

Bosch Rexroth A A10VSO 71 DFR1/31R-VPA42N00 *GOEU axial piston pump

Manufacturer: Bosch Rexroth

Manufacturer part number / published order designation: R902566696

Published model: A A10VSO 71 DFR1/31R-VPA42N00 *GOEU

About this compilation

Prepared by Hydmaster from selected manufacturer documentation. Original technical pages follow without cropped drawings, rewritten data or altered units. This cover and index are Hydmaster editorial material, not a manufacturer-issued exact-execution datasheet.

Coverage: selected pages relevant to the identified size and configuration. Other options or neighbouring models retained on an original page apply only where explicitly identified.

Execution notes and conditions

No universal maximum speed assigned; inlet pressure, displacement and temperature dependence remain on retained source pages.

No optional through drive, counterbalance valve, sensor or pressure-relief execution asserted unless card explicitly specifies it.

Source-page index

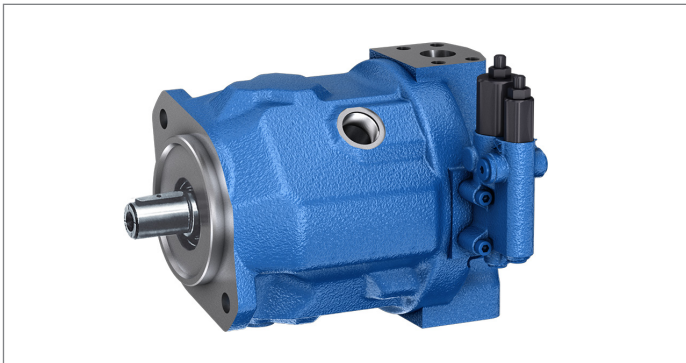
Source page numbers below are physical pages of each complete original PDF. The original printed page labels and technical content remain unchanged. Compiled page numbers count this cover/index.

Source A: Rexroth A10Vso Series 31 Technical Data

Original pages	Compiled pages	Relevant content
1-7	2-8	Standard family characteristics, fluids, pressure/speed limits with conditions, installation and safety; other executions not asserted
9-10	9-10	Standard family characteristics, fluids, pressure/speed limits with conditions, installation and safety; other executions not asserted
13-14	11-12	DFR1 control function and characteristics
28-30	13-15	Size71 standard clockwise ISO keyed shaft/metric flange geometry and actual controller
43-48	16-21	Standard family characteristics, fluids, pressure/speed limits with conditions, installation and safety; other executions not asserted

Axial piston variable pump

A10VSO series 31



- ▶ For **size 140**, please refer to data sheet 92714
- ▶ All-purpose medium pressure pump
- ▶ Sizes 18 to 100
- ▶ Nominal pressure 280 bar
- ▶ Maximum pressure 350 bar
- ▶ Open circuit

Features

- ▶ Variable pump with axial piston rotary group in swashplate design for hydrostatic drives in open circuit.
- ▶ Flow is proportional to drive speed and displacement.
- ▶ The flow can be infinitely varied by adjusting the swashplate angle.
- ▶ 2 drain ports
- ▶ Excellent suction characteristics
- ▶ Low noise level
- ▶ Long service life
- ▶ Good power to weight ratio
- ▶ Versatile controller range
- ▶ Short control time
- ▶ The through drive is suitable for adding gear pumps and axial piston pumps up to the same size, i.e., 100% through drive.
- ▶ Suitable for operation with mineral oil and HF hydraulic fluids

Inhalt

Type code	2
Hydraulic fluids	4
Working pressure range	6
Technical data, standard unit	7
Technical data, high-speed version	8
Technical data, HF hydraulic fluids	8
DG – Two-point control, direct operated	10
DR – Pressure controller	11
DRG – Pressure controller, remotely controlled	12
DFR/DFR1 – Pressure flow controller	13
DFLR – Pressure, flow and power controller	15
ED – Electrohydraulic pressure control	16
ER – Electrohydraulic pressure control	18
Dimensions, size 18 to 100	19
Dimensions of through drive	34
Overview of mounting options	40
Combination pumps A10VSO + A10VSO	41
Connector for solenoids	42
Installation instructions	43
Project planning notes	46
Safety instructions	47
Related documentation	48

Type code

01	02	03	04	05	06	07	08	09	10	11	12	13
	A10VS	O			/	31		-				

Version		18	28	45	71	88	100
01	Standard version for mineral oil (without code)	●	●	●	●	●	●
	HFA, HFB, HFC hydraulic fluid	●	●	●	●	●	E
	High-speed version (external dimensions are not affected by this option)	-	-	●	●	-	H

Axial piston unit

02	Swashplate design, variable, nominal pressure 280 bar, maximum pressure 350 bar	●	●	●	●	●	A10VS
----	---	---	---	---	---	---	-------

Operating mode

03	Pump, open circuit	O
----	--------------------	---

Size (NG)

04	Geometric displacement, see table of values on page 7 and 8	18	28	45	71	88	100
----	---	----	----	----	----	----	-----

Control device

		18	28	45	71	88	100
05	Two-point control, direct operated	●	●	●	●	●	DG
	Pressure controller hydraulic	●	●	●	●	●	DR
	with flow controller hydraulic X-T open	●	●	●	●	●	DFR
	X-T plugged, with flushing function	●	●	●	●	●	DFR1
	with pressure cut-off hydraulic remote controlled	●	●	●	●	●	DRG
	electric negative control $U = 24\text{ V}$	●	●	●	●	●	ED72
	electric positive control $U = 24\text{ V}$	●	●	●	●	●	ER72
	Pressure, flow and power controller	-	●	●	●	●	DFLR

Series

06	Series 3, index 1	31
----	-------------------	----

Direction of rotation

		18	28	45	71	88	100
07	Viewed on drive shaft clockwise	●	●	●	●	●	R
	counter-clockwise	●	●	●	●	●	L

Sealing material

		18	28	45	71	88	100
08	FKM (fluorocarbon rubber)	●	●	●	●	●	V
	NBR (nitrile rubber) only with use of HFA, HFB, HFC hydraulic fluid (position 01; order code "E")	●	●	●	●	●	P

Drive shaft

		18	28	45	71	88	100
09	Splined shaft standard shaft	●	●	●	●	●	S
	ISO 3019-1 Similar to shaft "S" however for higher torque	●	●	●	●	-	R
	Parallel keyed shaft DIN 6885 permissible through-drive torque (see page 9)	●	●	●	●	●	P

01	02	03	04	05	06	07	08	09	10	11	12	13
	A10VS	O			/	31		-				

Mounting flange

Mounting flange				18	28	45	71	88	100	
10	ISO 3019-2	2-hole		●	●	●	●	●	●	A

Working port

Working port			18	28	45	71	88	100	
11	SAE flange ports according to ISO 6162, metric fastening thread	laterally opposite	●	●	●	–	–	●	12
			–	–	–	●	●	–	42

Through drive (for mounting options, see page 40)

12	For flange ISO 3019-1	Hub for splined shaft ¹⁾							
	Diameter	Diameter	18	28	45	71	88	100	
	Without through drive		●	●	●	●	●	●	N00
	82-2 (A)	5/8 in 9T 16/32DP	●	●	●	●	●	●	K01
		3/4 in 11T 16/32DP	●	●	●	●	●	●	K52
	101-2 (B)	7/8 in 13T 16/32DP	-	●	●	●	●	●	K68
		1 in 15T 16/32DP	-	-	●	●	●	●	K04
	127-2 (C)	1 1/4 in 14T 12/24DP	-	-	-	●	●	●	K07
		1 1/2 in 17T 12/24DP	-	-	-	-	-	●	K24
	For flange ISO 3019-2								
	Diameter		18	28	45	71	88	100	
	80, 2-hole	3/4 in 11T 16/32DP	●	●	●	●	●	●	KB2
	100, 2-hole	7/8 in 13T 16/32DP	-	●	●	●	●	●	KB3
		1 in 15T 16/32DP	-	-	●	●	●	●	KB4
	125, 2-hole	1 1/4 in 14T 12/24DP	-	-	-	●	●	●	KB5
		1 1/2 in 17T 12/24DP	-	-	-	-	-	●	KB6
	Ø63, metric 4-hole	Shaft key Ø25	-	●	●	●	●	●	K57

Connector for solenoids²⁾

Connector for solenoids ²⁾		18	28	45	71	88	100	
13	Without connector (without solenoid, only for hydraulic controls, no code)	●	●	●	●	●	●	
	HIRSCHMANN connector – without suppressor diode	●	●	●	●	●	●	H

● = Available ○ = On request - = Not available

Notice

- Note the project planning notes on page 46 and the project planning notes regarding each control device.
- In addition to the type code, please specify the relevant technical data when placing your order.

