



# BOSCH

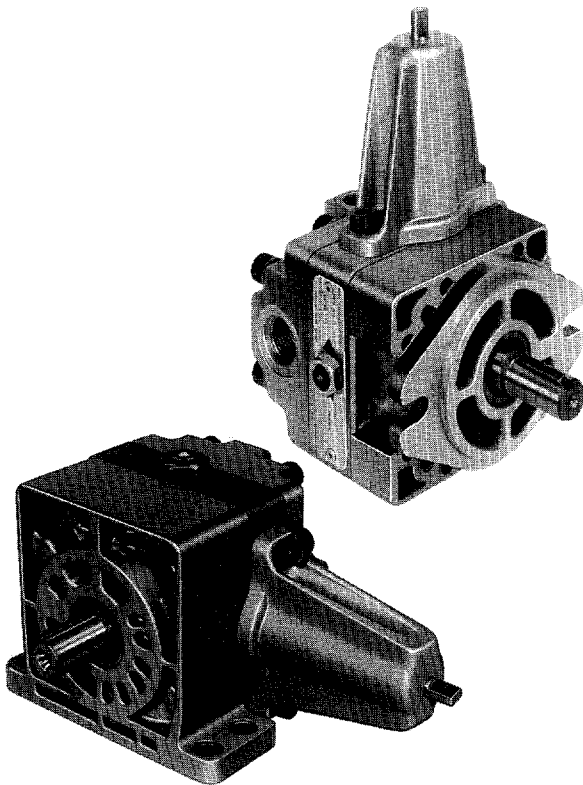
## REPAIR PARTS

### VARIABLE VOLUME VANE PUMP SPRING GOVERNED

#### MODEL PSQ

500 PSI  
1000 PSI  
1500 PSI  
7.5 GPM  
& 9.5 GPM

SUBPLATE AND FLANGE MOUNTED

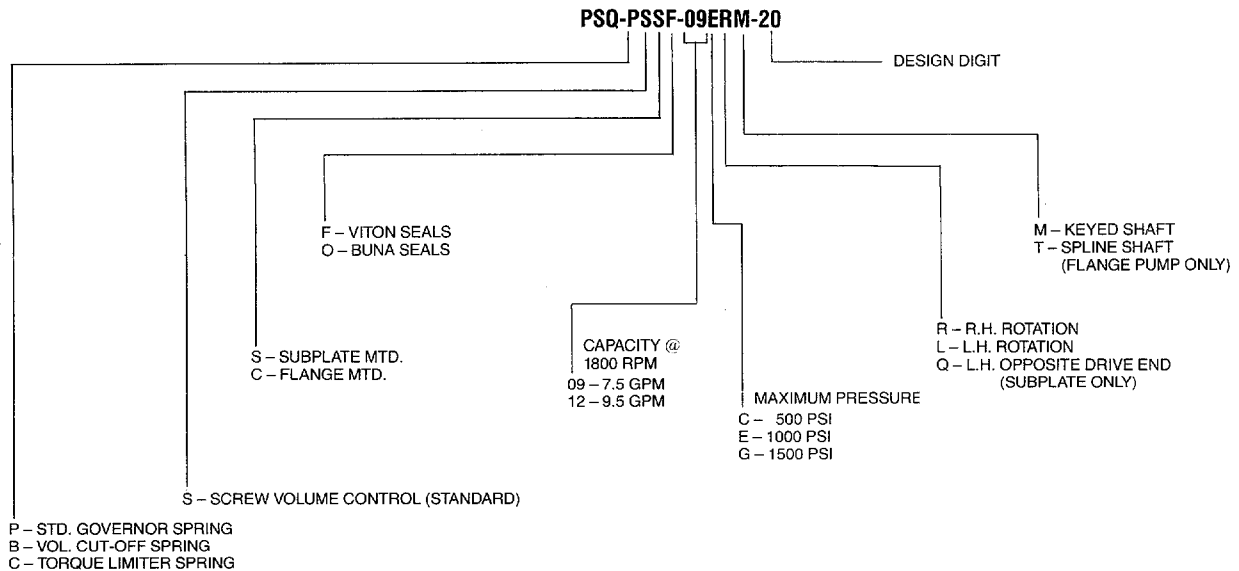


WHEN ORDERING PARTS, FURNISH:

