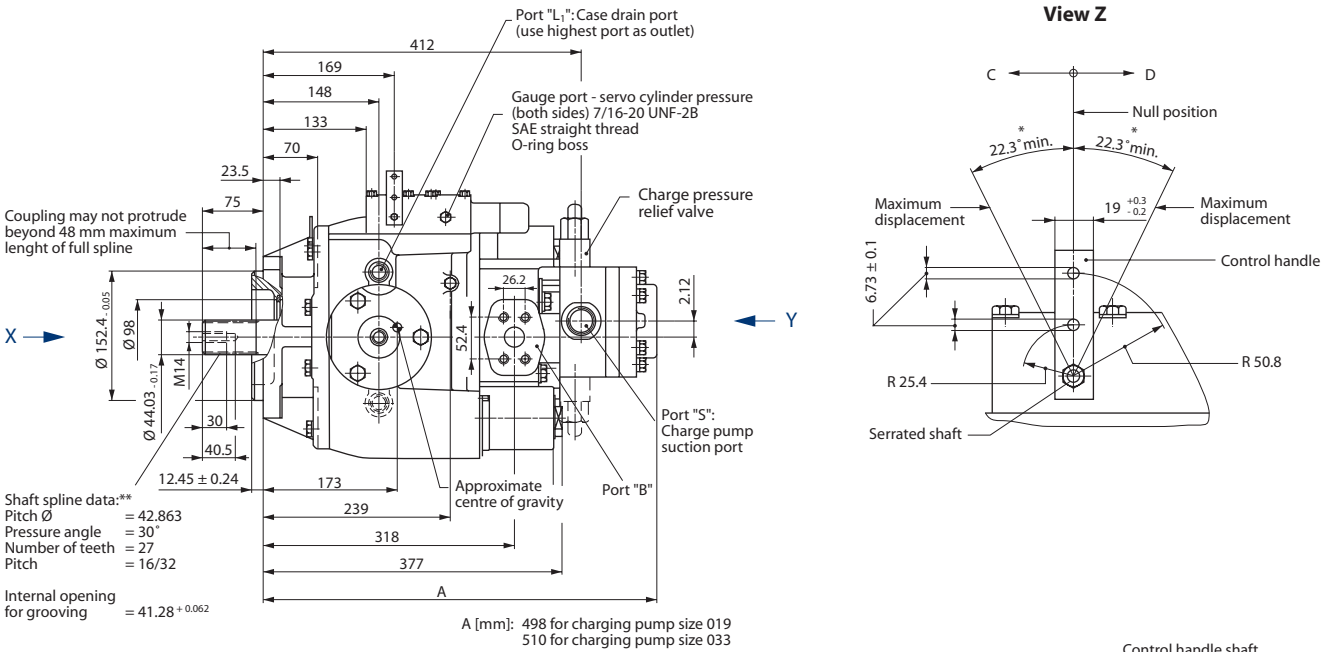


P000 009E

Dimensions			
Frame Size	A mm [in]	B mm [in]	Weight kg [lb]
033	308 [12.126]	285 [11.220]	46 [101]
052	324 [12.756]	301 [11.850]	56 [123]
070	339 [13.346]	316 [12.441]	63.5 [140]
089	352 [13.858]	329 [12.953]	78.5 [173]

**OUTLINE DRAWING, CONFIGURATION PS, DISPLACEMENT CONTROL VML 1**

- \* Minimum and maximum angle  $\alpha$ , (see section servo displacement control).
- \*\* Shaft spline data: spline shaft with involute spline, according to SAE handbook, 1963, class 1, fillet root side fit.