¹⁾ Hub for splined shaft according to ANSI B92.1a

(drive shaft allocation according to ISO 3019-1)

²⁾ Connectors for other electric components can deviate.

Hydraulic fluids

The A10VSO variable pump is designed for operation with HLP mineral oil according to DIN 51524-2.

See the following data sheets for application instructions and requirements for hydraulic fluids before the start of project planning:

- ▶ 90220: Hydraulic fluids based on mineral oils and related hydrocarbons
- ▶ 90221: Environmentally acceptable hydraulic fluids
- ▶ 90222: Fire-resistant, water-free hydraulic fluids (HFDR/HFDU) (for permissible technical data, see data sheet 90225)
- ▶ 90223: Fire-resistant, water-containing hydraulic fluids (HFAE, HFAS, HFB, HFC)
- ▶ 90225: Limited technical data for operation with water-free and water-containing fire-resistant hydraulic fluids (HFDR, HFDU, HFB, HFC)

Selection of hydraulic fluid

Bosch Rexroth rates hydraulic fluids on the basis of the Fluid Rating according to technical data sheet 90235.

Hydraulic fluids with positive evaluation in the Fluid Rating are provided in the following data sheet:

- ▶ 90245: Bosch Rexroth Fluid Rating List for Rexroth hydraulic components (pumps and motors)

The selection of hydraulic fluid shall take place so that the operating viscosity in the operating temperature range is within the optimum range (v_{opt} ; see selection diagram).

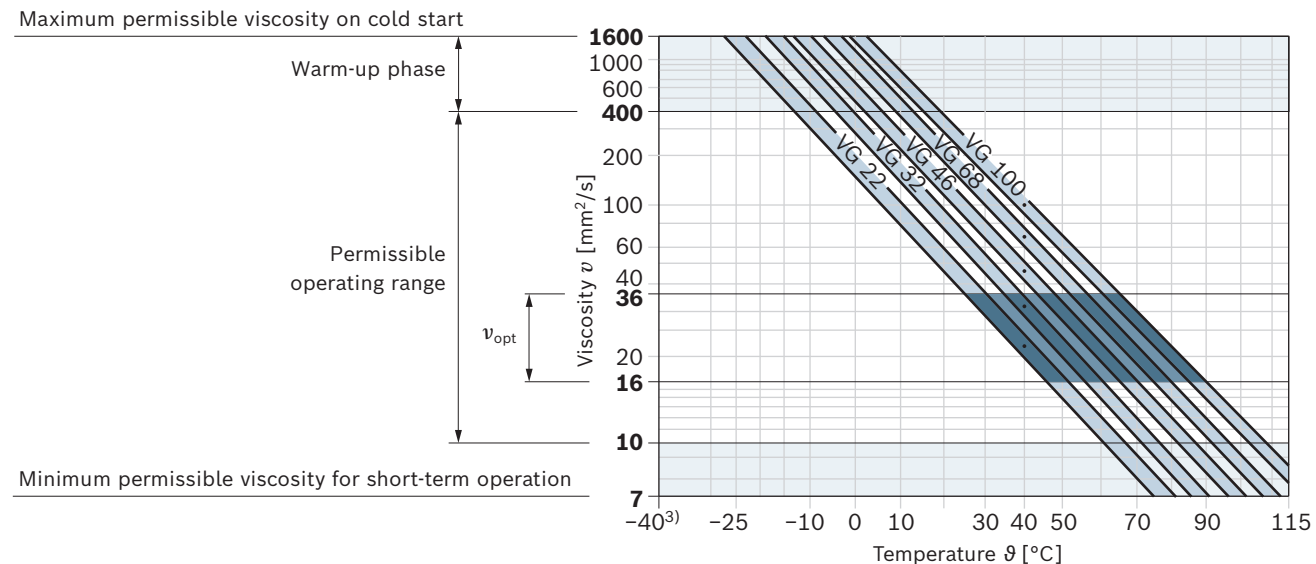
Notice

- ▶ The axial piston unit is suitable for operation with water-containing HF hydraulic fluid. See version "E".

Viscosity and temperature of hydraulic fluids

	Viscosity	Shaft seal	Temperature ²⁾	Remarks
Cold start	$v_{max} \leq 1600 \text{ mm}^2/\text{s}$	FKM	$\vartheta_{St} \geq -25^\circ\text{C}$	$t \leq 3 \text{ min}$, without load ($p \leq 50 \text{ bar}$), $n \leq 1000 \text{ rpm}$ Permissible temperature difference between axial piston unit and hydraulic fluid in the system: max. 25 K
Warm-up phase	$v = 1600 \dots 400 \text{ mm}^2/\text{s}$			$t \leq 15 \text{ min}$, $p \leq 0.7 \times p_{nom}$ and $n \leq 0.5 \times n_{nom}$
Permissible operating range	$v = 400 \dots 10 \text{ mm}^2/\text{s}^{1)}$	FKM	$\vartheta \leq +110^\circ\text{C}$	Measured at port L , L₁
	$v_{opt} = 36 \dots 16 \text{ mm}^2/\text{s}$			Optimal operating viscosity and efficiency range
Short-term operation	$v_{min} = 10 \dots 7 \text{ mm}^2/\text{s}$	FKM	$\vartheta \leq +110^\circ\text{C}$	$t \leq 3 \text{ min}$, $p \leq 0.3 \times p_{nom}$, measured at port L , L₁

▼ Selection diagram



1) This corresponds, e.g. on the VG 46, to a temperature range of +4 °C to +85 °C (see selection diagram)

2) If the temperature at extreme operating parameters cannot be adhered to, please contact us.

3) For applications in the low-temperature range, please contact us.

Filtration of the hydraulic fluid

Finer filtration improves the cleanliness level of the hydraulic fluid, which increases the service life of the axial piston unit.

A cleanliness level of at least 20/18/15 is to be maintained according to ISO 4406.

At a hydraulic fluid viscosity of less than 10 mm²/s (e.g. due to high temperatures during short-term operation), at the drain port, a cleanliness level of at least 19/17/14 according to ISO 4406 is required.