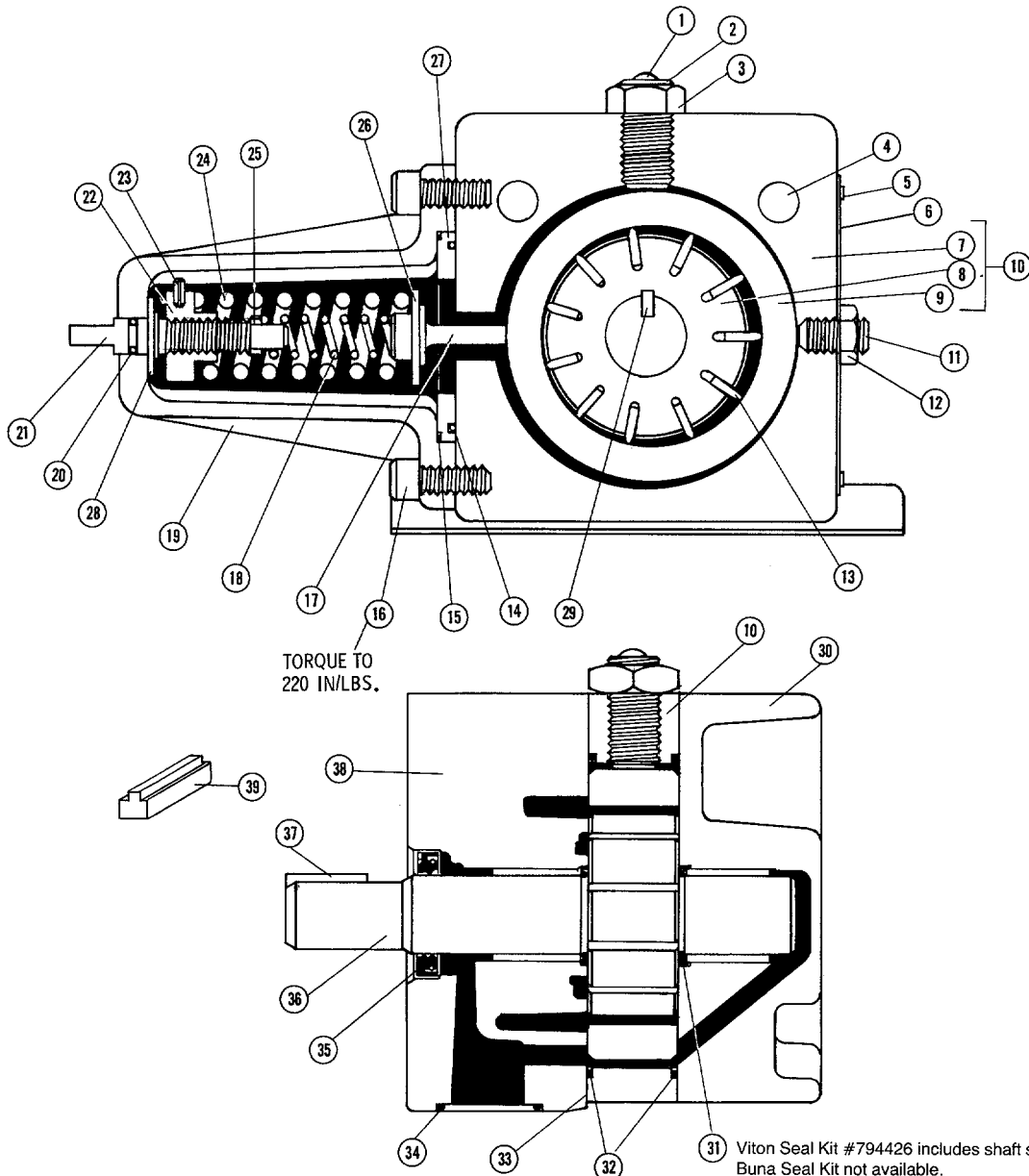
1. COMPLETE CODE NUMBER
2. PARTS REQUIRED
3. SHIPPING INSTRUCTIONS

WRITE FACTORY FOR NEAREST AUTHORIZED PARTS AND SERVICE CENTER.

