

Start up recommendations for By-Pass valves

Please read before installing the By-Pass valve.

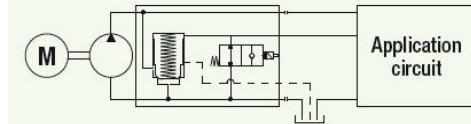
For XPi-XAi pumps applications where the pump is driven by a continuous running PTO (PTO which cannot be disengaged), Hydro Leduc offers a by-pass valve which is fitted onto the back of the pump. This solution allows the continuous running of the pump :

- Without creating problems of fluid overheating.
- Without affecting pump service life.
- With no modifications necessary to the hydraulic equipment on the truck.

By-Pass reference in function of the pump:

Pump model	Displacement (cc)	Tension	LEDUC Reference
XPi	12 to 63	24 V	BP63 0517931
	80 to 130	24 V	BP80 0522140
	12 to 63	12 V	BP63 0521180
	80 to 130	12 V	BP80 0522235
XAi	12 to 32	12 V	BPA32 0518755
	41 to 63	12 V	BPA63 0518520
	12 to 32	24 V	BPA32 0521710
	41 to 63	24 V	BPA63 0521715

Diagram:



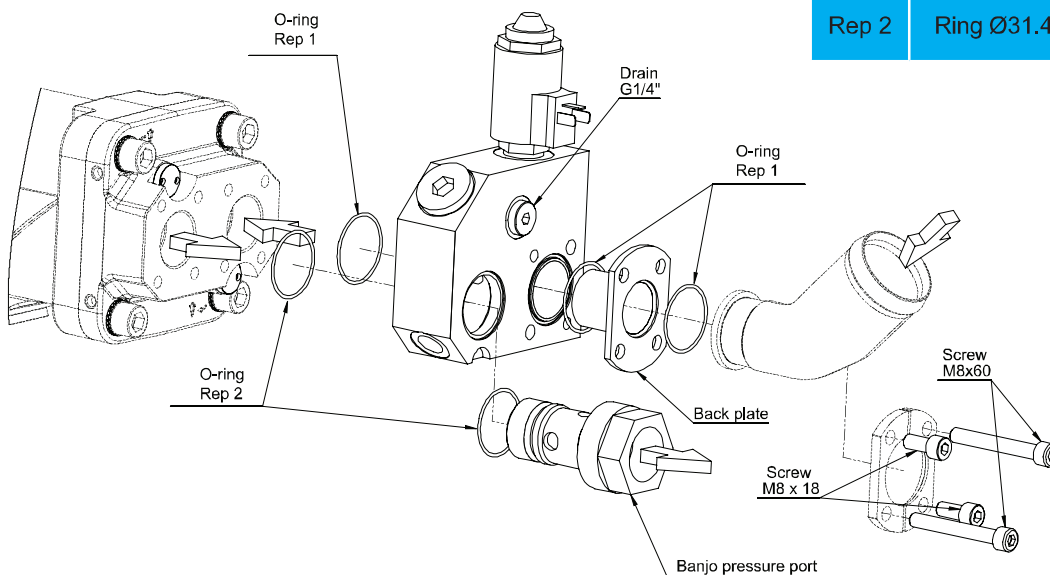
Installation:

The By-Pass valve is directly connected to the bottom of the pump XPi-XAi.

Fixed on the outlet with a "banjo" provided with the valve.

Fixed on the inlet with 2 screws also design to fix the aspiration pipe of the pump on the By-Pass.

O-ring	BP/BPA 12 to 63 cc	BP/BPA 80 to 130 cc
Rep 1	Ring Ø36.3 x Ø1.78	
Rep 2	Ring Ø31.47 x Ø1.78	Ring Ø34.65 x Ø1.78



4 positions available :
 CW : - coil up
 - coil down
 CCW : - coil up
 - coll down

Be careful during the assembly, the inlet and the outlet of the By-Pass valve have to coincide with the inlet and the outlet of the pump.

Technical data:

- The By-Pass valve is piloted with a 12 or 24V electric signal. A electric line has to be install on the vehicle up to the By-Pass valve.
- On working mode of your hydraulic equipment, the By-Pass valve is switch on.
- On non working mode of your hydraulic equipment, the By-Pass valve is switch off.
- A manual emergency system allows to keep the power of your hydraulic equipment in case of electric failure.
- If the distributor of your installation limits the oil return to the tank at less than 5l/mn or if the distributor is “close-center”, a drain hose has to be install between the By-Pass valve and the tank to assure a sufficient oil circulation.

CHARACTERIS-TICS	BP63 0517931	BP80 0522140	BP63 0521180	BP80 0522235	BPA32 0518755	BPA63 0518520	BPA32 0521710	BPA63 0521715
Tension (V)	24	24	12	12	12	12	24	24
P max. peak (bar)	400	400	400	400	400	400	400	400
P max. continuous (bar)	350	350	350	350	350	350	350	350
Weight (Kg)	3.6	3.6	3.6	3.6	3.6	3.6	3.6	3.6
Tightness	IP65	IP65	IP65	IP65	IP65	IP65	IP65	IP65
Function	Normally open	Normally open	Normally open	Normally open	Normally open	Normally open	Normally open	Normally open
Width (mm)	118	118	118	118	118	118	118	118
Height (mm)	186.5	186.3	186.3	186.3	186.3	186.3	186.3	186.3
Thickness (mm)	67	69	67	69	67	67	67	67
Ø Tightening	3/4"	1"	3/4"	1"	3/4"-16UNF-2B	1" 1/16UNF-2B	3/4"-16UNF-2B	1" 1/16UNF-2B
Tightening outlet (Nm)	50	100	50	100	50	50	50	50
Tightening inlet (Nm)	25	25	25	25	25	25	25	25