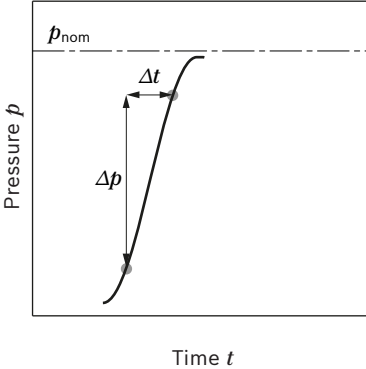
Examples of temperatures of hydraulic fluids at a viscosity of 10 mm²/s:

- ▶ 73 °C at HLP 32
- ▶ 85 °C at HLP 46

Working pressure range

Pressure at working port B			Definition
Nominal pressure p_{nom}	280 bar	The nominal pressure corresponds to the maximum design pressure. The maximum pressure corresponds to the maximum working pressure within a single operating period. The sum of single operating periods must not exceed the total operating period.	
Maximum pressure p_{max}	350 bar		
Single operating period	2 ms		
Total operating period	300 h		
Minimum pressure $p_{B absolute}$ (high-pressure side)	10 bar ¹⁾	Minimum pressure on the high-pressure side (B) required to prevent damage to the axial piston unit.	
Rate of pressure change $R_{A max}$	16000 bar/s	Maximum permissible speed of pressure build-up and reduction during a pressure change across the entire pressure range.	
Pressure at suction port S (inlet)			
Minimum pressure $p_{S min}$	Standard	0.8 bar absolute	Minimum pressure at suction port S (inlet) which is required to prevent damage to the axial piston unit. The minimum pressure depends on the rotational speed and displacement of the axial piston unit.
Maximum pressure $p_{S max}$		10 bar	
Case pressure at port L, L ₁			
Maximum pressure $p_{L max}$		2 bar ¹⁾ absolute	Maximum 0.5 bar higher than inlet pressure at port S , but not higher than $p_{L max}$. The case pressure must always be higher than the ambient pressure. A drain line to the reservoir is required.
Pilot pressure port X with external high pressure			
Maximum pressure p_{max}		350 bar	When designing all control lines with external high pressure, the values for the rate of pressure change, maximum single operating period and total operating period applicable to port B must not be exceeded.

▼ Rate of pressure change $R_{A max}$

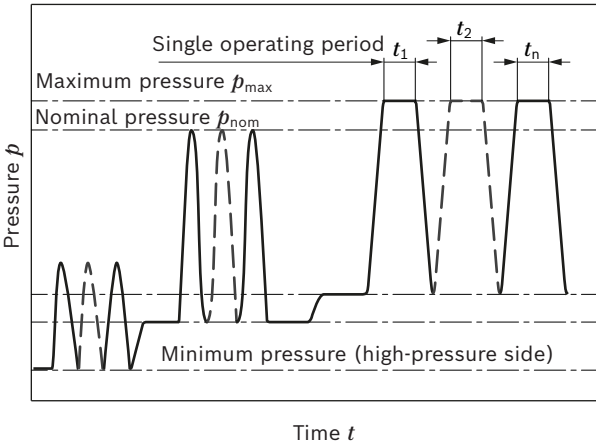


Notice

▶ Working pressure range applies when using hydraulic fluids based on mineral oils. Please contact us for values for other hydraulic fluids.

▶ In addition to the hydraulic fluid and the temperature, the service life of the shaft seal is influenced by the rotational speed of the axial piston unit and the case pressure.

▼ Pressure definition



Total operating period = $t_1 + t_2 + \dots + t_n$

1) Other values on request

Technical data, standard unit

Size		NG		18	28	45	71	88	100
Geometric displacement, per revolution		$V_{g \max}$	cm ³	18	28	45	71	88	100
Maximum rotational speed ¹⁾	at $V_{g \max}$	n_{nom}	rpm	3300	3000	2600	2200	2100	2000
	at $V_g < V_{g \max}$ ²⁾	$n_{\text{max perm}}$	rpm	3900	3600	3100	2600	2500	2400
Flow	at n_{nom} and $V_{g \max}$	$q_{v \max}$	l/min	59	84	117	156	185	200
	at $n_E = 1500$ rpm and $V_{g \max}$	$q_{vE \max}$	l/min	27	42	68	107	132	150
Power	at n_{nom} , $V_{g \max}$	$P_{\max}$	kW	28	39	55	73	86	93
at $\Delta p = 280$ bar	at $n_E = 1500$ rpm and $V_{g \max}$	$P_{E \max}$	kW	12.6	20	32	50	62	70
Torque with	$\Delta p = 280$ bar	$M_{\max}$	Nm	80	125	200	316	392	445
$V_{g \max}$ and	$\Delta p = 100$ bar	M	Nm	30	45	72	113	140	159
Rotary stiffness of drive shaft	S	c	Nm/rad	11087	22317	37500	71884	71884	121142
	R	c	Nm/rad	14850	26360	41025	76545	76545	–
	P	c	Nm/rad	13158	25656	41232	80627	80627	132335
Moment of inertia of the rotary group		J_{TW}	kgm ²	0.00093	0.0017	0.0033	0.0083	0.0083	0.0167
Case volume		V	l	0.4	0.7	1.0	1.6	1.6	2.2
Weight without through drive (approx.)		m	kg	12.9	18	23.5	35.2	35.2	49.5
Weight with through drive (approx.)				14	19.3	25.1	38	38	55.4

Determination of the characteristics

$$\text{Flow} \quad q_v = \frac{V_g \times n \times \eta_v}{1000} \quad [\text{l/min}]$$

$$\text{Torque} \quad M = \frac{V_g \times \Delta p}{20 \times \pi \times \eta_{hm}} \quad [\text{Nm}]$$

$$\text{Power} \quad P = \frac{2 \pi \times M \times n}{60000} = \frac{q_v \times \Delta p}{600 \times \eta_t} \quad [\text{kW}]$$

Key

V_g Displacement per revolution [cm³]

Δp Differential pressure [bar]

n Rotational speed [rpm]

η_v Volumetric efficiency

η_{hm} Hydraulic-mechanical efficiency

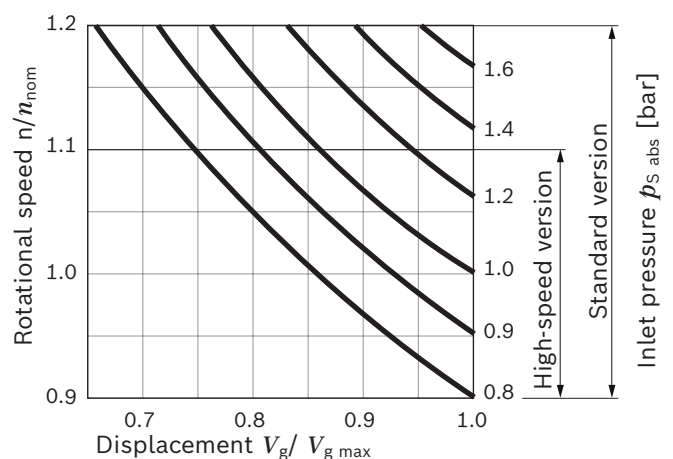
η_t Total efficiency ($\eta_t = \eta_v \times \eta_{hm}$)

Notice

- Theoretical values, without efficiency and tolerances; values rounded
- Operation above the maximum values or below the minimum values may result in a loss of function, a reduced service life or in the destruction of the axial piston unit. Bosch Rexroth recommends testing the loads by means of experiment or calculation/simulation and comparison with the permissible values.

Minimum permissible inlet pressure at suction port S with speed increase

In order to avoid damage to the pump (cavitation), a minimum inlet pressure must be guaranteed at suction port **S**. The minimum inlet pressure level depends on the rotational speed and the displacement of the variable pump.



During continuous operation in overspeed over n_{nom} , a reduction in operational service life is to be expected due to cavitation erosion.

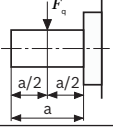
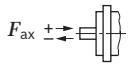
1) The values are applicable:

- At an absolute pressure $p_{\text{abs}} = 1$ bar at the suction port **S**
- For the optimum viscosity range from $\nu_{\text{opt}} = 36$ to $16 \text{ mm}^2/\text{s}$
- With hydraulic fluid based on mineral oils

2) For a speed increase up to $n_{\text{max perm}}$, see diagram

"Minimum permissible inlet pressure at suction port **S** with speed increase".

