

*TECHNICAL DATA SHEETS*  
*and*  
*RECOMMENDATIONS*

**ABER**

Manufacturing Hydraulic Excellence since 1972

[www.ABER.pt](http://www.ABER.pt)



# BENT AXIS PISTON PUMPS RECOMMENDATIONS BEFORE START-UP



## Manufacturer's Declaration

ABER ensures compliance of its products with the essential health and safety requirements of the harmonized standards EN ISO 12100:2010 and EN 809:1998+A1:2009.

## General information

BI pumps are axial piston pumps with single and double fixed displacement. They are available from 25 to 172 cm<sup>3</sup>/rot. and with a maximum pressure of 400bar. They can be assembled directly into the PTO's, with the exception of the PTO's of two shafts without support.

Features:

- high precision
- good performance
- small dimensions
- light
- robust
- low environmental temperatures
- low noise
- low weight
- changeable direction of rotation without risk of breaking the pump

## Pump selection

To ensure that the PTO will not be overloaded, and get the correct flow requirements with the speed of the engine chosen, it is important to use a pump with the right capacity. Pump capacity (D), expressed in cm<sup>3</sup>/rot, can be calculated using the following formula:

$$D = \frac{Q \times 1000}{N \times Z}$$

D-Pump displacement [cm<sup>3</sup>/rot]

Q-Flow required [l/min]

N-Motor speed

Z-Engine to PTO ratio

In order to not overload the PTO's mechanical units, it is important to calculate the torque and power consumed by the pumps. Torque and power are calculated with the following expressions:

$$M = \frac{D \times P_b}{63} \quad P = \frac{D \times N \times Z \times P_b}{600 \times 0,95 \times 1000}$$

M-Torque [Nm]

Pb-Pressure [bar]

P-Power [kW]

N-Motor speed [rpm]

Z-PTO ratio

0,95-Pump efficiency (can change from one pump to another)

**ATTENTION**

If the calculated load exceeds the maximum allowed for the PTO, a different combination should be selected.

## Hose selection

In order to avoid intense heat generation and cavitation phenomenon that causes noise and deterioration of the pump ABER recommends the following speeds and dimensions of the hoses. Inlet pressure range is from 0,8 to 2 bar abs.

|             |           |
|-------------|-----------|
| Inlet hose  | Max. 1m/s |
| Outlet hose | Max. 5m/s |

| Inlet Hose   |                               |
|--------------|-------------------------------|
| Flow (l/min) | Internal pipe diameter (inch) |
| 30-50        | 1"1/2                         |
| 50-70        | 1"3/4                         |
| 70-90        | 2"                            |
| 90-110       | 2"1/4                         |
| 110-140      | 2"1/2                         |
| 140-170      | 2"3/4                         |
| 170-200      | 3"                            |
| 200-240      | 3"1/4                         |