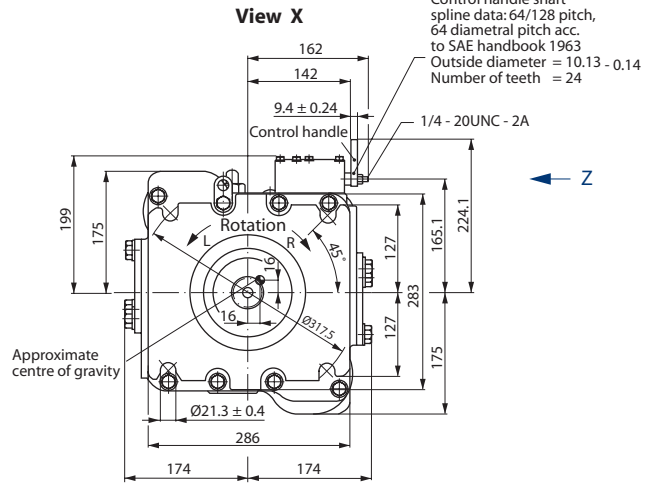
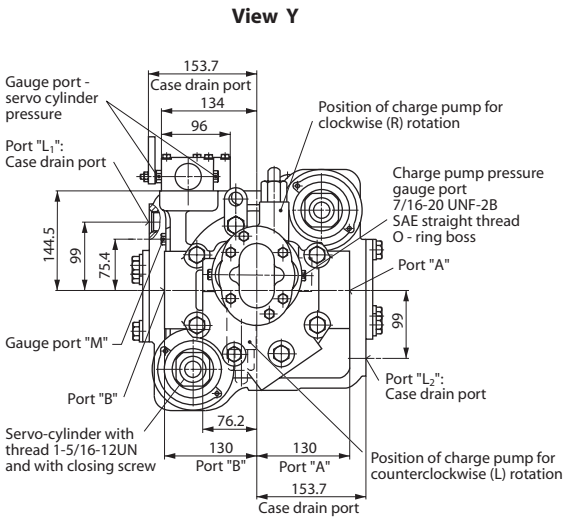
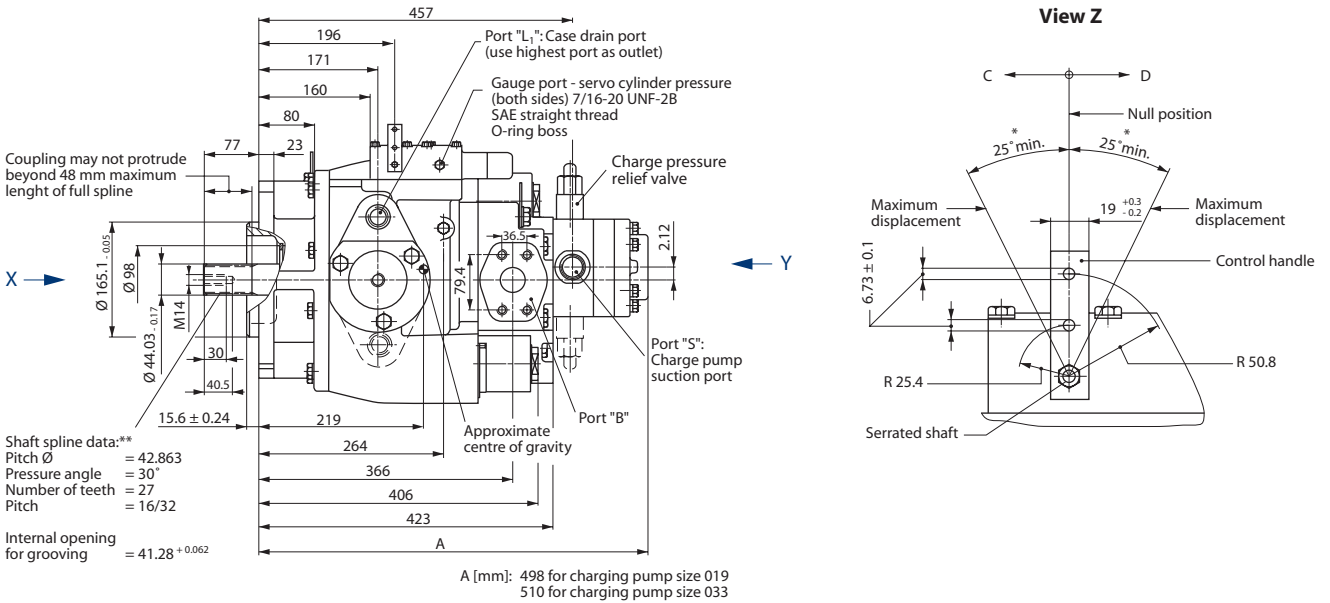