Permissible radial and axial loading of the drive shaft

Size		NG		18	28	45	71	88	100
Maximum radial force at a/2		$F_{q \max}$	N	350	1200	1500	1900	1900	2300
Maximum axial force		$\pm F_{ax \max}$	N	700	1000	1500	2400	2400	4000

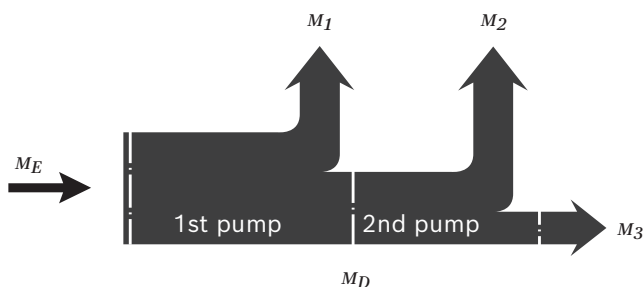
Notice

- The values given are maximum values and do not apply to continuous operation. All loads of the drive shaft reduce the bearing service life!
- For drives with radial loading (pinion, V-belt), please contact us

Permissible input and through-drive torques

Size			18	28	45	71	88	100
Torque at $V_{g \max}$ and $\Delta p = 280 \text{ bar}^1$	$M_{\max}$	Nm	80	125	200	316	392	445
Max. input torque on drive shaft ²⁾								
S	$M_{E \max}$	Nm	124	198	319	626	626	1104
	$\varnothing$	in	3/4	7/8	1	1 1/4	1 1/4	1 1/2
R	$M_{E \max}$	Nm	160	250	400	644	644	–
	$\varnothing$	in	3/4	7/8	1	1 1/4	1 1/4	–
P	$M_{E \max}$	Nm	88	137	200	439	439	857
	$\varnothing$	in	18	22	25	32	32	40
Maximum through-drive torque								
S	$M_{D \max}$	Nm	108	160	319	492	492	778
R	$M_{D \max}$	Nm	120	176	365	548	548	–
P	$M_{D \max}$	Nm	88	137	200	439	439	778

▼ Distribution of torques



Torque at 1st pump	M_1
Torque at 2nd pump	M_2
Torque at 3rd pump	M_3
Input torque	$M_E = M_1 + M_2 + M_3$
	$M_E < M_{E \max}$
Through-drive torque	$M_D = M_2 + M_3$
	$M_D < M_{D \max}$

¹⁾ Efficiency not considered

²⁾ For drive shafts with no radial force

DG – Two-point control, direct operated

The variable pump can be set to a minimum swivel angle by connecting an external switching pressure to port **X**. This will supply control fluid directly to the stroking piston; a minimum control pressure of $p_{st} \geq 50$ bar is required.

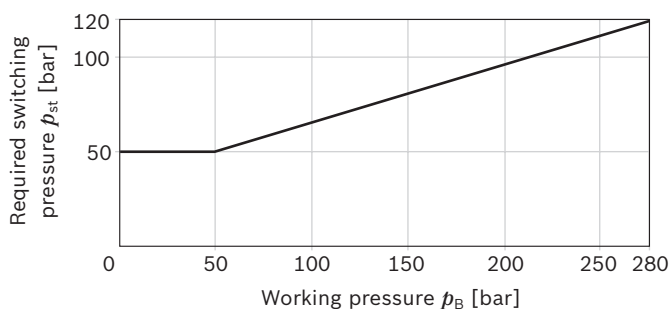
The variable pump can only be switched between $V_{g \max}$ and $V_{g \min}$.

Please note that the required switching pressure at port **X** is directly dependent on the actual working pressure p_B in port **B**. (See switching pressure characteristic curve).

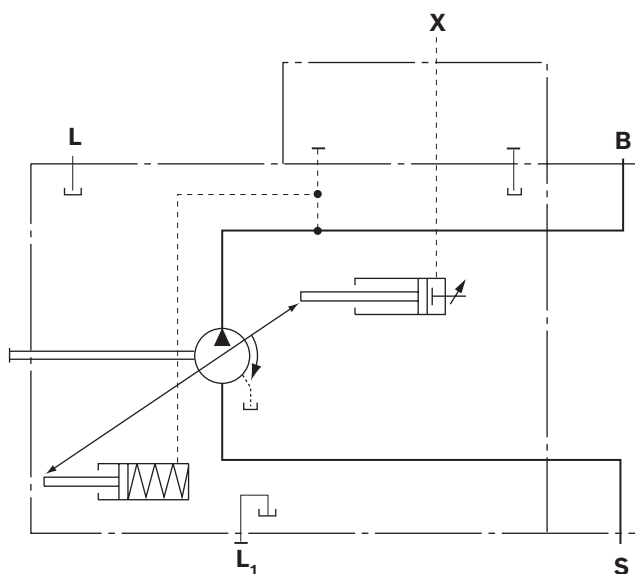
The maximum permissible switching pressure is 280 bar.

- Switching pressure p_{st} in **X** = 0 bar $\triangleq V_{g \max}$
- Switching pressure p_{st} in **X** ≥ 50 bar $\triangleq V_{g \min}$

▼ Switching pressure characteristic curve



▼ Circuit diagram DG



DFR/DFR1 – Pressure flow controller

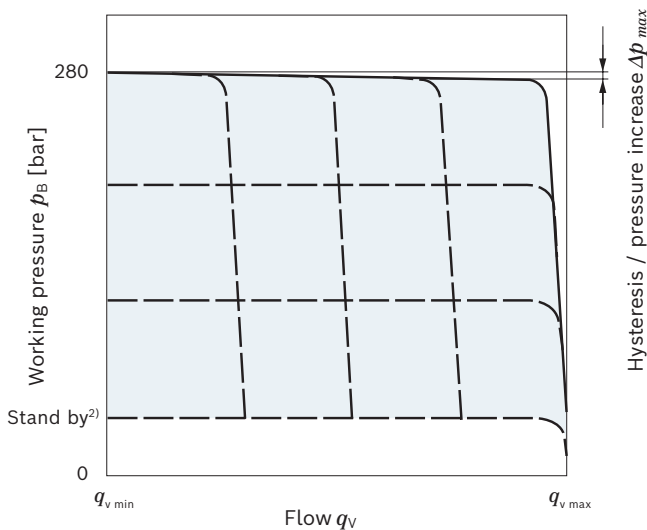
In addition to the pressure controller function (see page 11), an adjustable orifice (e.g. directional valve) is used to adjust the differential pressure upstream and downstream of the orifice. This is used to control the pump flow. The pump flow is equal to the actual hydraulic fluid quantity required by the consumer. With all controller combinations, the V_g reduction has priority.

- ▶ Basic position in depressurized state: $V_{g \max}$.
- ▶ Setting range¹⁾ to 280 bar.
Standard is 280 bar.
- ▶ For pressure controller data, see page 11

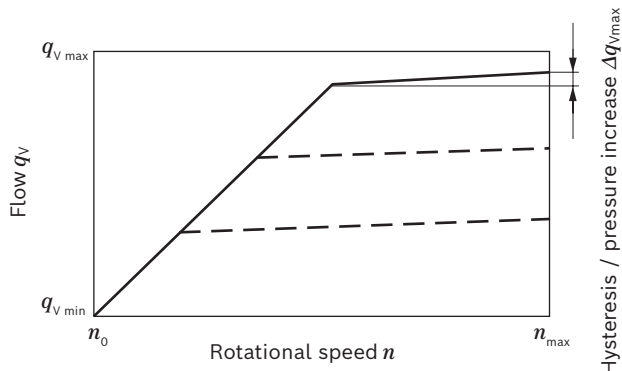
Notice

- ▶ The DFR1 version has no unloading between **X** and the reservoir. The LS must thus be unloaded in the system. Because of the flushing function of the flow controller in the DFR1 control valve, sufficient unloading of the **X**-line must also be provided.

