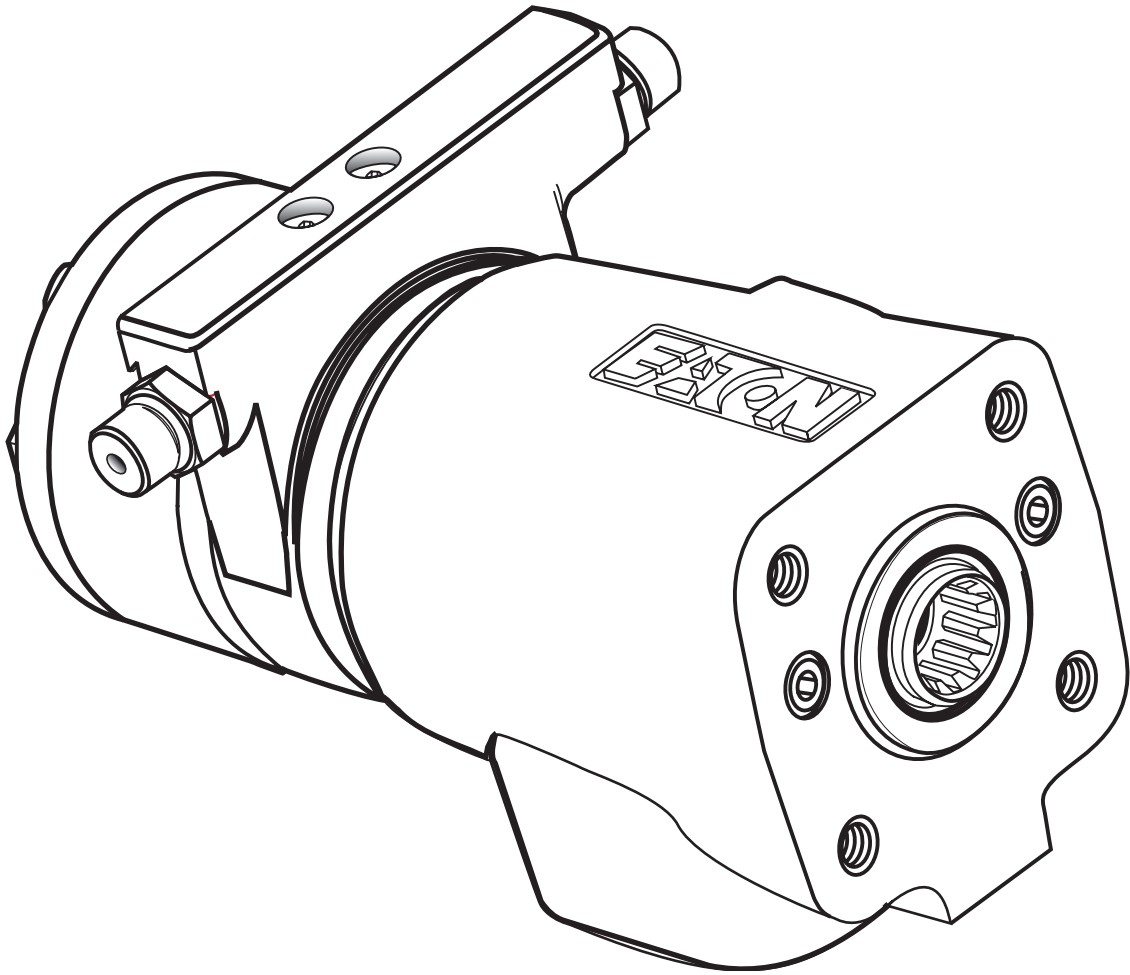




Series 10 VersaSteer™
Parts and Repair Information



Series 10 VersaSteer

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Introduction

This manual provides service information for Char-Lynn® Series 10 VersaSteer™ 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.

ID Tag

Ordering Parts

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® VersaSteer™ Steering Control Unit when ordering replacement parts. Listings are available from Eaton. Sample tag shows identification.

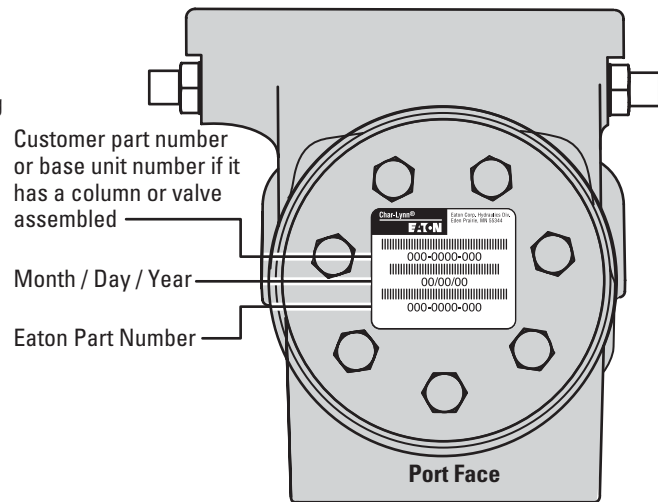
When ordering replacement parts, you must include the following information:

