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

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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Series 20 Axial Piston Pumps
Technical Information

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Axial Piston Variable Displacement Pump

Series 20 Axial Piston Pumps
Technical Information
General Description

Sectional View

- Swash plate
- Control handle
- Servo valve (control valve)
- Charge pump
- Charge check valve
- Input shaft
- Shaft seal
- Cylinder block assembly
- Servo cylinder
- Design 1
- Design 2
Above figure shows schematically the function of a hydrostatic transmission using an axial piston variable displacement pump and a fixed displacement motor.

**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
**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**

![Graph showing external drain fluid loss vs. driveshaft speed](image)
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$^1$ [6672 psi]

$^1$only with POR-valve

**Case pressure**
Max. rated pressure $= 2.5$ bar [36.3 psi]
Intermittent $= 5.0$ bar [72.5 psi]

**Hydraulic fluids**
Refer to Sauer-Danfoss publications *Hydraulic Fluids and Lubricants*, 520L0463 and *Experience with Biodegradable Hydraulic Fluids*, 520L0465.

**Temperature range**
$\vartheta_{\text{min}} = -40 ^\circ \text{C} [-40 ^\circ \text{F}]$
$\vartheta_{\text{max}} = 95 ^\circ \text{C} [203 ^\circ \text{F}]$

**Viscosity range**
$\nu_{\text{min}} = 7$ mm$^2$/s [49 SUS$^*$]
$\nu_{\text{max}} = 1000$ mm$^2$/s [4630 SUS$^*$] (intermittent cold start)
Recommended viscosity range: 12 - 60 mm$^2$/s [66 - 280 SUS$^*$]

$^*$SUS (Saybolt Universal Second)

**Filtration**

**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

Technical Data

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Units</th>
<th>070</th>
<th>089</th>
<th>334</th>
</tr>
</thead>
<tbody>
<tr>
<td>Max. displacement</td>
<td>cm³</td>
<td>69.8</td>
<td>89.0</td>
<td>333.7</td>
</tr>
<tr>
<td></td>
<td>[in³]</td>
<td>[4.26]</td>
<td>[5.43]</td>
<td>[20.36]</td>
</tr>
<tr>
<td>Charge pump displacement options</td>
<td>cm³</td>
<td>18.03</td>
<td>65.50</td>
<td></td>
</tr>
<tr>
<td></td>
<td>[in³]</td>
<td>[1.10]</td>
<td>[4.00]</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td>12.30</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td>[0.75]</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Minimum speed</td>
<td>min⁻¹ (rpm)</td>
<td>500</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Rated speed 1</td>
<td>min⁻¹ (rpm)</td>
<td>3200</td>
<td>2900</td>
<td>1900</td>
</tr>
<tr>
<td>Maximum swash plate angle</td>
<td>degree</td>
<td>±18</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Mass moment of inertia of rotating group (without charge pump)</td>
<td>kg m² · 10⁻³</td>
<td>12.34</td>
<td>17.77</td>
<td>161.40</td>
</tr>
<tr>
<td></td>
<td>[lbf ft² · 10⁻³]</td>
<td>[292.8]</td>
<td>[421.7]</td>
<td>[3830.0]</td>
</tr>
<tr>
<td>Weight</td>
<td>kg</td>
<td>63</td>
<td>78</td>
<td>270</td>
</tr>
<tr>
<td></td>
<td>[lb]</td>
<td>[139]</td>
<td>[172]</td>
<td>[595]</td>
</tr>
</tbody>
</table>

1 for higher speeds contact your Sauer–Danfoss representative.

Determination of Nominal Pump Sizes

Use these formulae to determine the nominal pump size for a specific application:

**Based on SI units**

**Output flow:**

\[ Q = \frac{V_g \cdot n \cdot \eta_v}{1000} \text{ l/min} \]

**Input torque:**

\[ M = \frac{V_g \cdot \Delta p}{20 \cdot \pi \cdot \eta_m} \text{ N\cdot m} \]

**Input power:**

\[ P = \frac{M \cdot n}{9550} = \frac{Q \cdot \Delta p}{600 \cdot \eta_t} \text{ kW} \]

**Based on US units**

**Output flow:**

\[ Q = \frac{V_g \cdot n \cdot \eta_v}{231} \text{ [US gal/min]} \]

**Input torque:**

\[ M = \frac{V_g \cdot \Delta p}{2 \cdot 1714 \cdot \eta_m} \text{ [lbf\cdot in]} \]

**Input power:**

\[ P = \frac{M \cdot n}{63.025} = \frac{Q \cdot \Delta p}{1714 \cdot \eta_t} \text{ [hp]} \]