▼ Characteristic curve

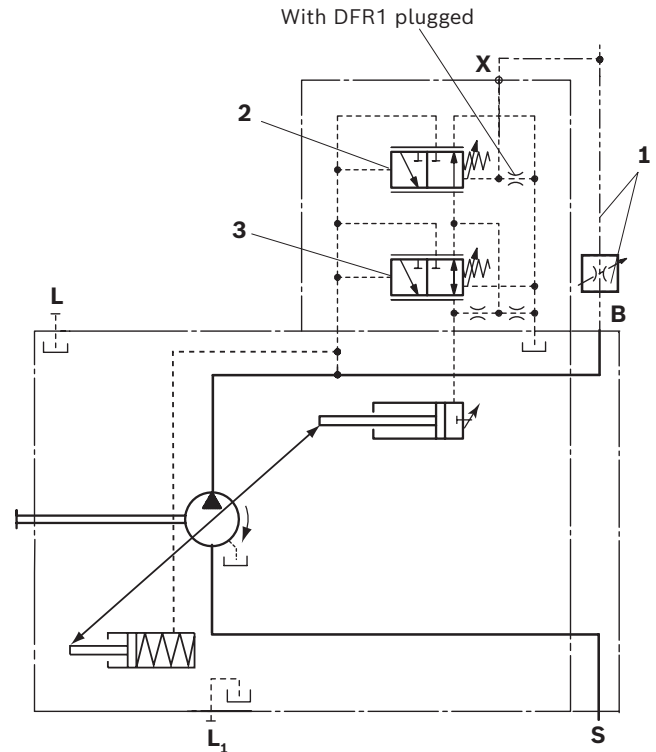


▼ Characteristic curve at variable rotational speed



Characteristic curves valid at $n_1 = 1500$ rpm and $\vartheta_{\text{fluid}} = 50$ °C.

▼ Circuit diagram DFR



- 1 The metering orifice (control block) and the line are not included in the scope of delivery.
- 2 Flow controller (FR).
- 3 Pressure controller (DR)

For further information, see page 14

1) To prevent damage to the pump and the system, the permissible setting range must not be exceeded.

The range of possible settings at the valve is higher.

2) Zero stroke pressure from pressure setting Δp on controller (2)

Differential pressure Δp :

- ▶ Standard setting: 14 bar
If another setting is required, please state in the plain text.
- ▶ Setting range: 14 bar to 22 bar

Unloading port **X** to the reservoir results in a zero stroke pressure ("standby"), which is approx. 1 to 2 bar higher than the defined differential pressure Δp ; however, system influences are not taken into account.

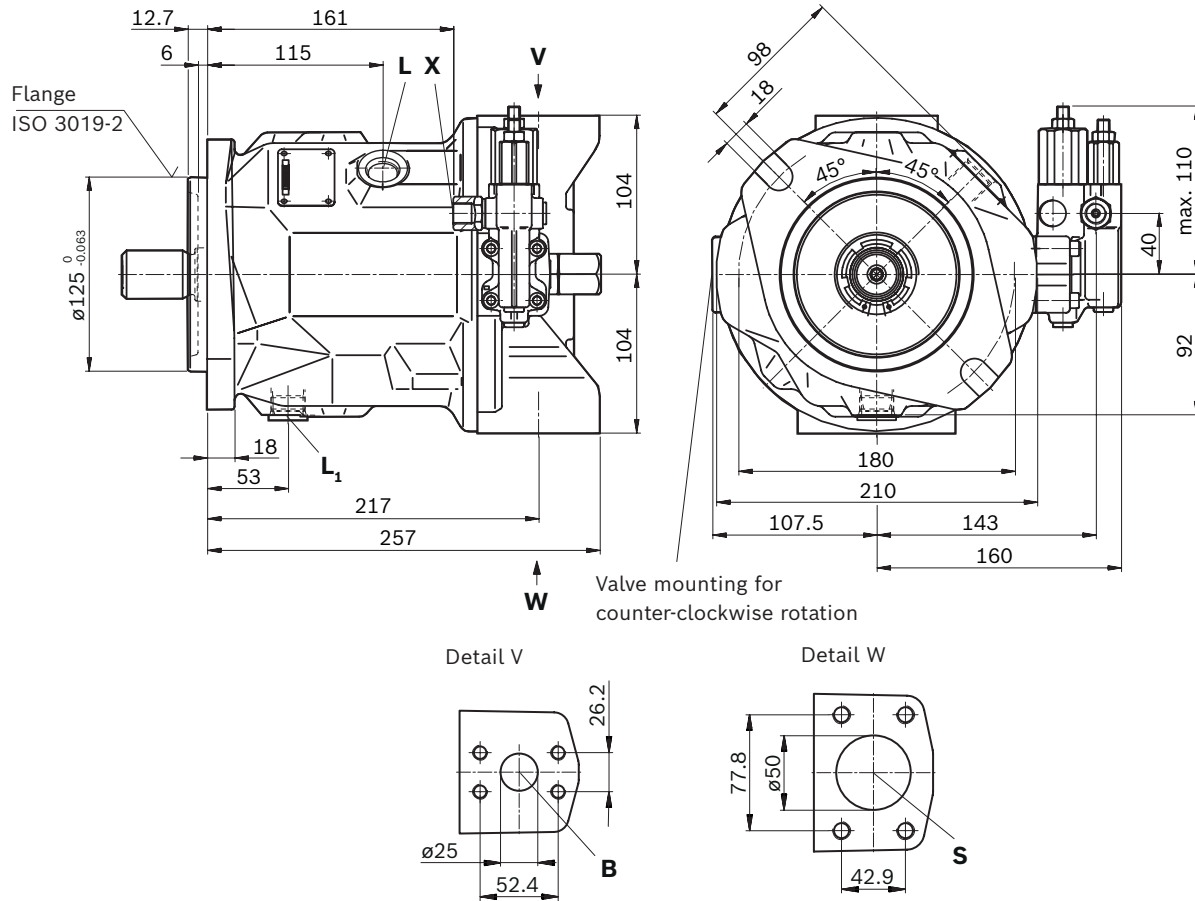
Controller data

DR pressure controller data, see page 11.
 Maximum flow deviation measured at drive speed
 n = 1500 rpm.

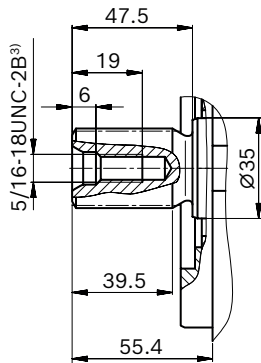
NG		18	28	45	71	88	100
Flow deviation	Δq_{Vmax} [l/min]	0.9	1.0	1.8	2.8	3.4	4.0
Hysteresis	Δp [bar]	Maximum 4					
Pilot fluid consumption	[l/min]	maximum approx. 3 to 4.5 (DFR) Maximum approx. 3 (DFR1)					

Dimensions, sizes 71 and 88

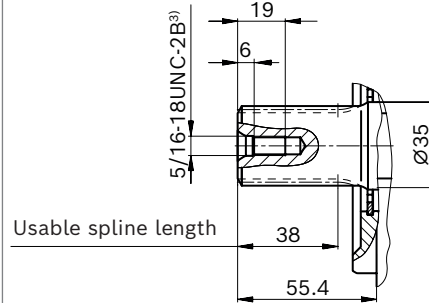
DFR/DFR1 – Pressure flow controller, hydraulic, clockwise rotation



▼ Splined shaft 1 1/4 in (32-4, ISO 3019-1)

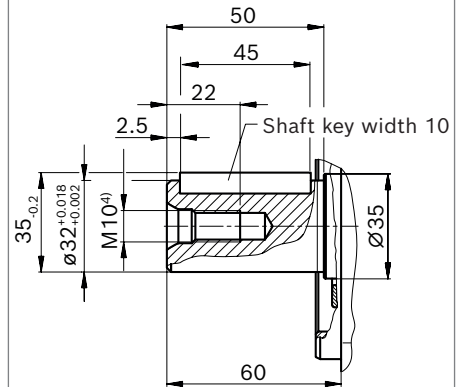
S – 14T 12/24DP¹⁾

▼ Splined shaft 1 1/4 in (similar to ISO 3019-1)