| Flow (l/min) | Outlet Hose                   |         |         |         |         |
|--------------|-------------------------------|---------|---------|---------|---------|
|              | Internal pipe diameter (inch) |         |         |         |         |
| 30           | 1/2"                          | 1/2"    | 1/2"    | 1/2"    | 1/2"    |
| 40           | 5/8"                          | 1/2"    | 1/2"    | 1/2"    | 1/2"    |
| 50           | 5/8"                          | 5/8"    | 5/8"    | 1/2"    | 1/2"    |
| 60           | 3/4"                          | 5/8"    | 5/8"    | 5/8"    | 5/8"    |
| 70           | 1"                            | 3/4"    | 3/4"    | 5/8"    | 5/8"    |
| 80           | 1"                            | 3/4"    | 3/4"    | 3/4"    | 3/4"    |
| 90           | 1"                            | 1"      | 1"      | 3/4"    | 3/4"    |
| 100          | 1"                            | 1"      | 1"      | 1"      | 3/4"    |
| 110          | 1"                            | 1"      | 1"      | 1"      | 1"      |
| 120          | 1"                            | 1"      | 1"      | 1"      | 1"      |
| 130          | 1"                            | 1"      | 1"      | 1"      | 1"      |
| 140          | 1"1/4                         | 1"      | 1"      | 1"      | 1"      |
| 150          | 1"1/4                         | 1"      | 1"      | 1"      | 1"      |
| 160          | 1"1/4                         | 1"1/4   | 1"      | 1"      | 1"      |
| 170          | 1"1/4                         | 1"1/4   | 1"      | 1"      | 1"      |
| 180          | 1"1/4                         | 1"1/4   | 1"1/4   | 1"      | 1"      |
| 190          | 1"1/4                         | 1"1/4   | 1"1/4   | 1"      | 1"      |
| 200          | 1"1/2                         | 1"1/4   | 1"1/4   | 1"1/4   | 1"      |
| 210          | 1"1/2                         | 1"1/4   | 1"1/4   | 1"1/4   | 1"1/4   |
| 220          | 1"1/2                         | 1"1/4   | 1"1/4   | 1"1/4   | 1"1/4   |
| 230          | 1"1/2                         | 1"1/2   | 1"1/4   | 1"1/4   | 1"1/4   |
|              | 50-100                        | 100-150 | 150-200 | 200-300 | 300-350 |
|              | P (bar)                       |         |         |         |         |

**ATTENTION**

The recommended speeds and dimensions specified may not be enough when the temperatures are too low, the tank is below the level of the pump, the inlet hose is long or there are many valves and fittings in the inlet hosing. In these cases we recommend increasing the diameter of the hoses and reducing the pump rotation speed.

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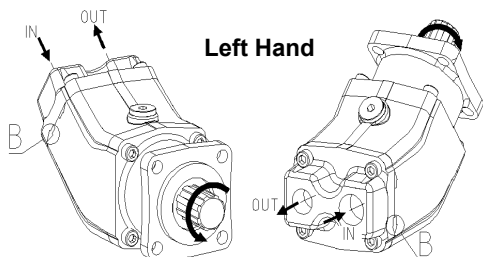
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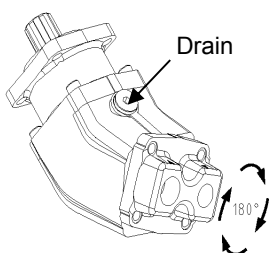
# BENT AXIS PISTON PUMPS RECOMMENDATIONS BEFORE START-UP

## Direction of rotation

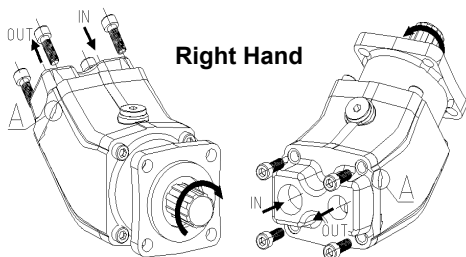
1. Check PTO direction of rotation.
2. The direction of rotation of the pump must be according to the PTO rotation. ABER normally supplies pumps with left hand rotation, change it if needed.



2.1. Fully unscrew the four end cover



2.2. Turn the connection cover 180°



2.3. Screw again the four screws:  
 -torque BI\_M / BI\_M7 = 80Nm  
 -torque BI\_P / BI\_P7 / BI\_H9 = 110Nm

3. Grease spline shaft with solid lubricant before installation. Connect the pump to the PTO (apply 80Nm torque in the tightening nuts). High efforts or shocks are not recommended during the installation. The pump must be connected without making use of any type of tool that forces its assembly. In driving gear application and couplings use circlips and/ or washers with one M10 screw and locking fluid (70Nm).

### ATTENTION

During the installation always leave the inlet port in a higher or equal level than outlet port. This increases the pump life.

4. Remove all protection covers from the threaded holes (inlet/outlet). Apply the inlet and outlet fittings into the pump (query the tightening informations from the fittings manufacturer). Connect the outlet and the inlet pipes to the accessories (always respect recommended hoses dimensions and thread dimensions). Be sure that all connections are robust and well-sealed.

