Series 10 Steering Control Unit
Parts and Repair Information

Design -002
Series 10
Steering Control Unit

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Introduction

This manual provides service information for Char-Lynn® Series 10 Steering Control Units. Step by step instructions for complete disassembly, inspection and reassembly of the control unit are given.

The following recommendations should be followed to insure successful repairs.

• Most repairs require the removal of the control unit from the vehicle.
• Cleanliness is extremely important.
• Clean the port areas thoroughly before disconnecting the hydraulic lines.
• Plug the control unit ports and cover open hydraulic lines immediately after they have been disconnected.
• Drain the oil and clean the exterior of the control unit before making repairs.
• Wash all metal parts in clean solvent.
• Use filtered, moisture-free compressed air to dry the parts. Do not wipe them dry with paper towels or cloth – lint in a hydraulic system will cause damage.
• Always use new seals when reassembling hydraulic control units.
• Lubricate new rubber seals with a petroleum jelly before installation.
• Torque all bolts over gasketed joints, then repeat the torquing sequence to make up for gasket compression.

After all repairs are complete it is essential to verify the accuracy of control unit repairs on an authorized test stand.
How to Order Replacement Parts

Each order must include the following:

1. Product Number
2. Date Code
3. Part Name
4. Part Number
5. Quantity of Parts

Refer to specific part listings for your Char-Lynn® Steering Control Unit when ordering replacement parts. Listings are available from Eaton. Sample tag shows identification.

When ordering replacement parts, you must include the following information:

For additional literature contact Eaton Hydraulics at
14615 Lone Oak Road,
Eden Prairie, MN 55344
http://hydraulics.eaton.com

Tools Required For Disassembly and Assembly

- Screwdriver (102-152 mm [4 in. - 6 in.] long, x 3 mm [1/8 in.] wide flat blade).
- 1/2 inch socket for current hex head cap screws.
- Breaker bar wrench.
- Torque wrench (30 Nm [300 lb-in] capacity).

Special Tools:

- Plunger and Sleeve Tool No. 600792-001*

*Tools available—by special order—through our service department.
*Anti-cavitation valve parts will vary according to configuration.
### Table 1.0 Parts List

#### Series 10 Steering Control Unit

<table>
<thead>
<tr>
<th>ITEM NO.</th>
<th>PART NO.</th>
<th>QTY.</th>
<th>DESCRIPTION</th>
<th>PAGE</th>
</tr>
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<tr>
<td>1</td>
<td>See Table 1.0</td>
<td>7</td>
<td>Cap Screw, Hex Head</td>
<td>6</td>
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<tr>
<td>2</td>
<td>23901-000</td>
<td>1</td>
<td>Cap, End</td>
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<td>3</td>
<td>5776-000</td>
<td>3</td>
<td>Seal, 72,6 mm [2.86 in.] ID</td>
<td>6</td>
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<td>4</td>
<td>See Table 1.0</td>
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<td>Gerotor, Sub-assembly</td>
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<td>5</td>
<td>113094-000</td>
<td>1</td>
<td>Plate, Spacer</td>
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<td>6</td>
<td>112238-000</td>
<td>1</td>
<td>Drive</td>
<td></td>
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<td>7</td>
<td>204107-XXX</td>
<td>1</td>
<td>Housing, Valve</td>
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<td>8a</td>
<td>14880-000</td>
<td>1</td>
<td>Control Sleeve</td>
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<tr>
<td>8b</td>
<td>1</td>
<td>1</td>
<td>Control Spool</td>
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<td>9</td>
<td>15-000</td>
<td>1</td>
<td>Pin, Centering</td>
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<td>10</td>
<td>112714-000</td>
<td>2 or 3</td>
<td>Spring, Spacer</td>
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<td>11</td>
<td>113599-000</td>
<td>4 or 6</td>
<td>Spring, Centering</td>
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<td>Retainer Spring</td>
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<td>14880-000</td>
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<td>Bearing Race</td>
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<td>Bearing, Needle Thrust</td>
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<td>Seal – 24,9 mm [.98 in.] ID</td>
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<td>844-000</td>
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<td>Dust Seal</td>
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<td>18</td>
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<td>Pin, Roll – 34,92 mm [1.375 in.] Length</td>
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<td>19</td>
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<td>Ball – 6,35 mm [.25 in.] OD</td>
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<tr>
<td>23</td>
<td>230490-000 or 4999516-000</td>
<td>2</td>
<td>Compression Spring</td>
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</tr>
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<td>24</td>
<td>113596-000</td>
<td>2</td>
<td>Anti-cav plug retainer</td>
<td></td>
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<td>25</td>
<td>230313-000</td>
<td>2</td>
<td>Compression Spring</td>
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<td>60</td>
<td>4999651-001</td>
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<td>O-ring</td>
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</table>
Disassembly

Cleanliness is extremely important when repairing a steering control unit. Work in a clean area. Before disconnecting lines, clean port area of unit thoroughly. Use a wire brush to remove foreign material and debris from around exterior joints of the unit.