R – 14T 12/24DP¹⁾²⁾

▼ Cylindrical keyed shaft (DIN 6885)

P – A10 × 8 × 45

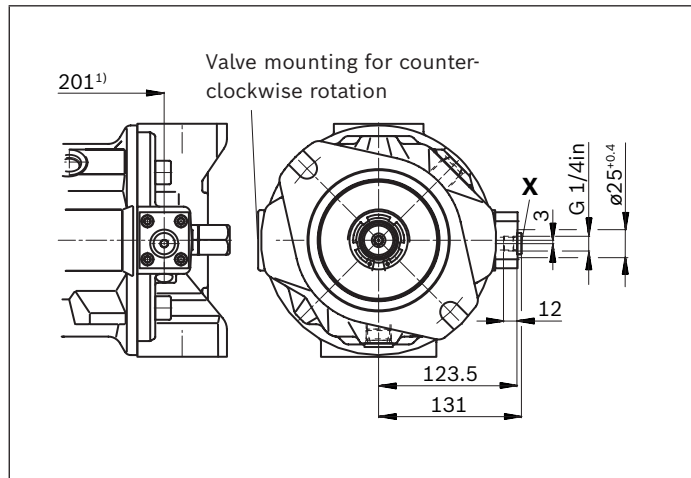


Ports		Standard	Size	$p_{\max}$ [bar] ⁵⁾	State ⁸⁾
B	Working port (standard pressure series) Fastening thread	ISO 6162-1 DIN 13	1 in M10 × 1.5; 17 deep	350	O
S	Suction port (standard pressure series) Fastening thread	ISO 6162-1 DIN 13	2 in M12 × 1.75; 20 deep	10	O
L	Drain port	DIN 3852 ⁶⁾	M22 × 1.5; 14 deep	2	O ⁷⁾
L₁	Drain port	DIN 3852 ⁶⁾	M22 × 1.5; 14 deep	2	X ⁷⁾
X	Pilot pressure port	DIN 3852	M14 × 1.5; 12 deep	350	O
X	Pilot pressure port with DG-control	DIN 3852-2	G1/4 in; 12 deep	350	O

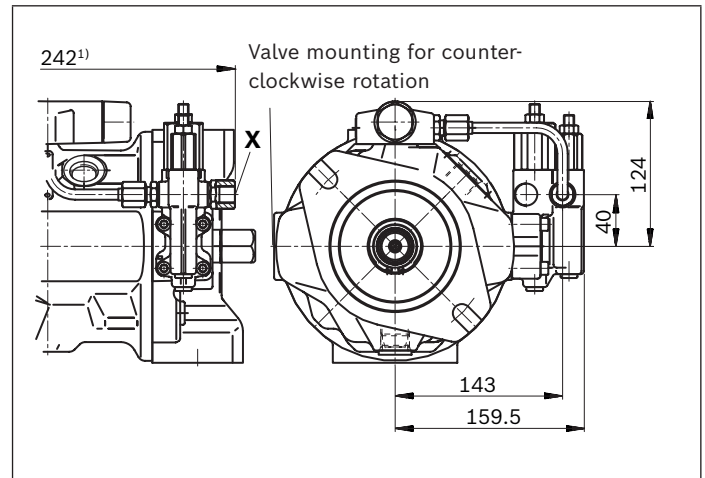
- 1) Involute spline according to ANSI B92.1a, 30° pressure angle, flat root, side fit, tolerance class 5
- 2) Splines according to ANSI B92.1a, spline runout is a deviation from standard ISO 3019-1.
- 3) Thread according to ASME B1.1
- 4) Thread according to DIN 13, center bore according to DIN 332-2
- 5) Depending on the application, momentary pressure peaks can occur. Keep this in mind when selecting measuring devices and fittings.

- 6) The countersink may be deeper than specified in the standard.
- 7) Depending on the installation position, L or L₁ must be connected (also see installation instructions on page 43).
- 8) O = Must be connected (plugged on delivery)
X = Plugged (in normal operation)

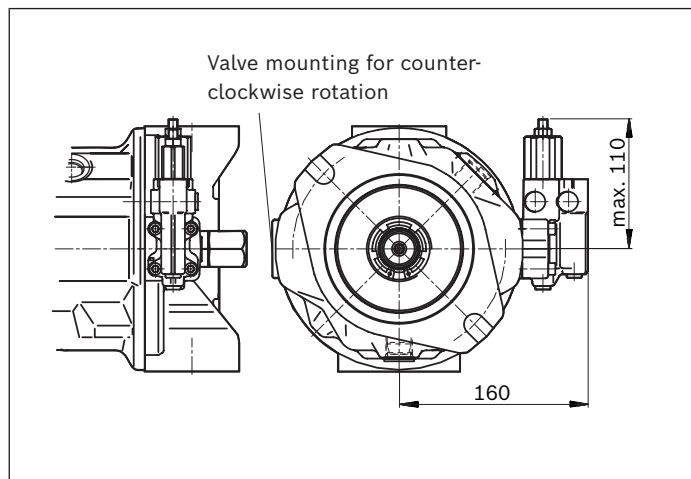
▼ **DG – Two-point control, direct operated**



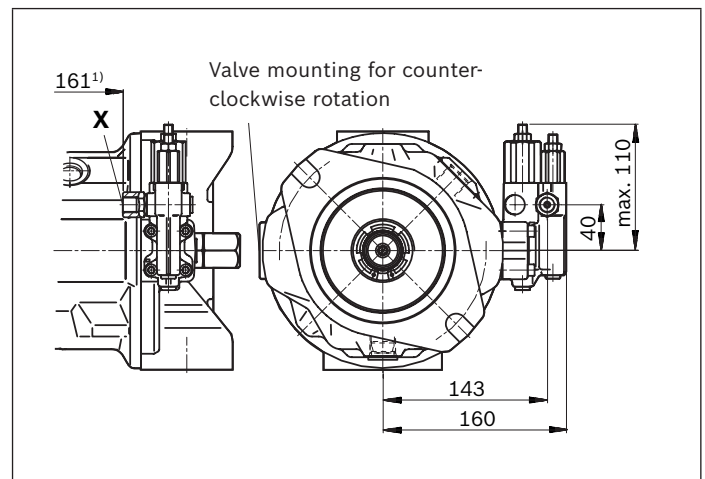
▼ **DFLR – Pressure, flow and power controller**



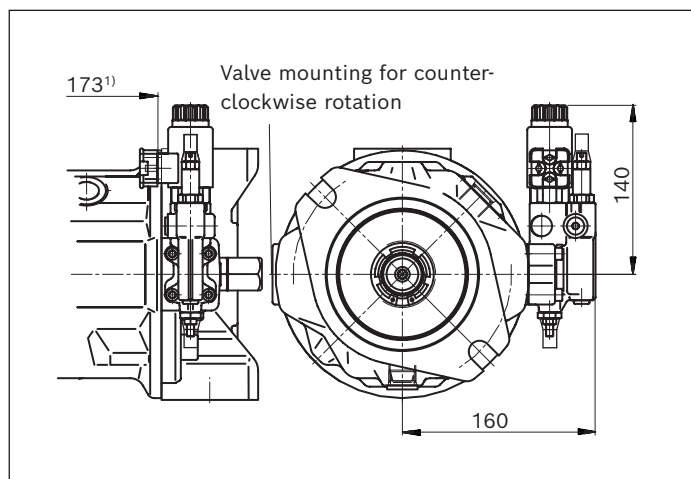
▼ **DR – Pressure controller**



▼ **DRG – Pressure controller, remote controlled**



▼ **ED7., ER7. - Electrohydraulic pressure control**



1) To flange surface

Installation instructions

General

The axial piston unit must be filled with hydraulic fluid and air bled during commissioning and operation. This must also be observed following a longer standstill as the axial piston unit may empty via the hydraulic lines. Filling and air bleeding must be carried out completely, particularly in the installation position "drive shaft upwards," as there is e.g. a danger of dry running. The leakage in the housing area must be directed to the reservoir via the highest available drain port (**L**, **L₁**). For combination pumps, the leakage must be drained off at each single pump.