## PUMP CODING



**SUBPLATE MOUNTED**



TORQUE TO  
220 IN/LBS.

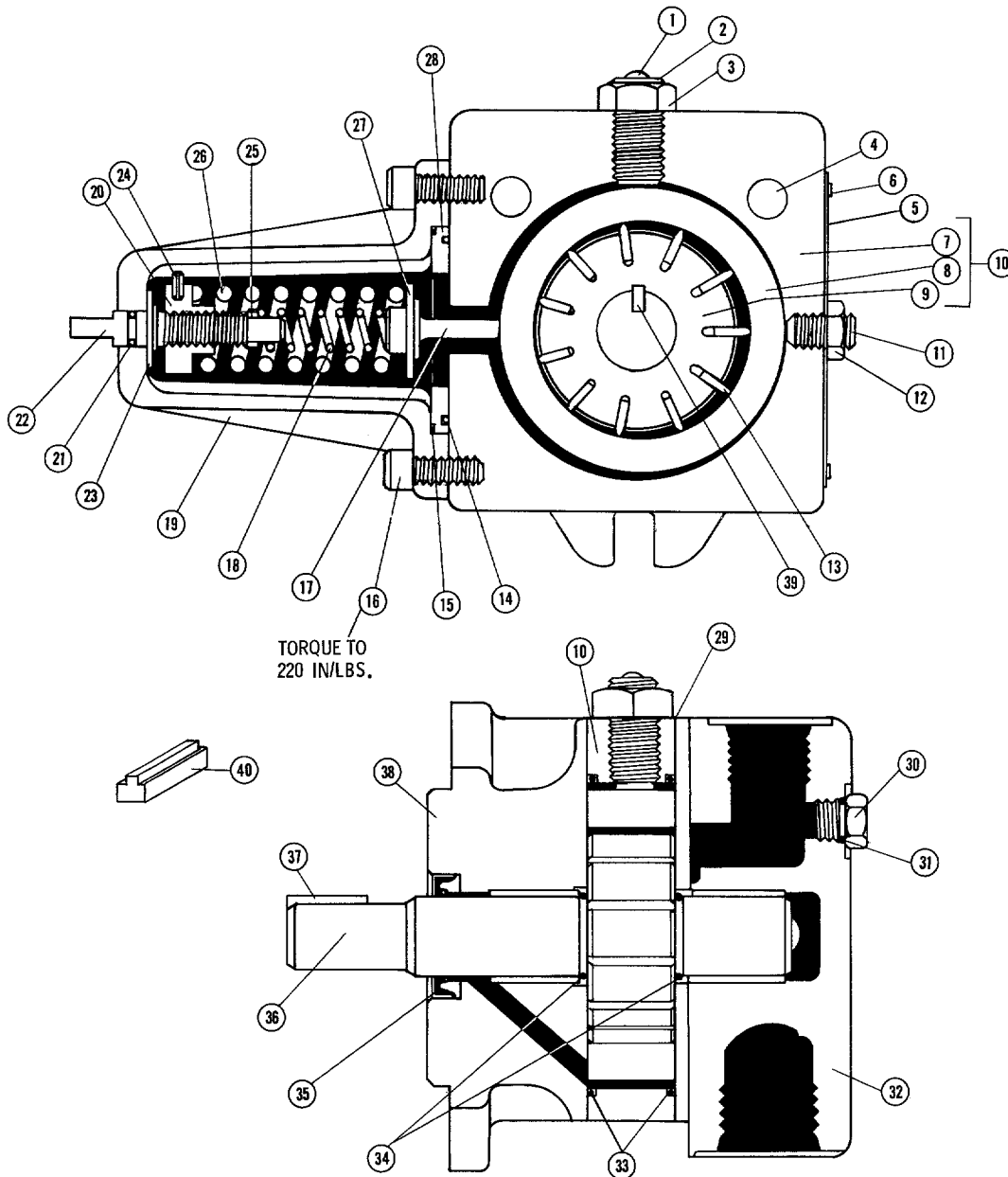
Viton Seal Kit #794426 includes shaft seal which is also part of body assembly.  
Buna Seal Kit not available.