For additional literature contact Eaton Hydraulics at

14615 Lone Oak Road,
Eden Prairie, MN 55344

<http://hydraulics.eaton.com>

Bar Code Label — Launch Date June, 1999



Tools

Tools Required For Disassembly and Assembly

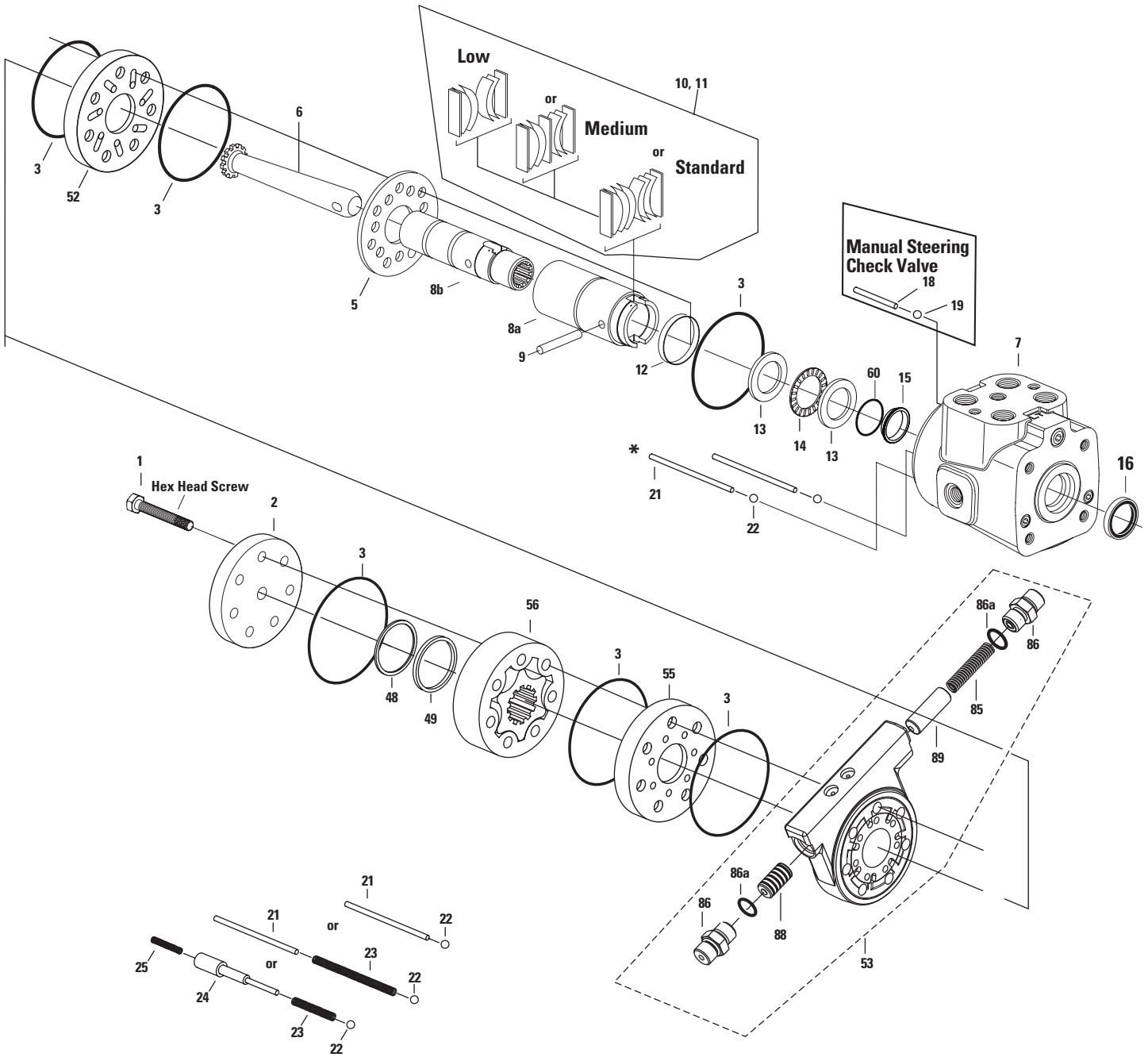
- Screwdriver (102-152 mm [4 in. - 6 in.] long, x 3 mm [1/8 in.] thin flat blade).
- 1/2 inch socket for current hex head cap screws.
- Breaker bar wrench.
- Torque wrench (30 Nm [300 lb-in] capacity).
- 11/16 inch wrench.

Special Tools:

- Plunger and Sleeve Tool No. 600792-001*

*Tools available—by special order—through our service department.

Parts Assembly Drawing



*Anti-cavitation valve parts will vary according to configuration.

Parts

Table 1.0 Parts List

Series 10 VersaSteer

| ITEM NO. | PART NO. | QTY. | DESCRIPTION | REFERENCE PAGE |
|----------|------------------------------|--------|--|----------------|
| 1 | See Table 1.0 | 7 | Cap Screw, Hex Head | 6 |
| 2 | 23901-000 | 1 | Cap, End | |
| 3 | 5776-000 | 6 | Seal, 72,6 mm [2.86 in.] ID | |
| 5 | 113094-000 | 1 | Plate, Spacer | |
| 6 | 4998212-001 | 1 | Drive | |
| 7 | 204107-XXX | 1 | Housing, Valve | |
| 8a | | 1 | Control Sleeve | |
| 8b | | 1 | Control Spool | |
| 9 | 15-000 | 1 | Pin, Centering | |
| 10 | 112714-000 | 2 or 3 | Spring, Spacer | |
| 11 | 113599-000 | 4 or 6 | Spring, Centering | |
| 12 | 112737-000 | 1 | Retainer Spring | |
| 13 | 14880-000 | 2 | Bearing Race | |
| 14 | 5544-000 | 1 | Bearing, Needle Thrust | |
| 15 | 9332-000 | 1 | Seal – 24,9 mm [.98 in.] ID | |
| 16 | 844-000 | 1 | Dust Seal | |
| 18 | 16026-422P | 1 | Pin, Roll– 34,92 mm [1.375 in.] Length | |
| 19 | 285020-080 | 1 | Ball – 6,35 mm [.25 in.] OD | |
| 21 | 16026-436 | 2 | Pin, Roll – 40,00 mm [1.575 in.] Length | |
| 22 | 18015-000 | 2 | Ball, Check – 6,35 mm [.250 in.] OD | |
| 23 | 230400-000 or 4999516-000 | 2 2 | Compression Spring Compression Spring (See main parts assembly drawing) | |
| 24 | 113598-000 | 2 | Anti-cav plug retainer | |
| 25 | 230313-000 | 2 | Compression Spring | |
| 48 | 202038-000 | 1 | Ring, Seal | |
| 49 | 16101-322 | 1 | Ring, Back-up | |
| 52 | 4999016-001 | 1 | Plate, Valve | |
| 53 | 4999092-001 | 1 | Valve S/A | |
| 55 | 4999015-000 | 1 | Plate Valve | |
| 56 | See Table 1.0 | 1 | Gerotor Sub-assembly | 6 |
| 60 | 4999651-001 | 1 | O-ring | |
| 85 | 230397-000 | 1 | Spring, Compression | |
| 86 | 112114-010 | 2 | Fitting | |
| 86a | 250003-906 | 2 | O-Ring | |
| 88 | 4998914-001 | 1 | Piston | |
| 89 | 4992809-001 | 1 | Piston, Guide Spring | |