P005 109E

Frame size	Port A and B	Port L <sub>1</sub> and L <sub>2</sub>	Port S	Port M
119	SAE flange, size 1 SAE split flange boss 5000 psi 4 threads 3/8-16 UNC-2B 18 deep	7/8-14 UNF-2B SAE straight thread O-ring boss	1 5/16-12 UNF-2B SAE straight thread O-ring boss	7/16-20 UNF-2B SAE straight thread O-ring boss

**OUTLINE DRAWING, CONFIGURATION PS, DISPLACEMENT CONTROL VML 1**

- \* Minimum and maximum angle  $\alpha$ , (see section servo displacement control).
- \*\* Shaft spline data: spline shaft with involute spline, according to SAE handbook, 1963, class 1, fillet root side fit.



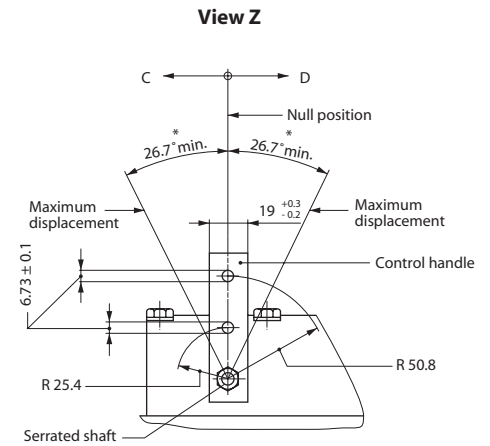
P005 110E

Frame size	Port A and B	Port L <sub>1</sub> and L <sub>2</sub>	Port S	Port M
166	SAE flange, size 1 1/2 SAE split flange boss 6000 psi 4 threads 5/8-11 UNC-2B 35 deep	1 5/16-12 UNF-2B SAE straight thread O-ring boss	1 5/16-12 UNF-2B SAE straight thread O-ring boss	7/16-20 UNF-2B SAE straight thread O-ring boss