Ref. No.	Part No.	Description	Qty.
1	492440	Delrin Ball	1
2	309178	Thrust Screw	1
3	492439	Lock Nut	1
4	491842	Dowel Pin	2
5	491865	Rivet	2
6	492637	Nameplate	1
7	See	Center Body	1
8	Item	Rotor	1
9	#10	Pressure Ring	1
10	778544	Matched Rotating Group – 7.5 GPM	1
10	778545	Matched Rotating Group – 9.5 GPM	1
11	491845	Volume Control Screw	1
12	401011	Lock Nut	1
13	778277	Vane Set	1
14	407105	O-Ring, 1/16 × 1-1/2 × 1-5/8	1
15	406712	O-Ring, 3/32 × 1-11/16 × 1-7/8	1
16	400798	Screw, 5/16-18 × 3/4	2
17	309177	Steel Spring Seat	1
18	408706	Spring	1
19	222823	Governor Housing	1
20	406270	O-Ring, 1/16 × 1/4 × 3/8	1
21	309038	Adjusting Screw	1
22	309039	Adjustable Spring Seat	1

Ref. No.	Part No.	Description	Qty.
23	402265	Roll Pin	1
24	492469	Spring, Std. Governor	1
24	492500	Spring, 'B' Governor	1
24	492471	Spring, 'C' Governor	1
25	404864	Roll Pin	1
26	491872	Washer	1
27	222824	Seal Plate	1
28	492468	Thrust Washer	1
29	492155	Woodruff Key	1
30	725530	End Body Assembly (R.H. Rotation)	1
30	725549	End Body Assembly (L.H. Opposite Drive)	1
31	492150	Retaining Ring	2
32	492011	O-Ring, .070 × 3.30 × 3.44	2
33	491902	Shim (.0015)	1
34	725544*	Seal Kit (Viton)	1
35	493205	Shaft Seal (Viton)	1
35	492299	Expansion Plug (Opposite Drive)	1
36	309204	Keyed Shaft	1
37	403258	Key	1
38	725551	Front Body Assembly (Viton) (R.H. Rotation)	1
38	725537	Front Body Assembly (L.H. Opposite Drive)	1
39	492163	Key (Retrofit PSQ to PVQ)	1

\*Contains (3) 406555 O-ring 3/32 x 13/16 x 1 and Installation Page.