We recommend that you keep the unit in a vise during disassembly. Follow the clamping procedures explained throughout the manual.

1. Clamp unit in vise, meter end up. Clamp lightly on edges of port face sides (see figure 1). Use protective material on vise jaws. Housing distortion could result if jaws are overtightened.

### Table 2.0

<table>
<thead>
<tr>
<th>ACTUAL DISPL.</th>
<th>REF. NO. 4 GEROTOR PART NO. Width mm[in]</th>
<th>REF. NO. 29 CAP SCREW PART NO. LENGTH mm[in]</th>
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<tr>
<td>cm³/r [in³/r]</td>
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<td></td>
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<tr>
<td>60 [3.8]</td>
<td>8618-023 10.2 [.40]</td>
<td>16336-514 38.1 [1.50]</td>
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<tr>
<td>75 [4.5]</td>
<td>8618-024 10.2 [.40]</td>
<td>16336-514 38.1 [1.50]</td>
</tr>
<tr>
<td>95 [5.9]</td>
<td>8618-003 13.2 [.52]</td>
<td>16336-515 41.3 [1.62]</td>
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<td>120 [7.3]</td>
<td>8618-009 16.5 [.65]</td>
<td>16336-516 44.5 [1.75]</td>
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<td>145 [8.9]</td>
<td>8618-020 20.1 [.78]</td>
<td>16336-517 47.6 [1.87]</td>
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<td>160 [9.7]</td>
<td>8618-004 21.9 [.86]</td>
<td>16336-520 50.8 [2.00]</td>
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<td>185 [11.3]</td>
<td>8618-005 25.4 [1.00]</td>
<td>16336-521 54.0 [2.12]</td>
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<td>295 [17.9]</td>
<td>8618-035 40.4 [1.59]</td>
<td>16336-525 66.7 [2.62]</td>
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<td>370 [22.6]</td>
<td>8618-032 50.8 [2.00]</td>
<td>16336-531 79.4 [3.12]</td>
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<td>460 [28.2]</td>
<td>8618-033 63.5 [2.50]</td>
<td>16336-535 92.0 [3.62]</td>
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<td>590 [35.9]</td>
<td>8618-036 80.8 [3.18]</td>
<td>16336-542 108.0 [4.25]</td>
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<tr>
<td>740 [45.1]</td>
<td>8618-034 101.6 [4.00]</td>
<td>16336-551 130.2 [5.12]</td>
</tr>
</tbody>
</table>

Gerotor (Meter) End

25 mm [1 inch] Max.

Figure 1

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Disassembly

2. Remove 5/16 in. cap screws.
3. Remove end cap.
4. Remove seal from gerotor (meter).

5. Remove gerotor (meter). Be careful not to drop star.
6. Remove seal from spacer plate.
7. Remove spacer plate.
8. Remove seal from housing.
9. Pull drive and twist to remove SP/SL drive assembly from housing.
10. Remove housing from vise.

Attention: Do not bind spool and sleeve in housing. Rotate spool and sleeve assembly slowly when removing it from housing.
Disassembly

11. Carefully remove bearing and races, anti-cavitation valves and manual steering check valve (roll pin and ball) from bolt holes by tipping housing Gerotor side down. (see figure 3).
12. Do not remove any valves other than manual steering check valve assembly and anti-cavitation valve assembly. All other valves are factory preset and are non-serviceable.
13. Carefully Remove Seal with a thin-blade screw driver. Do not scratch seal groove with screw driver.
14. Use thin bladed screw driver to pry dust seal from housing. Do not damage housing.
15. Push pin from spool and sleeve assembly.
16. Remove Drive
17. Push spool partially from control end of sleeve, then carefully remove centering springs and retaining ring from spool by hand (figure 8).