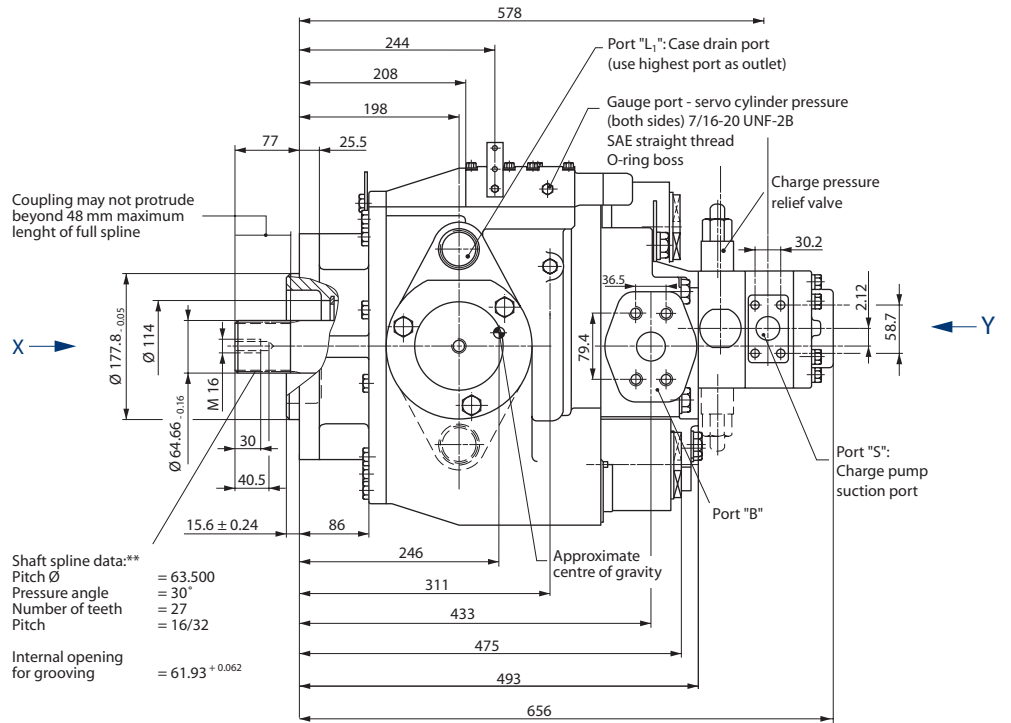


**PUMP CONFIGURATION  
 PS, DISPLACEMENT  
 CONTROL VML 1**

- \* Minimum and maximum angle  $\alpha$ , (see section servo displacement control).
- \*\* Shaft spline data: spline shaft with involute spline, according to SAE handbook, 1963, class 1, fillet root side fit.

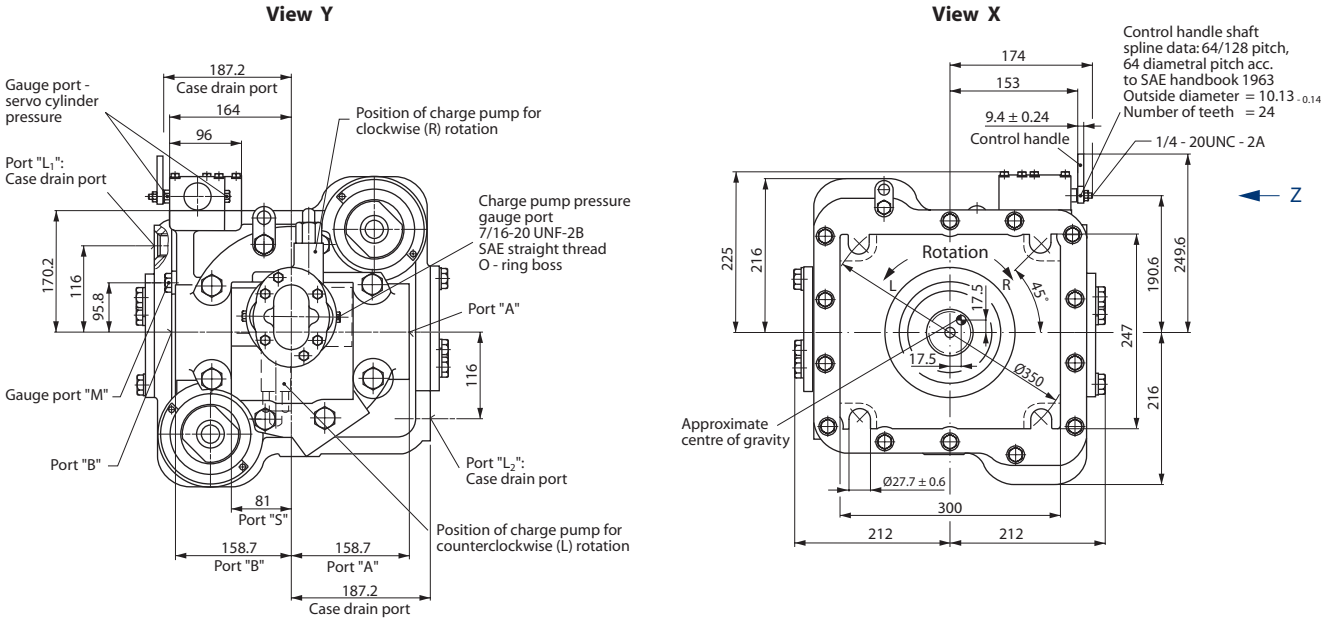


P000 026E



P005 115E

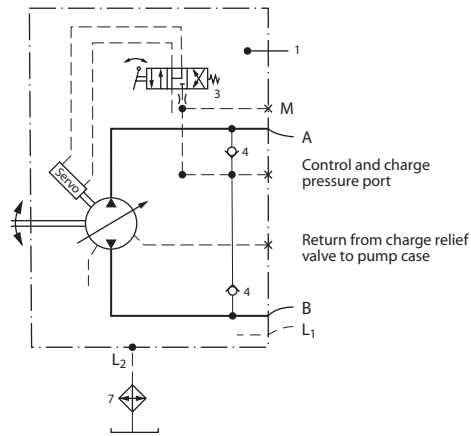
**PUMP CONFIGURATION PS, DISPLACEMENT CONTROL VML 1 (continued)**