5. Before start-up, the housing must be filled with the same hydraulic fluid used in the system. Re-fit drain plug and torque to 50Nm.



## Fluids

For BI pumps range, ABER recommends the use of high quality mineral oil type ISO HM or DIN 51524-2 HLP, with viscosities from 20 to 40mm<sup>2</sup>/s (cSt) at working temperature. The working viscosity limits stay between minimum 10mm<sup>2</sup>/s (cSt) and maximum 400mm<sup>2</sup>/s (cSt). In situations, when the viscosities stay between 400mm<sup>2</sup>/s (cSt) and 1500mm<sup>2</sup>/s (cSt), the system can be turned on, but cannot be loaded. It is possible to use other oils with the same characteristics, but only after consulting and getting authorization from ABER. The designation 32, 46, 68, etc. denotes the viscosity at 40°C of the oil. When choosing the oil it is necessary to be aware of the low viscosity with the increase of the temperature. Therefore, we recommend that when you want to work above that temperature, you should choose an oil with more viscosity (thicker) in order to compensate the reduction of viscosity when the temperature increases. The maximum temperature allowed in the circuit is 75°C. We advise you to use an oil cooler when you verify that the system's temperature is about or higher than these values. The oil must be replaced after 1000 working hours or at least once a year, change filters elements as well.

## Drain line

BI pumps range is of fixed flow and do not need to use an exterior drain line because they are drained from the inside. If they are to be applied in an engine PTO, it is mandatory to use a by-pass valve and it is recommendable the use of a drain line directly from the by-pass valve to the oil tank.

## Filtration

The filtration is extremely important and may influence or even determine the life of the equipment. ABER recommends the use of a return filter and an air filter with an absolute filtration degree of 10µm, as according to the ISO 4406 class 18/13. The first filter to be applied into the system must be replaced as soon as it reaches the 50 working hours; after the first replacement, it must be replaced along with the oil or when pressures out of the common are verified in the return.

### ATTENTION

Be sure that the whole system is perfectly cleaned before filling it with oil. Never mix water or other liquids, different oil qualities, viscosities or brands with the oil in the system. If any oil leaks out from below the nameplate of the pump, stop the system immediately to determine the cause of the leak and correct the problem source. Make shore that there was no gearbox contamination.