# FLANGE MOUNTED

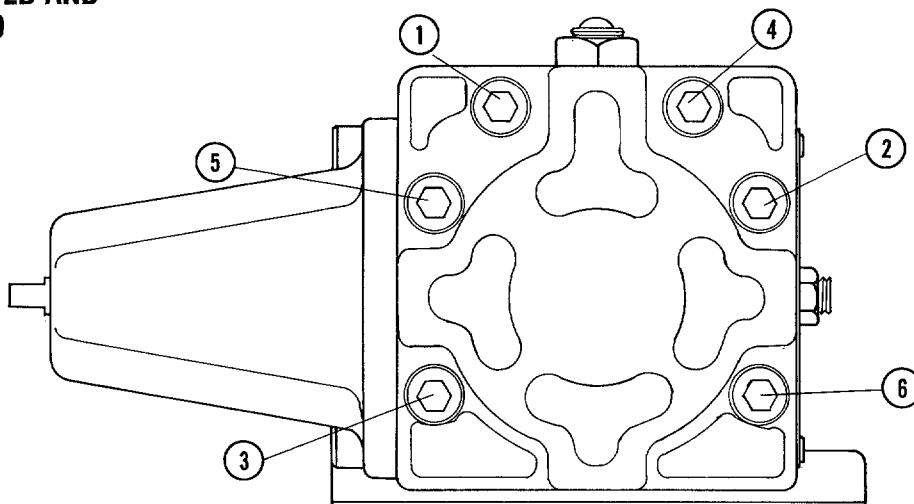


Viton Seal Kit #794426 includes shaft seal which is also part of body assembly.  
Buna Seal Kit not available.

Ref. No.	Part No.	Description	Qty.	Ref. No.	Part No.	Description	Qty.
1	492440	Delrin Ball	1	23	492468	Thrust Washer	1
2	309178	Thrust Screw	1	24	402265	Roll Pin	1
3	492439	Lock Nut	1	25	404864	Roll Pin	1
4	491842	Dowel Pin	2	26	492469	Spring, Standard Governor	1
5	492637	Nameplate	1	26	492500	Spring, 'B' Governor	1
6	491865	Rivet	2	26	492471	Spring, 'C' Governor	1
7	See	Center Body	1	27	491872	Washer	1
8	Item	Pressure Ring	1	28	222824	Seal Plate	1
9	#10	Rotor	1	29	492204	Shim (.0020)	1
10	778544	Matched Rotating Group - 7.5 GPM	1	30	355098	Plug, #4 SAE	1
10	778545	Matched Rotating Group - 9.5 GPM	1	31	406879	O-Ring, #4 SAE (-904)	1
11	491845	Volume Control Screw	1	32	725534	End Body Assembly (R.H. Rotation)	1
12	401011	Lock Nut	1	32	725535	End Body Assembly (L.H. Rotation)	1
13	778277	Vane Set	1	33	492011	O-Ring, .070 x 3.30 x 3.44	2
14	407105	O-Ring, 1/16 x 1-1/2 x 1-5/8	1	34	492150	Retaining Ring	2
15	406712	O-Ring, 3/32 x 1-11/16 x 1-7/8	1	35	493205	Shaft Seal (Viton)	1
16	400798	Screw, 5/16-18 x 3/4	2	36	309204	Keyed Shaft	1
17	309177	Steel Spring Seat	1	36	309205	Splined Shaft	1
18	408706	Spring	1	37	403258	Key	1
19	222823	Governor Housing	1	38	725548	Front Body Assembly (Viton)	1
20	309039	Adjustable Spring Seat	1	39	492155	Woodruff Key	1
21	406270	O-Ring, 1/16 x 1/4 x 3/8	1	40	492163	Key (Retrofit PSQ to PVQ)	1
22	309038	Adjusting Screw	1	-	355097	Plug, #6 SAE (Not Shown)	1
				-	406600	O-Ring, #6 SAE (-906) (Not Shown)	1

# TORQUE SEQUENCE

## SUBPLATE MOUNTED AND FLANGE MOUNTED



**Notes:** Bolt torquing must be done in sequence below to avoid damaging covers.

- (1) Torque sequence for Cap Screws:
  - (A) Torque 6 screws on rear cover to 50-100 in.-lbs. in numerical order as shown.
  - (B) Torque 6 screws on rear cover to  $360 \pm 40$  in.-lbs. in numerical order as shown.
- (2) Prior to assembly, coat both faces of rotor with lubricant 492273 ( STP )
- (3) 492440 ball is to be peened into socket after test, and thrust screw setting rechecked.

### SUBPLATE MOUNTED

Ref. No.	Part No.	Description	Qty.
1,4	400814	Cap Screws	2
2,3,5,6	400807	Cap Screws	4

### FLANGE MOUNTED

Ref. No.	Part No.	Description	Qty.
1,4	400816	Cap Screws	2
2,3,5,6	400815	Cap Screws	4

9 535 233 265  
HPUS RSB 003/6 US (1.96)