Parts

Gerotor

Table 1.0

| ACTUAL DISPL. cm ³ /r [in ³ /r] | REF. NO. 4 GEROTOR | | REF. NO. 29 CAP SCREW | |
|--|-----------------------|--------------|--------------------------|---------------|
| | PART NO. | Width mm[in] | PART NO. | LENGTH mm[in] |
| 60 [3.6] | 201234-023 | 10,2 [.40] | 16336-530 | 76,2 [3.00] |
| 75 [4.5] | 201234-024 | 10,2 [.40] | 16336-530 | 76,2 [3.00] |
| 95 [5.9] | 201234-003 | 13,2 [.52] | 16336-531 | 79,5 [3.13] |
| 120 [7.3] | 201234-009 | 16,5 [.65] | 16336-532 | 82,6 [3.25] |
| 145 [8.9] | 201234-020 | 20,1 [.79] | 16336-533 | 85,9 [3.38] |
| 160 [9.7] | 201234-004 | 21,9 [.86] | 16336-534 | 88,9 [3.50] |
| 185 [11.3] | 201234-005 | 25,4 [1.00] | 16336-534 | 88,9 [3.50] |
| 230 [14.1] | 201234-031 | 31,7 [1.25] | 16336-537 | 98,6 [3.88] |
| 295 [17.9] | 201234-035 | 40,4 [1.59] | 16336-541 | 104,9 [4.13] |
| 370 [22.6] | 201234-008 | 50,8 [2.00] | 16336-545 | 117,6 [4.63] |
| 460 [28.2] | 201234-033 | 63,5 [2.50] | 16336-551 | 133,4 [5.25] |
| 590 [35.9] | 201234-036 | 80,8 [3.18] | 16336-556 | 146,1 [5.75] |
| 740 [45.1] | 8618-034 | 101,6[4.00] | 16336-564 | 165,1 [6.50] |

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 figure1). Use protective material on vise jaws. Housing distortion could result if jaws are overtightened.

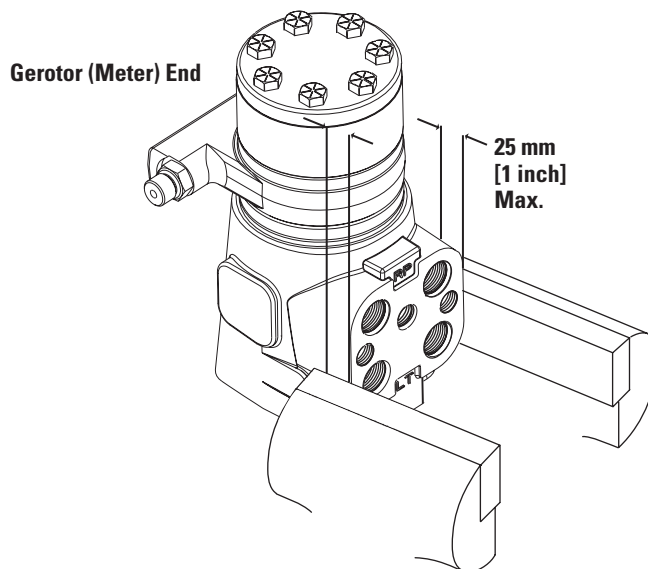


Figure 1

Disassembly

2. Remove 5/16 in. cap screws.
3. Remove end cap.
4. Remove seal.

Note: All Series 10 VersaSteer™ steering control units have a low slip sealed gerotor star, this unit includes a ring seal and a back-up ring.

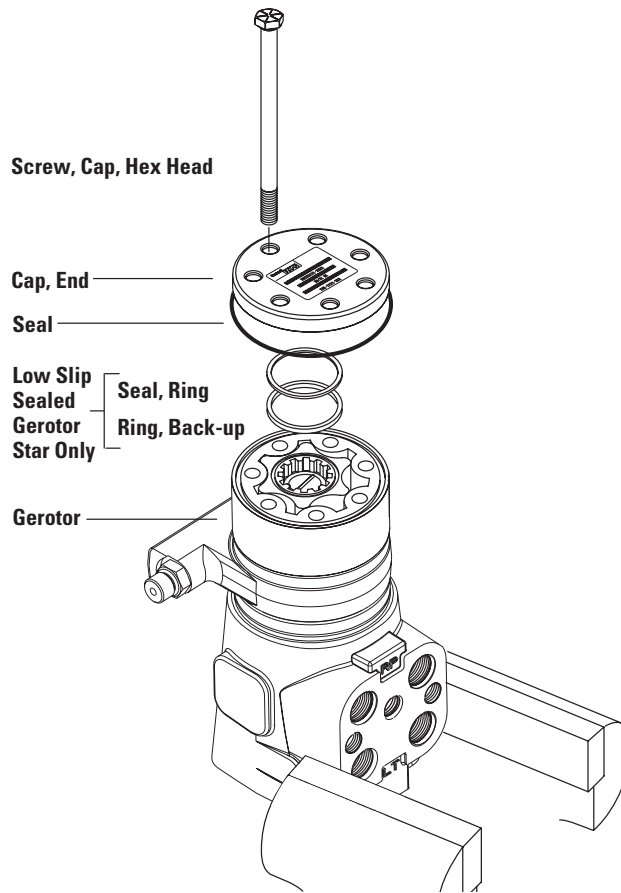


Figure 2

5. Remove gerotor (meter). Be careful not to drop star.
6. Remove seal from valve plate.
7. Remove valve plate.
8. Remove seal from valve S/A.