CTI Bent axis piston pumps recommendations before start-up 1405- 2

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## BENT AXIS PISTON PUMPS RECOMMENDATIONS BEFORE START-UP

### Faults; cause and remedies

| Faults  | Cause  | Remedies  |
|---|--|---|
| No oil flow                                       | <ol style="list-style-type: none"> <li>1. Empty tank</li> <li>2. Closed valve in inlet hose</li> <li>3. Air in inlet hose</li> <li>4. Wrong sense of rotation</li> <li>5. Reversed hoses</li> <li>6. No input power</li> <li>7. Pump damaged</li> </ol>      | <ol style="list-style-type: none"> <li>1. Fill tank with recommended fluid</li> <li>2. Open valve</li> <li>3. Put tank above the pump level</li> <li>4. Change rotation sense</li> <li>5. Reverse hoses</li> <li>6. Replace power source or other damaged equipment</li> <li>7. Replace pump</li> </ol>   |
| Equipment works with irregular movements          | <ol style="list-style-type: none"> <li>1. Air in housing</li> <li>2. Air leakage in inlet hose</li> <li>3. Low oil level</li> <li>4. Pump damaged</li> </ol>   | <ol style="list-style-type: none"> <li>1. Fill housing with recommended fluid</li> <li>2. Repair air leakage</li> <li>3. Fill tank with recommended fluid</li> <li>4. Replace pump</li> </ol>   |
| Pump is noisy                                     | <ol style="list-style-type: none"> <li>1. Small diameter hose</li> <li>2. Restriction in inlet hose</li> <li>3. Very thick oil</li> <li>4. Air in inlet hose</li> <li>5. Pump damaged</li> </ol>   | <ol style="list-style-type: none"> <li>1. Replace inlet hose for other with a larger diameter</li> <li>2. Remove restrictions</li> <li>3. Replace for an recommended fluid</li> <li>4. Put tank above the pump level, check air pressure in the tank</li> <li>5. Replace pump</li> </ol>  |
| Oil is too hot                                    | <ol style="list-style-type: none"> <li>1. Low oil level</li> <li>2. Small tank</li> <li>3. Dirty oil</li> <li>4. Relief valve improperly set</li> <li>5. Relief valve stuck in open position</li> <li>6. Very thick oil</li> <li>7. Too much flow</li> </ol> | <ol style="list-style-type: none"> <li>1. Fill tank with recommended fluid</li> <li>2. Replace for a bigger tank</li> <li>3. Replace oil and filter</li> <li>4. Adjust for equipment specifications or replace if necessary</li> <li>5. Clean and re-set for equipment specifications</li> <li>6. Replace for an recommended fluid</li> <li>7. Reduce speed or replace for a smaller displacement pump</li> </ol> |
| Equipment works very slow compared with the usual | <ol style="list-style-type: none"> <li>1. Relief valve improperly set</li> <li>2. Relief valve stuck in open position</li> <li>3. Pump damaged</li> </ol>  | <ol style="list-style-type: none"> <li>1. Adjust for equipment specifications or replace if necessary</li> <li>2. Clean and re-set for equipment specifications</li> <li>3. Replace pump</li> </ol>   |
| Oil leakage                                       | <ol style="list-style-type: none"> <li>1. From inlet/outlet lines</li> <li>2. From below the nameplate</li> <li>3. From body sections</li> </ol>   | <ol style="list-style-type: none"> <li>1. Tighten fittings and hoses, or replace if necessary</li> <li>2. Stop the system immediately to determine the cause of the leak and correct the problem source</li> <li>3. Tighten bolts for specified torque, or replace damaged o'ring or body</li> </ol>  |



When the pump is working, never touch or pull hoses or intermediate shaft when applied. When intermediate shaft is applied take into account that parts can be ejected.

The application of the pumps must follow all the instructions hereby mentioned in order to assure the safety of all personal working with the equipment including its surroundings, assure a long life to the product and preserve the warranty of the brand. All applications that do not follow the hereby instruction are solely the users responsibility. If there should happen any malfunctioning, it is strictly forbidden the disassembly of the product except if it is being made by a qualified technician of the brand or if there is a special authorization to do that. If this specification should not be followed, all warranties might be lost.

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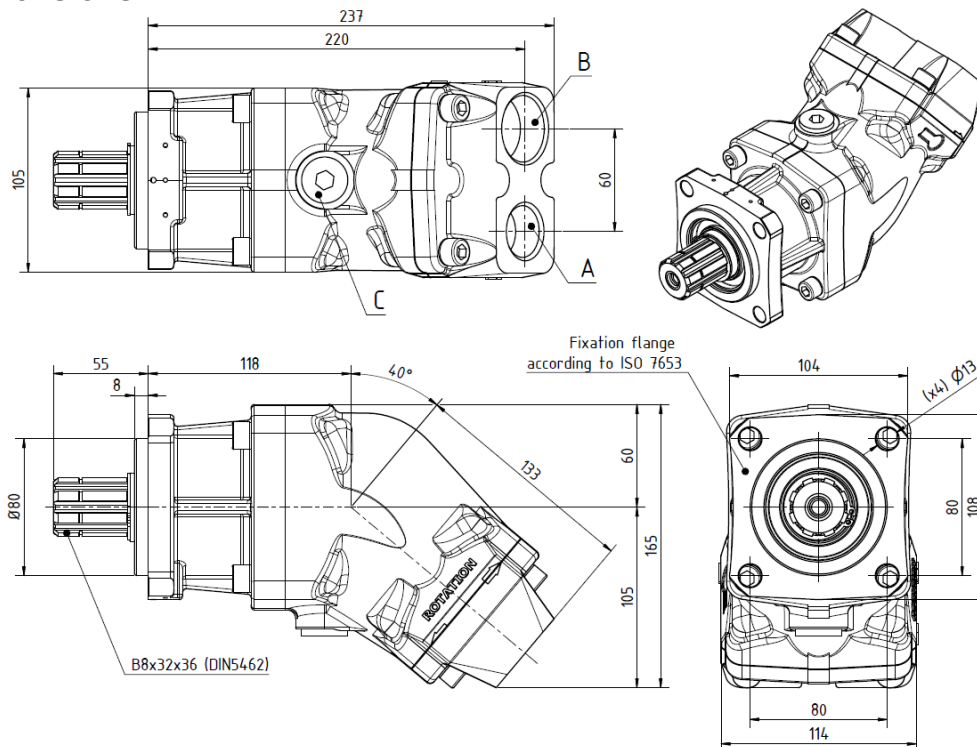
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# OIL-HYDRAULIC PISTON PUMP IRON CAST BENT AXIS PUMP