If a shared drain line is used for several units, make sure that the respective case pressure in each unit is not exceeded. The shared drain line must be dimensioned to ensure that the maximum permissible case pressure of all connected units is not exceeded in any operating condition, particularly at cold start. If this is not possible, separate drain lines must be laid.

To prevent the transmission of structure-borne noise, use elastic elements to decouple all connecting lines from all vibration-capable components (e.g. reservoir, frame parts).

Under all operating conditions, the suction lines and the drain lines must flow into the reservoir below the minimum fluid level. The permissible suction height h_s results from the total pressure loss. However, it must not be higher than $h_{s \max} = 800 \text{ mm}$. The minimum suction pressure at port **S** must not fall below 0.8 bar absolute during operation and during cold start.

When designing the reservoir, ensure that there is adequate distance between the suction line and the drain line. We recommend using a baffle (baffle plate) between suction line and drain line. A baffle improves the air separation ability as it gives the hydraulic fluid more time for desorption. Apart from that, this prevents the heated return flow from being drawn directly back into the suction line. The suction port must be supplied with air-free, calmed and cooled hydraulic fluid.

Notice

In certain installation positions, an influence on the adjustment or control can be expected. Gravity, dead weight and case pressure can cause minor characteristic shifts and changes in actuating time.

Installation position

See the following examples **1** to **9**.

Further installation positions are available upon request.

Recommended installation position: **1** and **3**

Key	
F	Filling / Air bleeding
S	Suction port
L; L₁	Drain port
SB	Baffle (baffle plate)
$h_{t \min}$	Minimum required immersion depth (200 mm)
$h_{\min}$	Minimum required distance to reservoir bottom (100 mm)
$h_{ES \min}$	Minimum height required to prevent axial piston unit from draining (25 mm)
$h_{S \max}$	Maximum permissible suction height (800 mm)

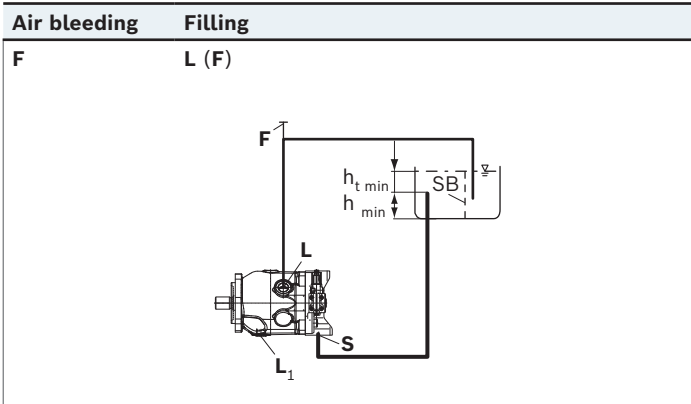
Notice

Port **F** is part of the external piping and must be provided on the customer side to make filling and air bleeding easier.

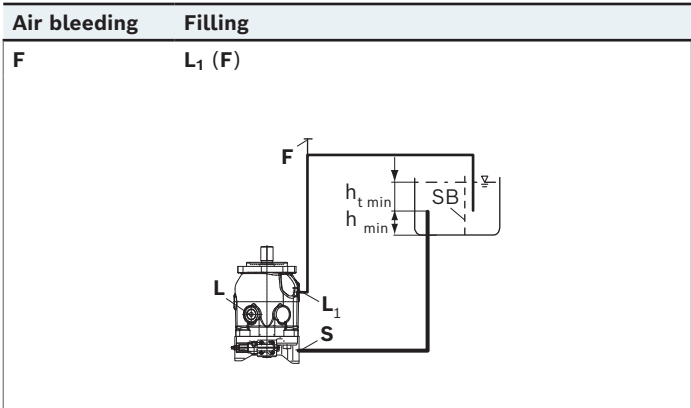
Below-reservoir installation (standard)

Below-reservoir installation means that the axial piston unit is installed outside of the reservoir below the minimum fluid level.

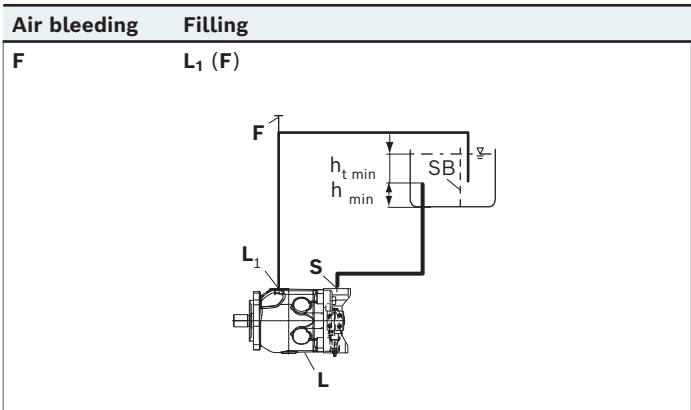
▼ Installation position 1



▼ Installation position 2¹⁾



▼ Installation position 3



For key, see page 43.

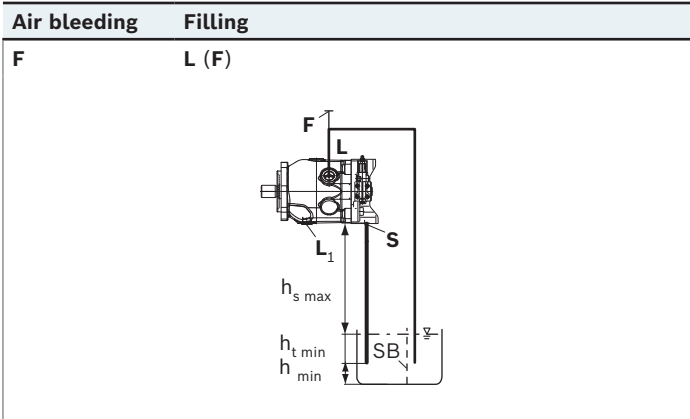
¹⁾ Because complete air bleeding and filling are not possible in this position, the pump should be air bled and filled in a horizontal position before installation.

Above-reservoir installation

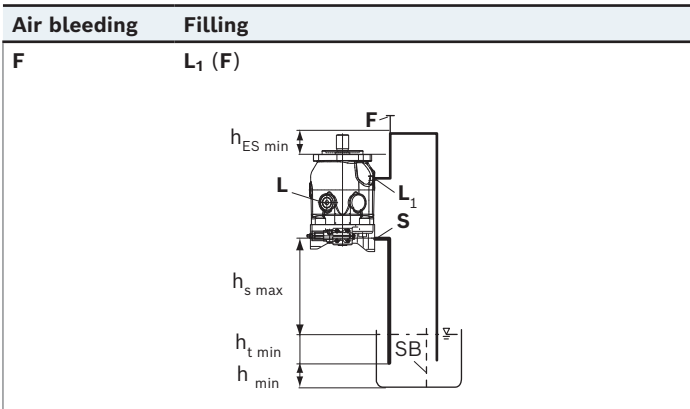
Above-reservoir installation means that the axial piston unit is installed above the minimum fluid level of the reservoir. To prevent the axial piston unit from draining in position 5, the height difference $h_{ES\ min}$ must be at least 25 mm. Observe the maximum permissible suction height $h_{S\ max} = 800\ mm$

A check valve in the drain line is only permissible in individual cases. Consult us for approval.