**Variables:**

<table>
<thead>
<tr>
<th>SI units</th>
<th>[US units]</th>
</tr>
</thead>
<tbody>
<tr>
<td>( V_g ) = Displacement per rev.</td>
<td>cm³/rev [in³/rev]</td>
</tr>
<tr>
<td>( p_{HD} ) = Outlet pressure</td>
<td>bar [psi]</td>
</tr>
<tr>
<td>( p_{ND} ) = Inlet pressure</td>
<td>bar [psi]</td>
</tr>
<tr>
<td>( \Delta p ) = ( p_{HD} - p_{ND} )</td>
<td>bar [psi]</td>
</tr>
<tr>
<td>( n ) = Speed</td>
<td>min⁻¹ (rpm)</td>
</tr>
<tr>
<td>( \eta_v ) = Volumetric efficiency</td>
<td></td>
</tr>
<tr>
<td>( \eta_m ) = Mechanical (torque) efficiency</td>
<td></td>
</tr>
<tr>
<td>( \eta_t ) = Overall efficiency (( \eta_v \cdot \eta_m ))</td>
<td></td>
</tr>
</tbody>
</table>
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-relation 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 besides).

<table>
<thead>
<tr>
<th>Pump rotation</th>
<th>Movement of control handle in direction</th>
<th>Pressure port OUT</th>
<th>Pressure port IN</th>
</tr>
</thead>
<tbody>
<tr>
<td>CCW (Left)</td>
<td>C</td>
<td>B</td>
<td>A</td>
</tr>
<tr>
<td></td>
<td>D</td>
<td>A</td>
<td>B</td>
</tr>
<tr>
<td>CW (Right)</td>
<td>C</td>
<td>A</td>
<td>B</td>
</tr>
<tr>
<td></td>
<td>D</td>
<td>B</td>
<td>A</td>
</tr>
</tbody>
</table>

Pump flow direction changes with the direction of rotation and the control handle movement (see besides).
Series 20 Axial Piston Pumps
Technical Information

**Reversing time**
Time for the directional change of the flow from \( Q_{\text{max}} \), across zero to \( Q_{\text{max}} \), 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: \( \Delta p_0 = 210 \text{ bar} \) [3046 psi]
- Speed: \( n = 1450 \text{ min}^{-1} \) (rpm)
- System temperature: 50 °C [122 °F]
- Viscosity: 35 mm²/s [164 SUS]

<table>
<thead>
<tr>
<th>Frame size</th>
<th>Minimum reversing time (s) without orifice</th>
<th>Maximum reversing time (s) with orifice Ø 0.66 in supply port</th>
</tr>
</thead>
<tbody>
<tr>
<td>070</td>
<td>1.0</td>
<td>9.3</td>
</tr>
<tr>
<td>089</td>
<td>1.1</td>
<td>9.0</td>
</tr>
<tr>
<td>334</td>
<td>5.6</td>
<td>43.8</td>
</tr>
</tbody>
</table>

_Schematic diagram of servo valve with alternative orifice positions_
**Series 20 Axial Piston Pumps**

**Technical Information**

**Technical Specification**

**Servo Displacement Control (linear response) (continued)**

**Reset time**

Time for reducing the flow from either flow direction from $Q_{\text{max}}$ 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: $\Delta p_2 = 210$ bar [3046 psi]
- System temperature: 50 °C [122 ° F]
- Viscosity: 35 mm²/s [164 SUS]

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

![Diagram of pilot ports and orifice insert]

<table>
<thead>
<tr>
<th>Frame size</th>
<th>Minimum reset time (s)</th>
</tr>
</thead>
<tbody>
<tr>
<td>070</td>
<td>3.0</td>
</tr>
<tr>
<td>089</td>
<td>3.34</td>
</tr>
<tr>
<td>334</td>
<td>5.4</td>
</tr>
</tbody>
</table>

**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.
Configuration PS, displacement control VML 1

Coupling may not protrude beyond 48 mm maximum length of full spline

Shaft spline data:**
Pitch Ø = P
Pressure angle = 30°
Number of teeth = R
Pitch = S

Approximate centre of gravity

Dimensions - mm [in]

<table>
<thead>
<tr>
<th>Frame size</th>
<th>B</th>
<th>C</th>
<th>D</th>
<th>E</th>
<th>F</th>
<th>G</th>
<th>H</th>
<th>J</th>
<th>K</th>
<th>L</th>
<th>M</th>
<th>Ø N</th>
</tr>
</thead>
<tbody>
<tr>
<td>070</td>
<td>315</td>
<td>294</td>
<td>305</td>
<td>259</td>
<td>188</td>
<td>146</td>
<td>112</td>
<td>120</td>
<td>84</td>
<td>48</td>
<td>16</td>
<td>84</td>
</tr>
<tr>
<td>089</td>
<td>328</td>
<td>307</td>
<td>312</td>
<td>271</td>
<td>195</td>
<td>140</td>
<td>118</td>
<td>129</td>
<td>91</td>
<td>49</td>
<td>17.5</td>
<td>98</td>
</tr>
</tbody>
</table>

*Minimum and maximum angle α, (see section Servo displacement control).