Ref. BIF M

## Main Dimensions



(Dimensions in mm)

## Main Data

| Pumps BIF                                     | 17M        | 25M      | 30M      | 40M      | 50M      |
|---|------------|----------|----------|----------|----------|
| Displacement (cm <sup>3</sup> /rot.)          | 17.5       | 26       | 32       | 42       | 50       |
| Operating pressure (bar) (up to)              | 400        | 400      | 400      | 400      | 400      |
| Peak pressure (bar)                           | 450        | 450      | 450      | 450      | 450      |
| Operating rotation <sup>1</sup> (rpm)         | 2500       | 2500     | 2300     | 2300     | 2300     |
| Max. rotation without load <sup>1</sup> (rpm) | 3200       | 3200     | 3000     | 3000     | 3000     |
| Weight (approx.) (kg)                         | 11.6       | 11.8     | 12       | 12.2     | 12.3     |
| Pistons quantity                              | 5          |          |          |          |          |
| A-Oil outlet (DIN ISO 228)                    | 3/4" BSP   | 3/4" BSP | 3/4" BSP | 3/4" BSP | 3/4" BSP |
| B-Oil inlet (DIN ISO 228)                     | 1" BSP     | 1" BSP   | 1" BSP   | 1" BSP   | 1" BSP   |
| C   | Drain hole |          |          |          |          |

### How to order:

**Example:** Pump 50cm<sup>3</sup>/rot; operating pressure up to 400 bar; peak pressure 450 bar, ref. BIF M → BIF50M

|  |  |
|--|--|
| Fluids                                 | mineral oils type ISO HM or DIN 51524-2 HLP              |
| Recommended viscosity range            | 20 to 40 cSt (mm <sup>2</sup> /s) at working temperature |
| Limits viscosity range                 | 10 to 750 cSt (mm <sup>2</sup> /s)                       |
| Start-up viscosity range, without load | 750 to 1500 cSt (mm <sup>2</sup> /s)                     |
| Filtration                             | 10µm ISO4406 18/13                                       |
| Inlet pressure range                   | 0,7 to 2 bar abs   |

In the application of any of these pumps; the use of these data does not exempt the reading of the instruction "BI pumps recommendations before start-up"

<sup>1</sup> These values are valid at an absolute pressure of 1 bar in suction port when operating with a mineral oil at a viscosity of 30 mm<sup>2</sup>/s (cSt).