P005 111E

Frame size	Port A and B	Port L <sub>1</sub> and L <sub>2</sub>	Port S	Port M
334	SAE flange, size 1 1/2 SAE split flange boss 6000 psi 4 threads 5/8-11 UNC-2B 35 deep	1 7/8-12 UNF-2B SAE straight thread O-ring boss	SAE flange, size 1 1/4 SAE split flange boss 3000 psi 4 threads 7/16-14 UNC-2B 28 deep	7/16-20 UNF-2B SAE straight thread O-ring boss

**PUMP CONFIGURATION  
 AA 010, DISPLACEMENT  
 CONTROL VML 1**



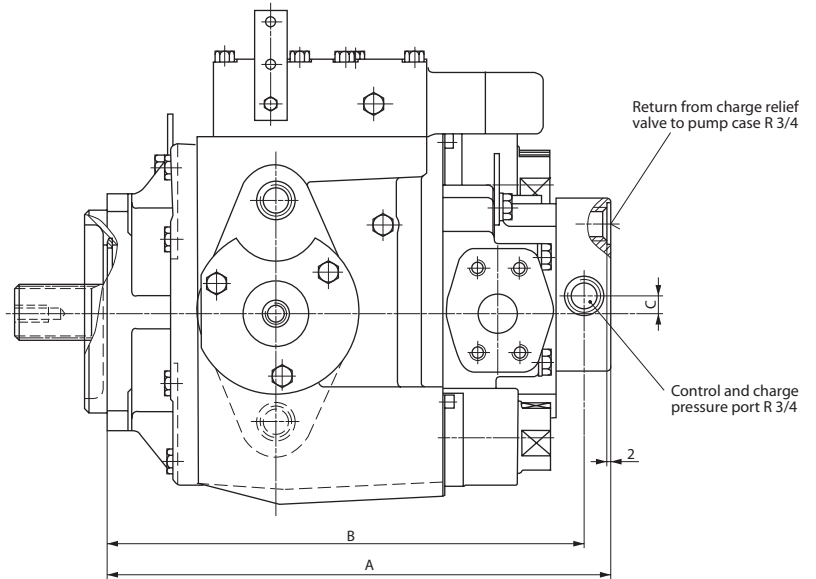
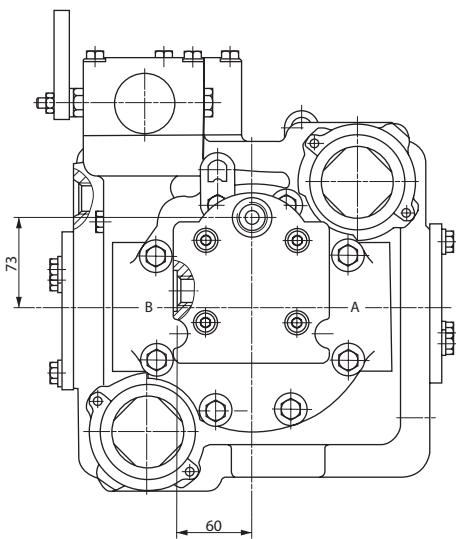
**Designation:**

- 1 = Variable Displacement pump
- 3 = Servo control valve
- 4 = Charge check valve
- 7 = Heat exchanger

**Ports:**

- A, B = Main pressure ports (working loop)
- S = Suction port - charge pump
- L1, L2 = Drain ports
- M = Gauge port - charge pressure

P000 058E



P000 010E

Dimensions				
Frame size	A mm [in]	B mm [in]	C mm [in]	Weight kg [lb]
119	422 [16.614]	401 [15.787]	14 [0.551]	128.5 [283]
166	476 [18.740]	450 [17.717]		160 [353]
227	504 [19.842]	478 [18.819]		208 [459]
334	546 [21.496]	520 [20.472]	21 [0.827]	264.5 [583]