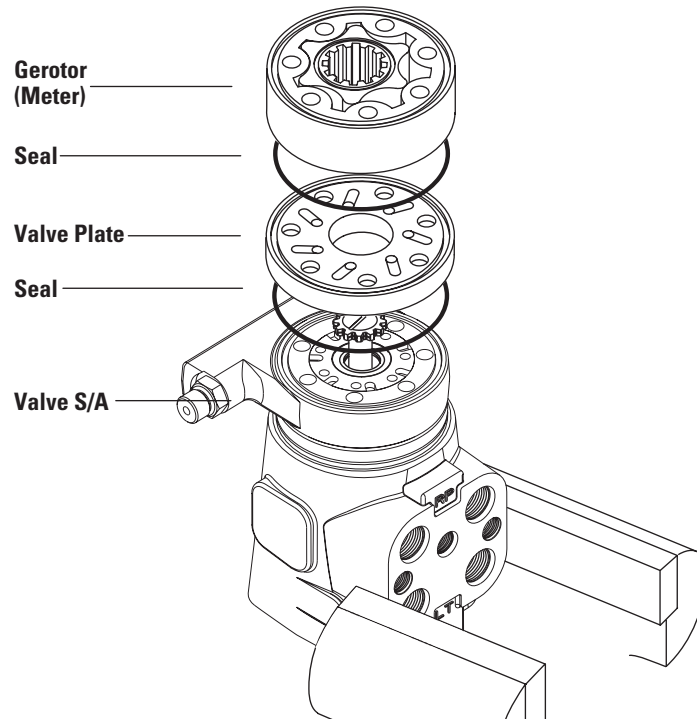


Figure 3

Disassembly

9. Remove valve Sub-assembly
10. Remove seal from valve plate.
11. Remove valve plate

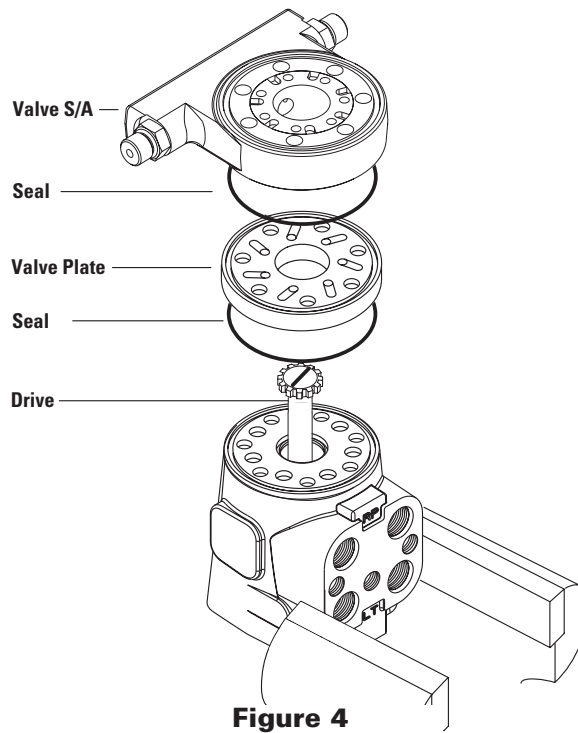
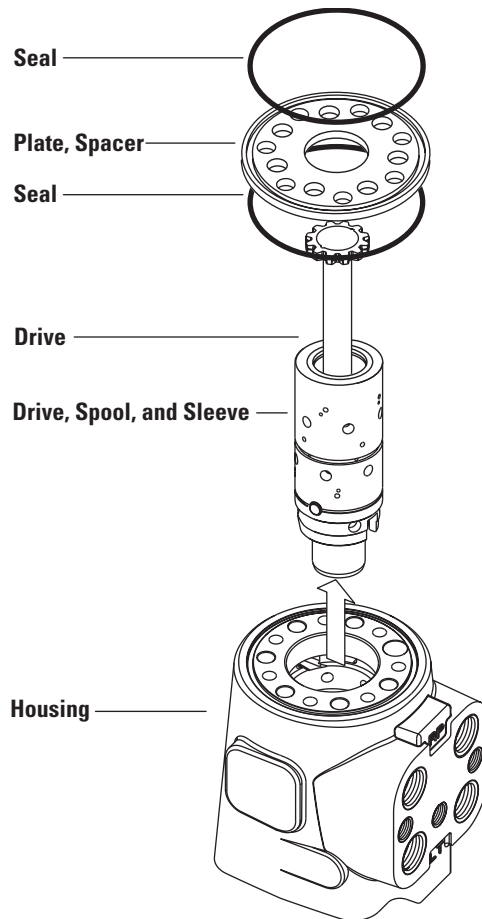


Figure 4

12. Remove seal from spacer plate.
13. Remove spacer plate.
14. Remove seal from housing.
15. Pull drive and twist to remove SP/SL drive assembly from housing.
16. Remove housing from vise.



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

17. 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 6).

Figure 5

Disassembly

18. 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.
19. Carefully Remove Seal with a thin-blade screw driver. Do not scratch seal groove with screw driver.
20. Use thin bladed screw driver to pry dust seal from housing. Do not damage housing.

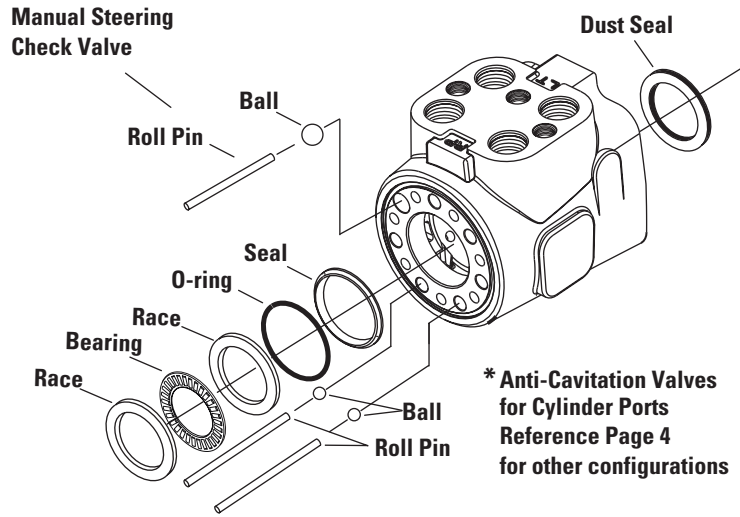


Figure 6

21. Push pin from spool and sleeve assembly.
22. Remove Drive
23. Push spool partially from control end of sleeve, then carefully remove centering springs and retaining ring from spool by hand (figure 7).