**Shaft spline data: spline shaft with involute spline, according to SAE handbook, 1963, class 1, fillet root side fit.

Dimensions - mm [in]

<table>
<thead>
<tr>
<th>Frame size</th>
<th>T</th>
<th>U</th>
<th>V</th>
<th>W</th>
<th>X</th>
<th>Y</th>
<th>Z</th>
</tr>
</thead>
<tbody>
<tr>
<td>070</td>
<td>71.4</td>
<td>112.7</td>
<td>105</td>
<td>108</td>
<td>60.5</td>
<td>85.8</td>
<td>9.5</td>
</tr>
<tr>
<td>089</td>
<td>77.7</td>
<td>128.7</td>
<td>115</td>
<td>119</td>
<td>65</td>
<td>95.2</td>
<td>12.7</td>
</tr>
</tbody>
</table>

1 Short version available on request. Please contact your local Sauer-Danfoss representative.
Configuration PS, displacement control VML 1 (continued)

View X (for SPV 2/070 only)

Control handle shaft spline data: 64/128 pitch, 64 diametral pitch acc. to SAE handbook 1963
Outside diameter = 10.13 ± 0.14
Number of teeth = 24

View X (for SPV 2/089 only)

Control handle shaft spline data: 64/128 pitch, 64 diametral pitch acc. to SAE handbook 1963
Outside diameter = 10.13 ± 0.14
Number of teeth = 24

### Frame size

<table>
<thead>
<tr>
<th></th>
<th>AA</th>
<th>BB</th>
<th>CC</th>
<th>DD</th>
<th>EE</th>
<th>FF</th>
<th>GG</th>
<th>HH</th>
<th>JJ</th>
</tr>
</thead>
</table>

View Y

Gauge port - servo cylinder pressure
Port "L": Case drain port
Port "S": Suction port (charge pump)
Port "L3": Case drain port

View Z

Port "L2": Case drain port
Port "B": Gauge port "M"
Port "A":
Position of charge pump for clockwise (R) rotation
Position of charge pump for counterclockwise (L) rotation
Gauge port - servo cylinder pressure
Port "L": Case drain port
Serrated shaft
Maximum displacement
Control handle
C
D
Null position
Series 20 Axial Piston Pumps
Technical Information
Dimensions – Frame Size 070 and 089 cm³

Configuration AA 010, displacement control VML 1

Dimensions - mm [in]

<table>
<thead>
<tr>
<th>Frame Size</th>
<th>A</th>
<th>B</th>
<th>Weight kg [lb]</th>
</tr>
</thead>
</table>

Circuit schematic

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
Configuration PS, displacement control
VML 1

Coupling may not protrude beyond 48 mm maximum length of full spline

Charge pressure relief valve
Port "B": Charge pump suction port
Port "L1": Case drain port (use highest port as outlet)

Shaft spline data:
- Pitch Ø = 63.500
- Pressure angle = 30°
- Number of teeth = 27
- Pitch = 16/32
- Internal opening for grooving = 61.93 + 0.062

Approximate centre of gravity

* Minimum and maximum angle α, (see section servo displacement control).

** Shaft spline data: spline shaft with involute spline, according to SAE handbook, 1963, class 1, fillet root side fit.
Configuration PS, displacement control VML 1 (continued)

**View Y**
- Charge pump pressure gauge port
- 7/16-20 UNF-2B
- SAE straight thread
- O-ring boss

**View X**
- Control handle shaft
- Spline data: 64/128 pitch, 64 diametral pitch acc.
- to SAE handbook 1963
- Outside diameter = 10.13 ± 0.14
- Number of teeth = 24

**View Z**
- Approximate center of gravity

**Dimensions – Frame Size 334 cm³**

**Port A and B:** SAE flange, size 1 1/2 SAE split flange boss, 6000 psi, 4 threads, 5/8-11 UNC-2B, 35 deep
**Port L1, L2:** 1 7/8-12 UNF-2B, SAE straight thread, O-ring boss
**Port S:** SAE flange, 1 1/4 SAE split flange boss, 3000 psi, 4 threads, 7/16-14 UNC-2B, 28 deep
**Port M:** 7/16-20 UNF-2B, SAE straight thread, O-ring boss
Configuration AA 010, displacement control VML 1

Series 20 Axial Piston Pumps
Technical Information
Dimensions – Frame Size 334 cm³

Dimensions - mm [in]

<table>
<thead>
<tr>
<th>Frame size</th>
<th>A</th>
<th>B</th>
<th>C</th>
<th>Weight [kg]</th>
<th>Weight [lb]</th>
</tr>
</thead>
<tbody>
<tr>
<td>334</td>
<td>546 [21.496]</td>
<td>520 [20.472]</td>
<td>21 [0.827]</td>
<td>264.5</td>
<td>583</td>
</tr>
</tbody>
</table>

Circuit schematic

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
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