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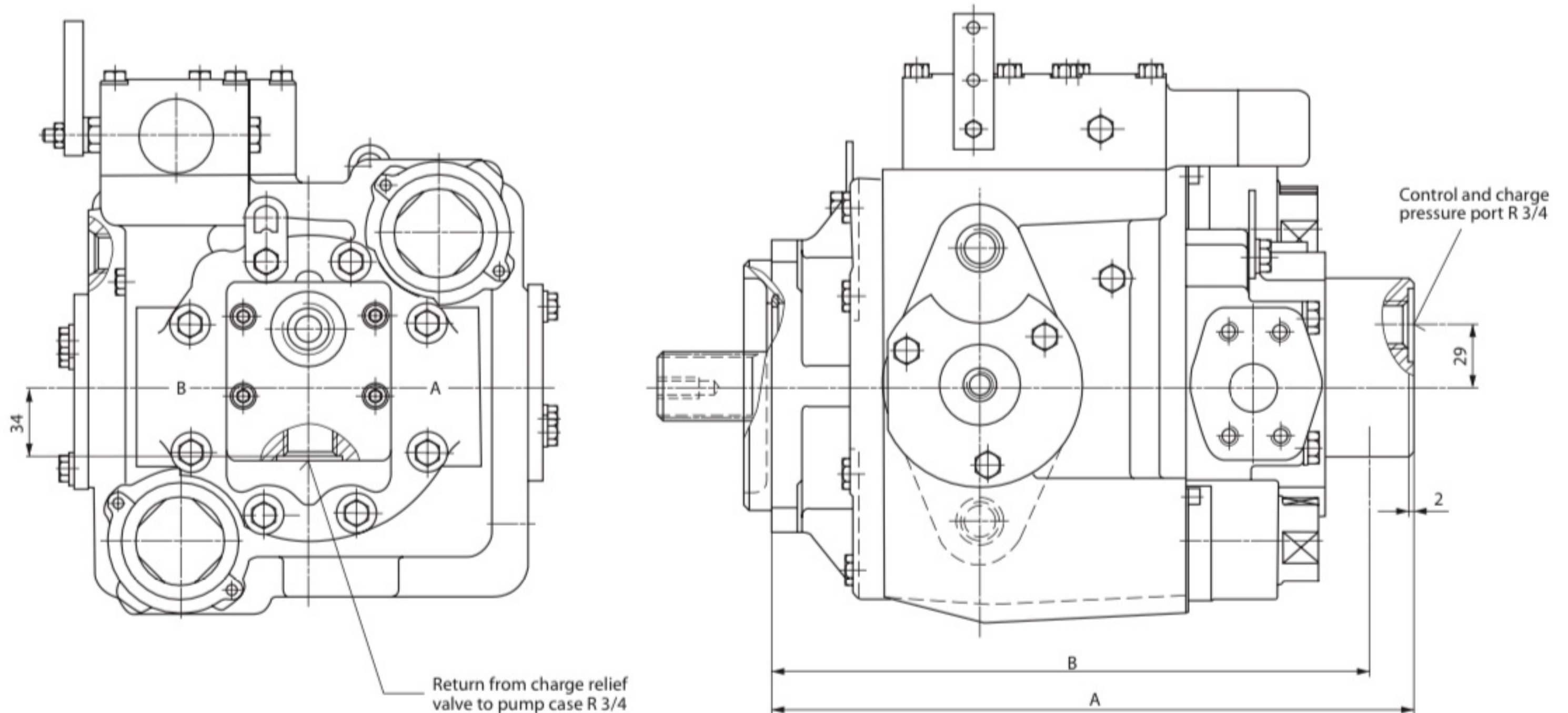
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**PUMP CONFIGURATION AA 010, DISPLACEMENT CONTROL VML 1 (continued)**



P000 009E

Dimensions			
Frame Size	A mm [in]	B mm [in]	Weight kg [lb]
033	308 [12.126]	285 [11.220]	46 [101]
052	324 [12.756]	301 [11.850]	56 [123]
070	339 [13.346]	316 [12.441]	63.5 [140]
089	352 [13.858]	329 [12.953]	78.5 [173]