***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.

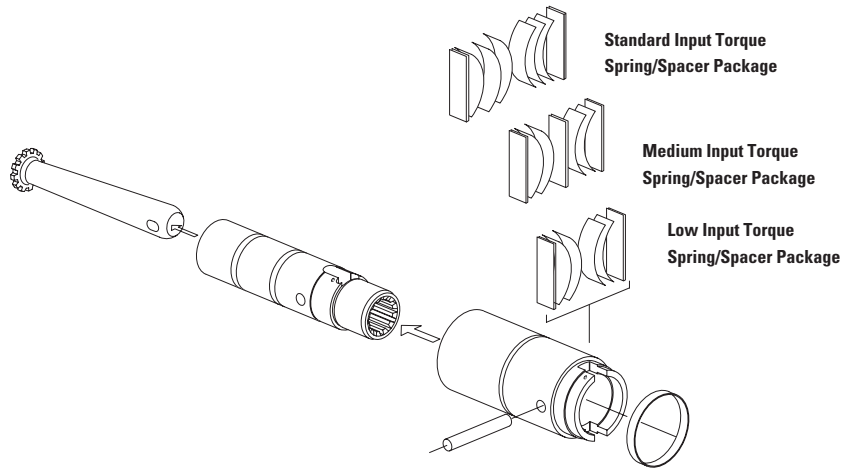


Figure 7

Disassembly

24. Disassemble valve sub-assembly as shown in figure 8.

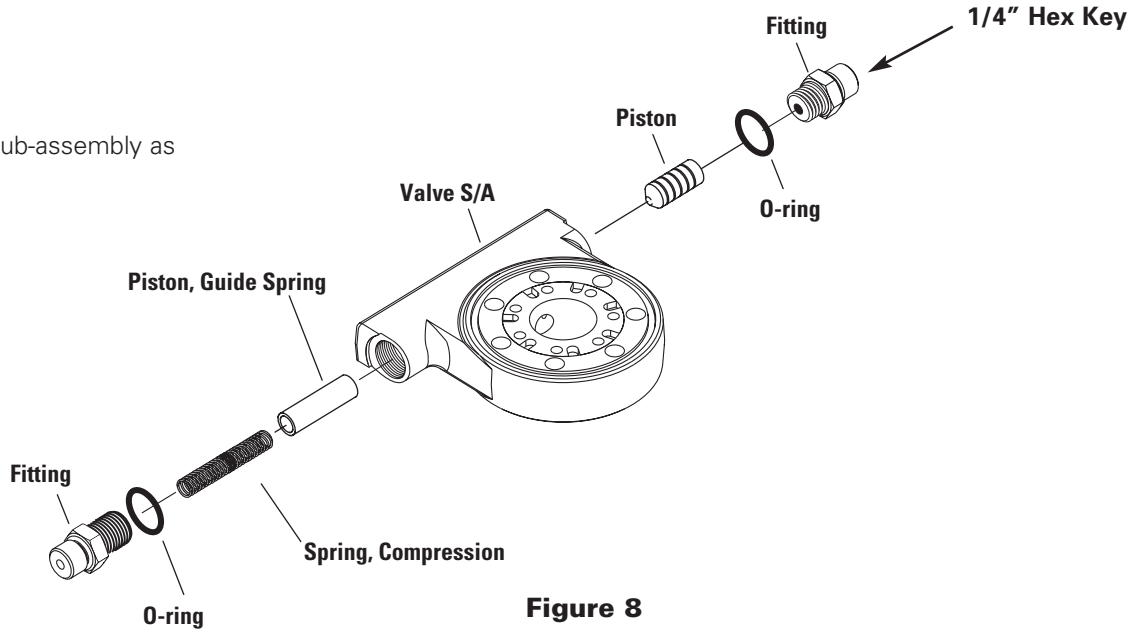


Figure 8

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.

1. Reassemble valve parts with new o-rings on plugs (See figure 9).

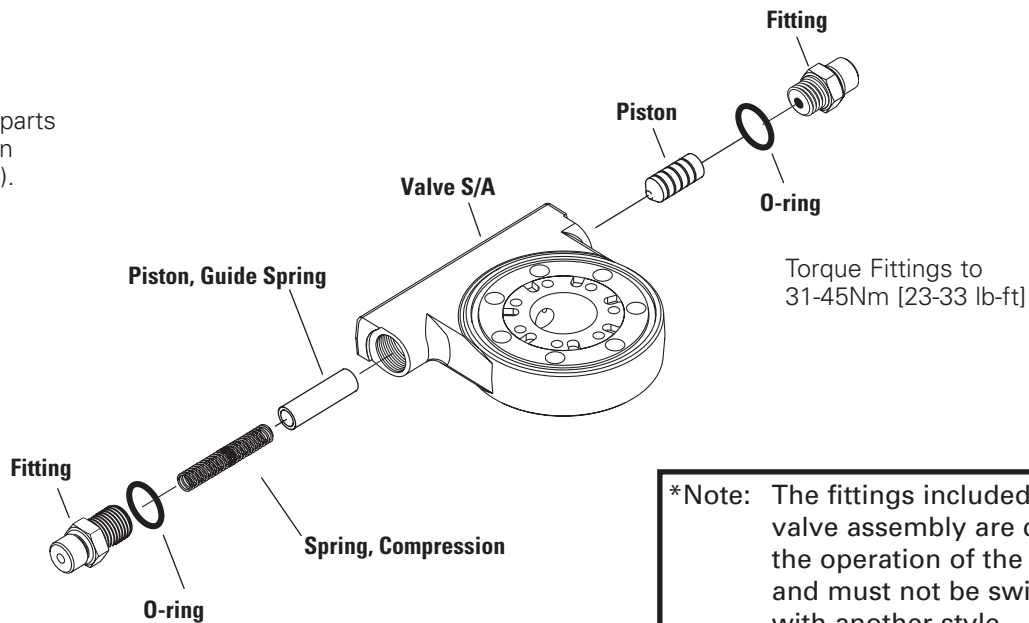


Figure 9

Assembly

2. 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 10).