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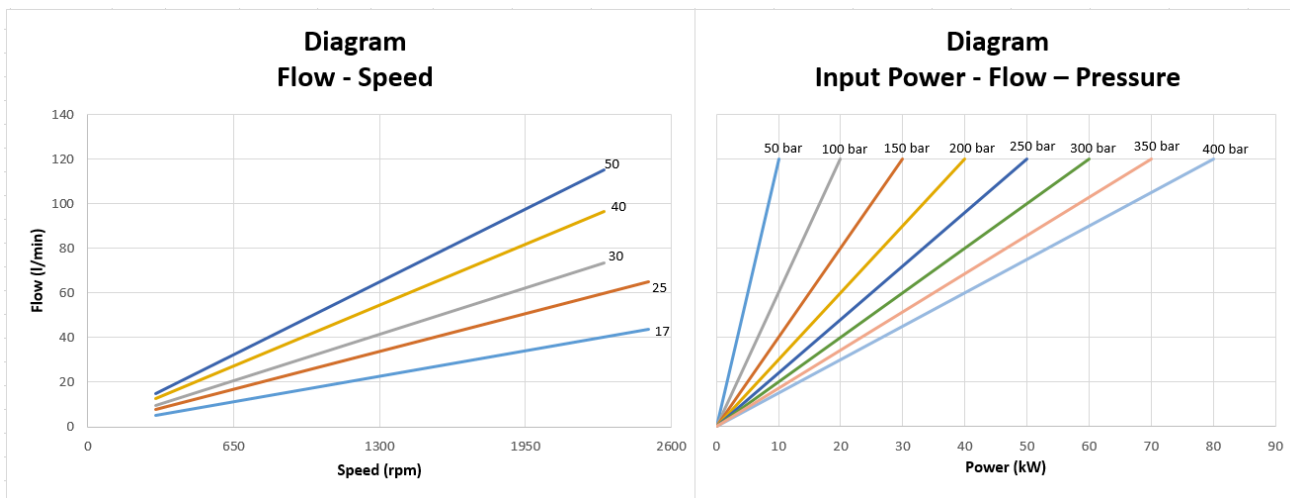


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# OIL-HYDRAULIC PISTON PUMP IRON CAST BENT AXIS PUMP

Ref. BIF M



## Hose dimensions

| Inlet Hose   |                               |
|--------------|-------------------------------|
| Flow (l/min) | Internal pipe diameter (inch) |
| 20-30        | 1"1/4                         |
| 30-40        | 1"1/4                         |
| 50-60        | 1"1/2                         |
| 70-90        | 1"3/4                         |
| 100-120      | 2"                            |

| Outlet Hose  |                               |         |         |         |         |
|--------------|-------------------------------|---------|---------|---------|---------|
| Flow (l/min) | Internal pipe diameter (inch) |         |         |         |         |
|              | 20                            | 1/2"    | 1/2"    | 1/2"    | 1/2"    |
| 30           | 1/2"                          | 1/2"    | 1/2"    | 1/2"    | 1/2"    |
| 40           | 5/8"                          | 1/2"    | 1/2"    | 1/2"    | 1/2"    |
| 50           | 5/8"                          | 5/8"    | 5/8"    | 1/2"    | 1/2"    |
| 60           | 3/4"                          | 5/8"    | 5/8"    | 5/8"    | 5/8"    |
| 70           | 1"                            | 3/4"    | 3/4"    | 5/8"    | 5/8"    |
| 80           | 1"                            | 3/4"    | 3/4"    | 3/4"    | 3/4"    |
| 90           | 1"                            | 1"      | 1"      | 3/4"    | 3/4"    |
| 100          | 1"                            | 1"      | 1"      | 1"      | 3/4"    |
| 110          | 1"                            | 1"      | 1"      | 1"      | 1"      |
|              | 50-100                        | 100-150 | 150-200 | 200-300 | 300-350 |
|              | <b>P (bar)</b>                |         |         |         |         |

### Important notes:

- To install one of these pumps, please consult and respect the instruction "BI pumps recommendations before start-up";
- Other axis available, please consult "Axel options".