*Note
Standard input torque unit uses six centering springs and two spacers.
Medium input torque unit uses four centering springs and three spacers.
Low input torque unit uses four centering springs and two spacers.
Assembly

Assembly Cleanliness
Recommendations
Check all mating surfaces. Replace any parts that have scratches or burrs that could cause leakage. Clean all metal parts in clean solvent. Blow dry with air. Do not wipe dry with cloth or paper towel because lint or other matter can get into the hydraulic system and cause damage. Do not use grit paper or file or grind these parts.

Note: Lubricate all seals with clean petroleum jelly. A good service policy is to replace all old seals with new seals. Do not use excessive lubricant on seals for meter section.

Refer to parts lists covering your steering control unit when ordering replacement parts.

Place housing on a flat work area on a clean lint free cloth. Install press-fit 24.9 mm [.98 in.] ID seal in housing with metal surface of seal facing toward housing (figure 6).

2-Piece Shaft Seal Installation
For installation of o-ring: 4999651-001
and
Seal 9332-000

1. Place housing on a flat work area as shown in figure 7.

2. Lubricate seal and o-ring with hydraulic oil before installation.

3. Align sleeve with housing bore (figure 7)
Assembly
2-Piece Shaft Seal Installation

4. Insert sleeve into housing bore (Figure 8).

5. Place o-ring on plunger (Figure 9).

6. Align seal with plunger. Cross section "L" shape of seal should be upside down (figure 10).

7. Push seal onto plunger. Lip of seal should be between o-ring and plunger. No gap should exist between o-ring and seal (figure 11).

8. Align plunger with sleeve (figure 12).

9. Push plunger into sleeve until it bottoms out, rotate 1/4 turn (figure 13).

10. While holding sleeve in housing, withdraw plunger.

11. Withdraw sleeve.

12. Inspect seal installation. Seal and o-ring must both be within shaft seal counterbore of housing (figure 14).
13. Clamp housing in Vice (figure 15).

14. Install two bearing races and Thrust bearing as shown in figure 16.

15. Assemble spool and sleeve carefully so that spring slots line up at the same end. Rotate spool while sliding parts together. Test for free rotation. Spool should rotate smoothly in sleeve with fingertip force applied at splined end. Align spring slots and identification marks (Figure 17) in spool and sleeve and stand parts on end of bench.
16. Installation of spring spacers and springs, hold spring retainer at an angle as shown (see figure 18 reference number 1), insert spring spacers and springs one at a time in sequence noted by reference numbers 2 - 9 (standard torque), 2 - 8 (medium torque), 2 - 7 (low torque), then position spring retainer correctly over all these parts. Adjust alignment of spring parts with a small screwdriver.

17. Assemble drive and spool/sleeve.

18. Insert pin through spool and sleeve assembly through hole in drive, until pin is flush at both sides of sleeve.
19. Position spool and sleeve assembly so that splined end of spool enters 14 hole end of housing first (figure 20).

**Attention:** While inserting spool and sleeve assembly into housing, make sure parts do not tilt out of position. Push assembly gently into place with slight rotating action. Bring spool assembly entirely within housing bore until parts are flush at 14 hole end of housing. With spool assembly in this flush position, check for free rotation within housing by turning assembly with fingertip force at splined end.

20. Install 72.6 mm [2.86 in.] ID O-ring in housing (figure 20).

21. Install anti-cavitation valves and manual steering check valve (if used) in holes, as shown in figure 20. After installing balls, inspect holes to make sure they are properly seated.
Timing Reference Data —

22. Install spacer plate. Align bolt holes in spacer plate with tapped holes in housing.

23. Lubricate and install 72,6 mm [2.86 in.] ID seal in spacer plate.

24. Install gerotor (meter) seal groove up, note position of star valleys in relation to marked drive.

25. Lubricate and install 72,6 mm [2.86 in.] ID seal in gerotor ring.

26. Lubricate and install 72,6 mm [2.86 in.] ID seal in gerotor (meter).

27. Install end cap on gerotor, aligning holes.

Note: Check to insure that spool and sleeve are flush or slightly below 14 hole surface of housing.

Attention: Clean upper surface of housing by wiping with palm of clean hand. Clean each of the flat surfaces of meter section parts in a similar way just before reassembly. Do not use cloth or paper to clean surfaces.
28. Install 7 dry cap screws in end cap. Pretighten cap screws to 17Nm [150 lb-in], then torque screws to 28-34 Nm [250-300 lb-in] in sequence shown in figure 24.

Figure 23