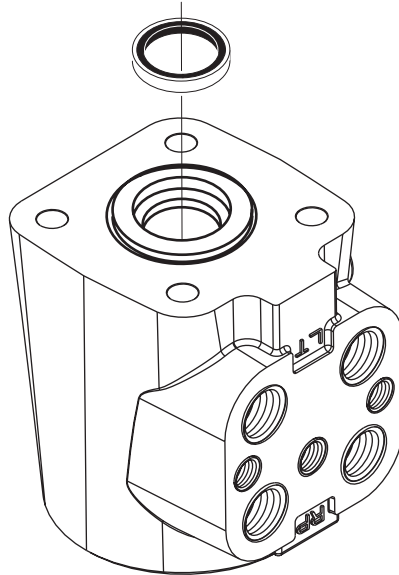


Figure 10

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 11.
2. Lubricate seal and o-ring with hydraulic oil before installation
3. Align sleeve with housing bore (figure 11)
4. Insert sleeve into housing bore (Figure 12)
5. Place o-ring on plunger (Figure 13).



Figure 11



Tool No. 600792-001



Figure 12



Figure 13

Assembly

2-Piece Shaft Seal Installation

- Align seal with plunger. cross section "L" shape of seal should be upside down (figure 14).



Figure 14

- Push seal onto plunger. Lip of seal should be between o-ring and plunger. No gap should exist between o-ring and seal (figure 15).



Figure 15

- Align plunger with sleeve (figure 16).



Figure 16

- Push plunger into sleeve until it bottoms out, rotate 1/4 turn (figure 17).

- While holding sleeve in housing, withdraw plunger.

- Withdraw sleeve.

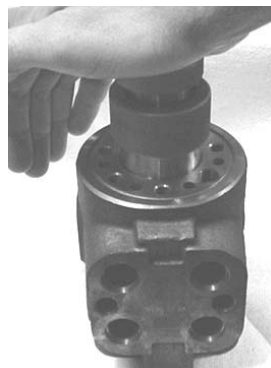


Figure 17

- Inspect seal installation. Seal and o-ring must both be within shaft seal counter bore of housing (figure 18).



Figure 18

- Clamp housing in vice (figure 19).

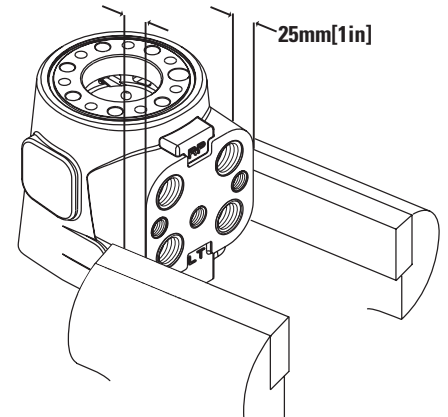


Figure 19

- Install two bearing races and thrust bearing as shown in figure 20.

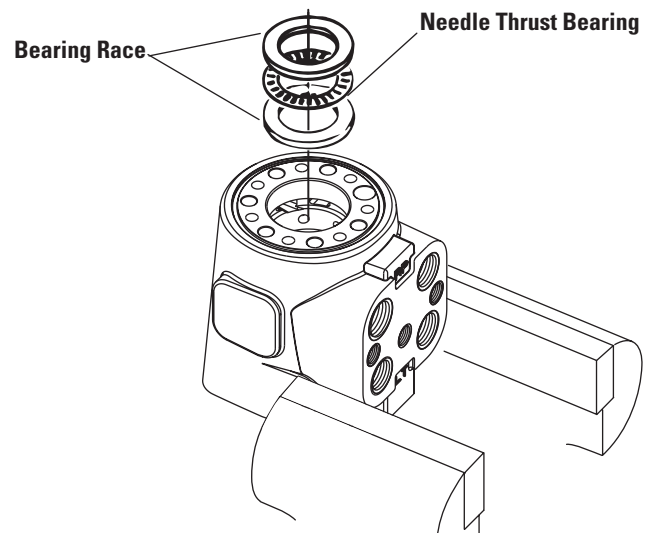


Figure 20

Assembly

- 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 21) in spool and sleeve and stand parts on end of bench.

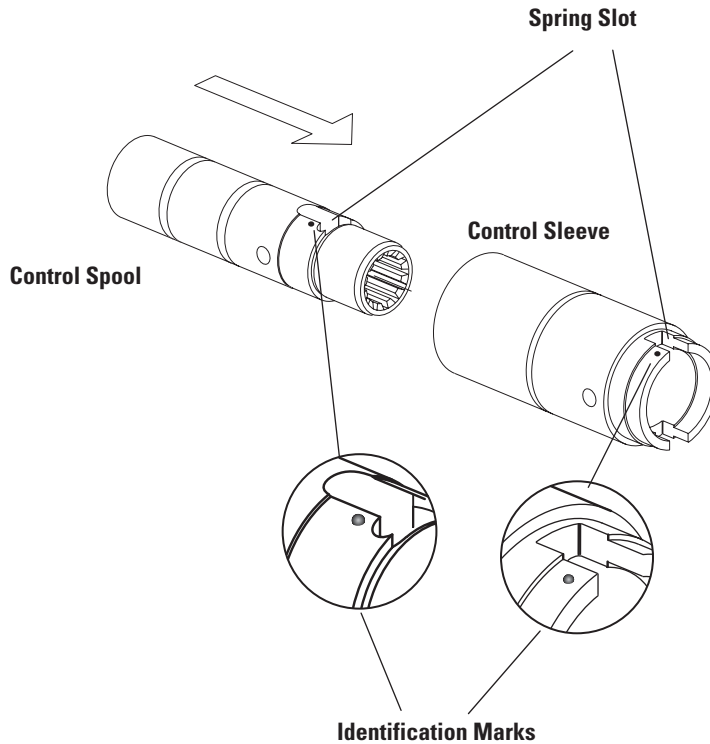


Figure 21

- Installation of spring spacers and springs, hold spring retainer at an angle as shown (see figure 22 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.