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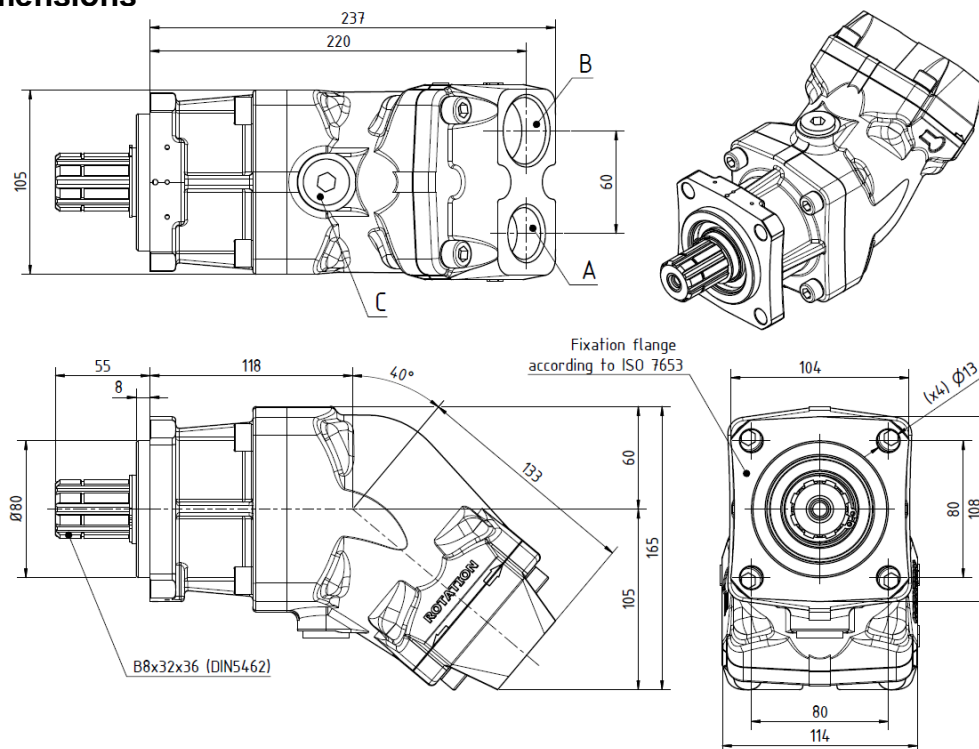
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# OIL-HYDRAULIC BENT PUMP AXIAL PISTONS

Ref. BIF M7

## Main Dimensions



(Dimensions in mm)

## Main Data

| Pumps BIF                                     | 60M7       | 80M7       |
|---|------------|------------|
| Displacement (cm <sup>3</sup> /rot.)          | 60         | 81         |
| Operating pressure (bar) (up to)              | 400        | 350        |
| Peak pressure (bar)                           | 450        | 400        |
| Operating rotation <sup>1</sup> (rpm)         | 2000       | 1500       |
| Max. rotation without load <sup>1</sup> (rpm) | 2600       | 2000       |
| Weight (approx.) (kg)                         | 12.8       | 12.8       |
| Pistons quantity                              | 7          |            |
| A-Oil outlet (DIN ISO 228)                    | 3/4" BSP   | 1" BSP     |
| B-Oil inlet (DIN ISO 228)                     | 1" BSP     | 1 1/4" BSP |
| C   | Drain hole |            |

### How to order:

**Example:** Pump 80cm<sup>3</sup>/rot, operating pressure up to 350 bar; peak pressure 400 bar, ref. BIF M7 → BIF80M7

|  |  |
|--|--|
| Fluids                                 | mineral oils type ISO HM or DIN 51524-2 HLP              |
| Recommended viscosity range            | 20 to 40 cSt (mm <sup>2</sup> /s) at working temperature |
| Limits viscosity range                 | 10 to 750 cSt (mm <sup>2</sup> /s)                       |
| Start-up viscosity range, without load | 750 to 1500 cSt (mm <sup>2</sup> /s)                     |
| Filtration                             | 10µm ISO4406 18/13                                       |
| Inlet pressure range                   | 0,8 to 2 bar abs   |

In the application of any of these pumps; the use of these data does not exempt the reading of the instruction "BI pumps recommendations before start-up"

<sup>1</sup> These values are valid at an absolute pressure of 1 bar in suction port when operating with a mineral oil at a viscosity of 30 mm<sup>2</sup>/s (cSt).