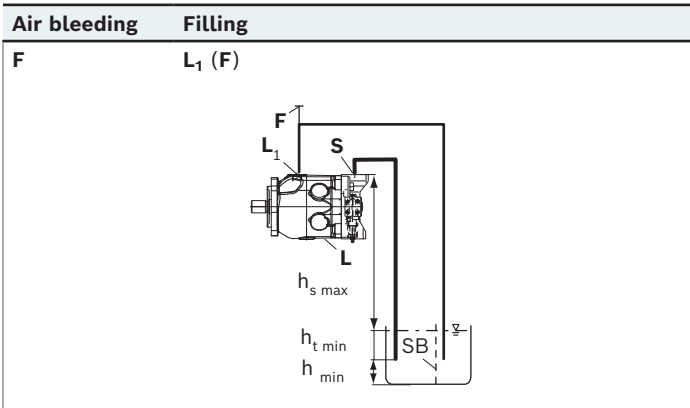
▼ Installation position 4



▼ Installation position 5¹⁾



▼ Installation position 6



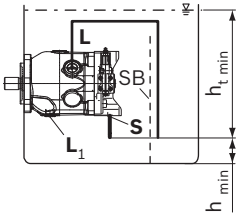
Inside-reservoir installation

Inside-reservoir installation is when the axial piston unit is installed in the reservoir below the minimum fluid level. The axial piston unit is completely below the hydraulic fluid. If the minimum fluid level is equal to or below the upper edge of the pump, see chapter "Above-reservoir installation".

Axial piston units with electrical components (e.g. electric control, sensors) must not be installed in a reservoir below the fluid level.

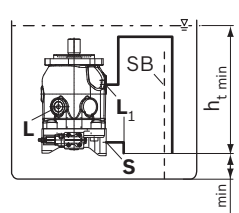
▼ Installation position 7

Air bleeding	Filling
L	L



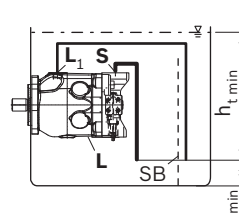
▼ Installation position 8¹⁾

Air bleeding	Filling
L ₁	L, L ₁



▼ Installation position 9

Air bleeding	Filling
L ₁	L, L ₁



For key, see page 43.

Notice

- Our advice is to fit a suction pipe to the suction port **S** and to fit a pipe to case drain port **L** or **L₁**. In this case, the other drain port must be plugged. The housing of the axial piston unit is to be filled via **L** or **L₁** (see installation position 7 to 9) before the piping is fitted and the reservoir is filled with hydraulic fluid.

¹⁾ Because complete air bleeding and filling are not possible in this position, the pump should be air bled and filled in a horizontal position before installation.

Project planning notes

- ▶ The A10VSO axial piston variable pump is intended to be used in an open circuit.
- ▶ Project planning, installation and commissioning of the axial piston units requires the involvement of skilled personnel.
- ▶ Before using the axial piston unit, please read the corresponding operating instructions completely and thoroughly. If necessary, this can be requested from Bosch Rexroth.
- ▶ Before finalizing your design, please request a binding installation drawing.
- ▶ The specified data and notes contained herein must be observed.
- ▶ Depending on the operating conditions of the axial piston unit (working pressure, fluid temperature), the characteristic curve may shift.
- ▶ The characteristic curve may also shift due to the dither frequency or control electronics.
- ▶ Preservation: Our axial piston units are supplied as standard with preservation protection for a maximum of 12 months. If longer preservation protection is required (maximum 24 months), please specify this in plain text when placing your order. The preservation periods apply under optimal storage conditions, details of which can be found in the data sheet 90312 or the operating instructions.
- ▶ Not all configuration variants of the product are approved for use in a safety function according to ISO 13849. Please consult the responsible contact at Bosch Rexroth if you require reliability parameters (e.g., MTTF_d) for functional safety.
- ▶ Depending on the type of control used, electromagnetic effects can be produced when using solenoids. Applying a direct current signal (DC) to solenoids does not create electromagnetic interference (EMI) nor is the solenoid affected by EMI. Electromagnetic interference (EMI) potential exists when operating and controlling a solenoid with a modulated direct current signal (e.g. PWM signal). Appropriate testing and measures should be taken by the machine manufacturer to ensure other components or operators (e.g. with pacemaker) are not affected by this potential.
- ▶ Pressure control (hydraulic or electronic) is not an adequate safeguard against pressure overload. A pressure relief valve should therefore be provided in the hydraulic system. In this connection, observe the technical limits of the pressure relief valve.
- ▶ Please note that a hydraulic system is an oscillating system. This can lead, for example, to the stimulation the natural frequency within the hydraulic system during operation at constant rotational speed over a long period of time. The excitation frequency of the pump is 9 times the rotational speed frequency. This can be prevented, for example, with suitably designed hydraulic lines.
- ▶ Please note the information regarding the tightening torques of port threads and other screw connections in the operating instructions.
- ▶ The ports and fastening threads are designed for the permissible pressures $p_{\max}$ of the respective ports, see the connection tables. The machine or system manufacturer must ensure that the connecting elements and lines correspond to the specified application conditions (pressure, flow, hydraulic fluid, temperature) with the necessary safety factors.
- ▶ The service ports and function ports are only intended to accommodate hydraulic lines.

Safety instructions

- ▶ During and shortly after operation, there is a risk of getting burnt on the axial piston unit and especially on the solenoids. Take the appropriate safety measures (e.g. by wearing protective clothing).
- ▶ Moving parts in control equipment (e.g. valve spools) can, under certain circumstances, get stuck in position as a result of contamination (e.g. contaminated hydraulic fluid, abrasion, or residual dirt from components). As a result, the hydraulic fluid flow and the build-up of torque in the axial piston unit can no longer respond correctly to the operator's specifications. Even the use of various filter elements (external or internal flow filtration) will not rule out a fault but merely reduce the risk. The machine/system manufacturer must test whether remedial measures are needed on the machine for the application concerned in order to bring the driven consumer into a safe position (e.g. safe stop) and ensure any measures are properly implemented.

Related documentation

Product-specific documentation

Document type	Title	Document number
Data sheet	Valve amplifier for proportional valves without electric position feedback; maximum current limit 1.5 A type VT-MSPA2...1A5	30232
	Storage and preservation of axial piston units	90312
Operating instructions	Axial piston variable pump A10VO, A10VSO series 31	92701-01-B

Documentation for hydraulic fluids

Document type	Title	Document number
Data sheet	Hydraulic fluids based on mineral oils and related hydrocarbons	90220
	Environmentally acceptable hydraulic fluids	90221
	Fire-resistant, water-free hydraulic fluids (HFDR/HFDU)	90222
	Fire-resistant hydraulic fluids – water-containing (HFAE, HFAS, HFB, HFC, HFC-E)	90223
	Axial piston units for operation with fire-resistant hydraulic fluids (HFDR, HFDU, HFA, HFB, HFC, HFC-E)	90225
	Rating of hydraulic fluids used in Rexroth hydraulic components (pumps and engines)	90235
	Bosch Rexroth Fluid Rating List for Rexroth hydraulic components (pumps and motors)	90245

Bosch Rexroth AG

An den Kelterwiesen 14
72160 Horb a.N.
Germany
Phone +49 7451 92-0
sales.industry.horb@boschrexroth.de
www.boschrexroth.com

© Bosch Rexroth AG 1987. All rights reserved, also regarding any disposal, exploitation, reproduction, editing, distribution, as well as in the event of applications for industrial property rights. The data specified within only serve to describe the product. As our products are constantly being further developed, no statements concerning a certain condition or suitability for a certain application can be derived from our information. The information given does not release the user from the obligation of own judgment and verification. It must be remembered that our products are subject to a natural process of wear and aging.