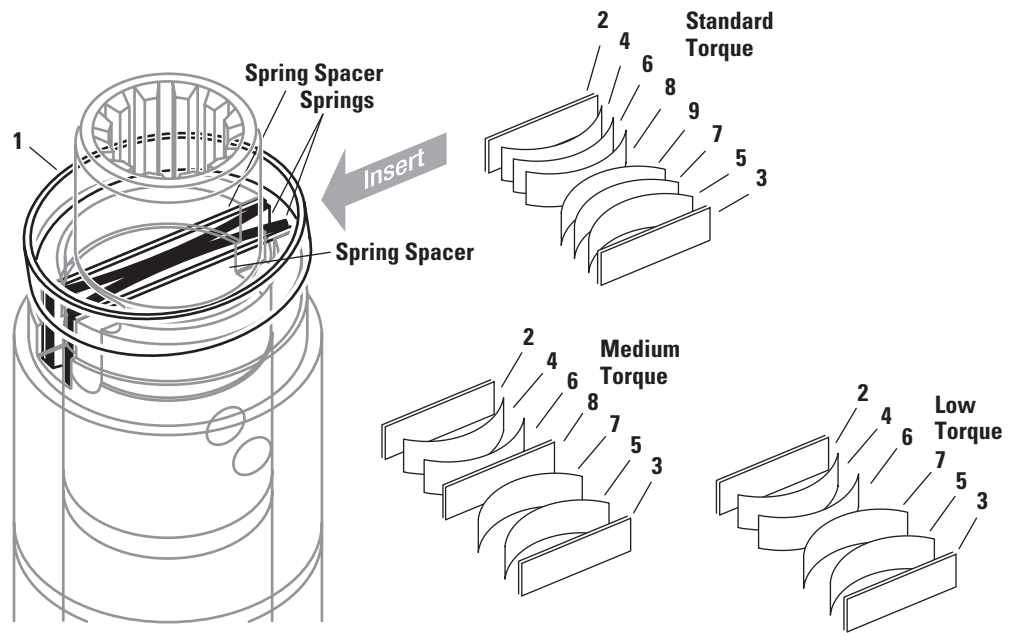


Figure 22

Assembly

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.

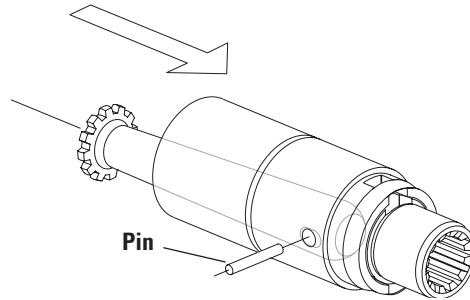


Figure 23

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.

19. Position spool and sleeve assembly so that splined end of spool enters 14 hole end of housing first (figure 23).

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.

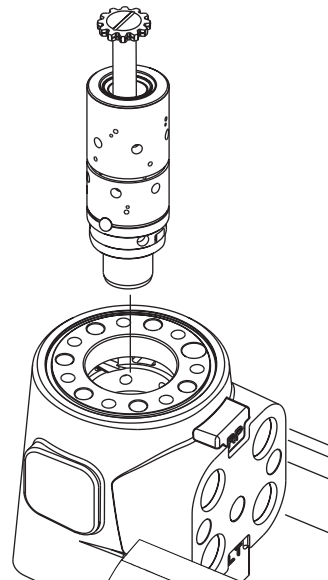


Figure 24

20. Install 72,6 mm [2.86 in.] ID O-ring in housing (figure 25).

21. Install anti-cavitation valves and manual steering check valve (if used) in holes, as shown in figure 25. After installing balls, inspect holes to make sure they are properly seated.

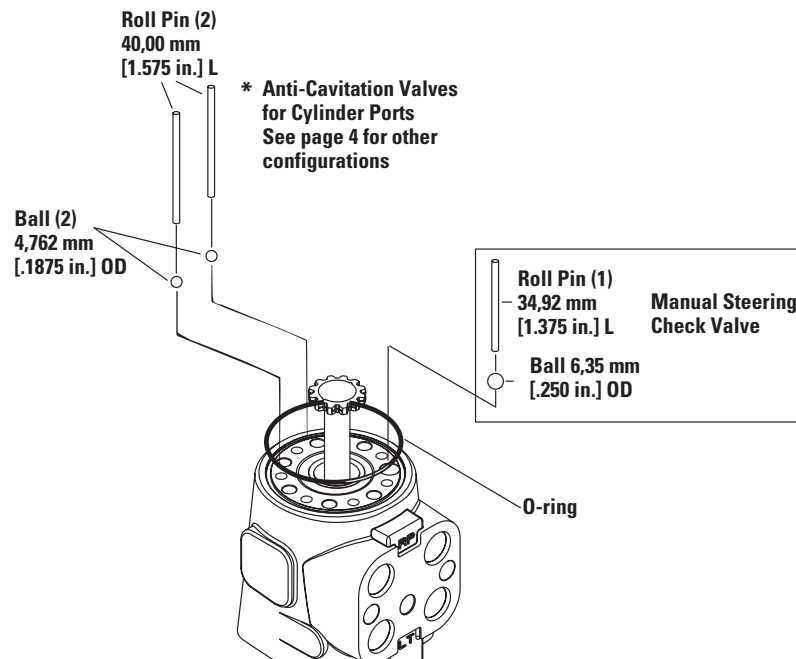


Figure 25

Assembly

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 valve plate.
25. Lubricate and install 72,6 mm [2.86 in.] ID seal in valve plate.
26. Install valve S/A, see figure 26 for correct position.
27. Lubricate and install 72,6 mm [2.86 in.] ID seal in valve S/A.
28. Install valve plate.
29. Lubricate and install 72,6 mm [2.86 in.] ID seal in valve plate.
30. Install gerotor, seal groove up; note position of star valleys in relation to marked drive.