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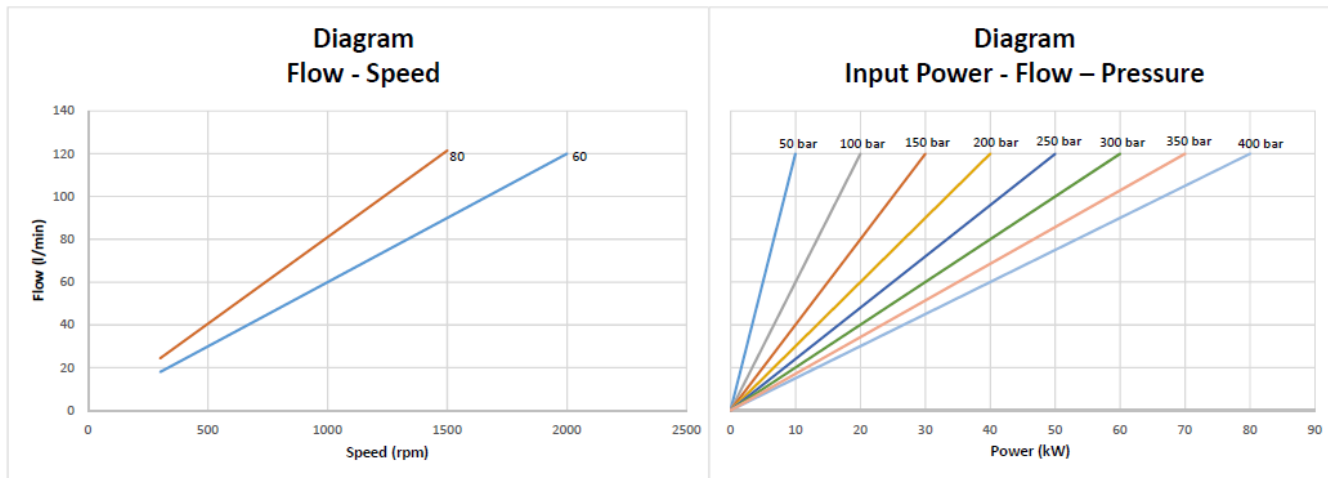


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# OIL-HYDRAULIC PISTON PUMP IRON CAST BENT AXIS PUMP

Ref. BIF M7



## Hose dimensions

| Inlet Hose   |                               |
|--------------|-------------------------------|
| Flow (l/min) | Internal pipe diameter (inch) |
| 30-40        | 1"1/4                         |
| 50-60        | 1"1/2                         |
| 70-90        | 1"3/4                         |
| 100-120      | 2"                            |
| 130-150      | 2"1/4                         |

| Outlet Hose  |                               |         |         |         |         |
|--------------|-------------------------------|---------|---------|---------|---------|
| Flow (l/min) | Internal pipe diameter (inch) |         |         |         |         |
|              | 30                            | 1/2"    | 1/2"    | 1/2"    | 1/2"    |
| 40           | 5/8"                          | 1/2"    | 1/2"    | 1/2"    | 1/2"    |
| 50           | 5/8"                          | 5/8"    | 5/8"    | 1/2"    | 1/2"    |
| 60           | 3/4"                          | 5/8"    | 5/8"    | 5/8"    | 5/8"    |
| 70           | 1"                            | 3/4"    | 3/4"    | 5/8"    | 5/8"    |
| 80           | 1"                            | 3/4"    | 3/4"    | 3/4"    | 3/4"    |
| 90           | 1"                            | 1"      | 1"      | 3/4"    | 3/4"    |
| 100          | 1"                            | 1"      | 1"      | 1"      | 3/4"    |
| 110          | 1"                            | 1"      | 1"      | 1"      | 1"      |
| 120          | 1"                            | 1"      | 1"      | 1"      | 1"      |
| 130          | 1"                            | 1"      | 1"      | 1"      | 1"      |
| 140          | 1"1/4                         | 1"      | 1"      | 1"      | 1"      |
| 150          | 1"1/4                         | 1"      | 1"      | 1"      | 1"      |
|              | 50-100                        | 100-150 | 150-200 | 200-300 | 300-350 |
|              | <b>P (bar)</b>                |         |         |         |         |

### Important notes:

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- Other axis available, please consult "Axel options".

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