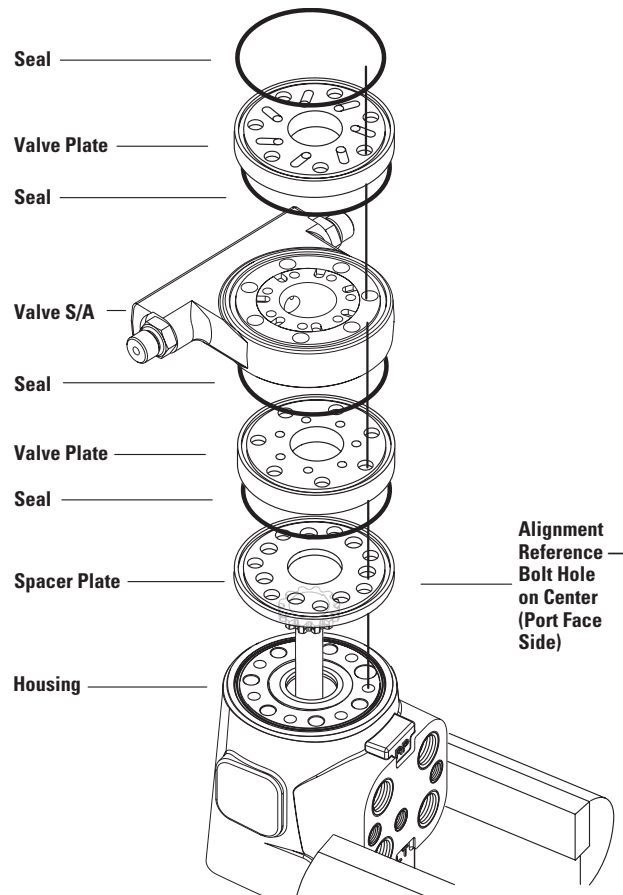


Figure 26

Timing Reference Data —

Align star valley (reference A) with marked drive (reference B). Valley must align with pin. Note parallel relationship of reference lines A, B, C, and D in figure 27. Align bolt holes without disengaging gerotor (meter) from drive.

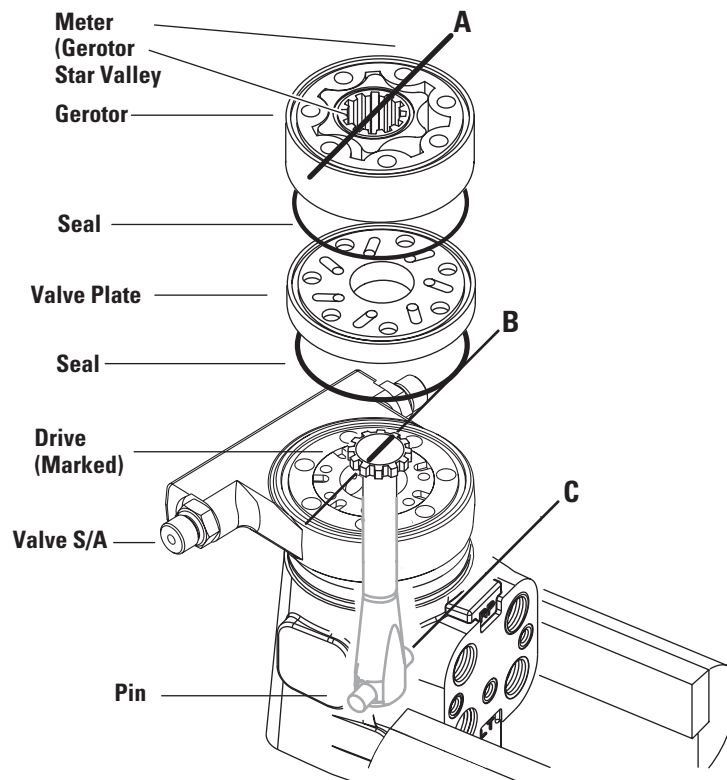


Figure 27

Assembly

31. Install back-up ring and seal ring in gerotor star.
32. Lubricate and install 72,6 mm [2.86 in.] ID seal in gerotor (meter).
33. Install end cap on gerotor, aligning holes.

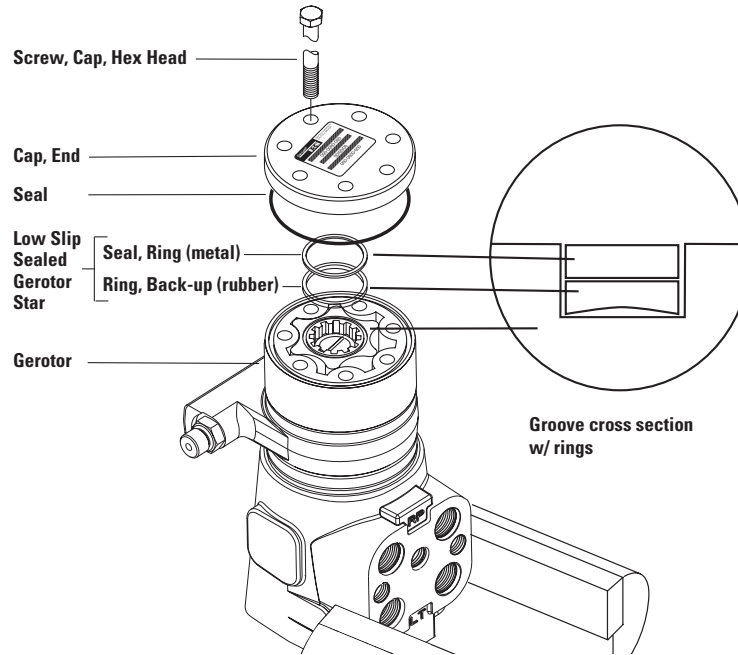


Figure 28

34. 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 29.

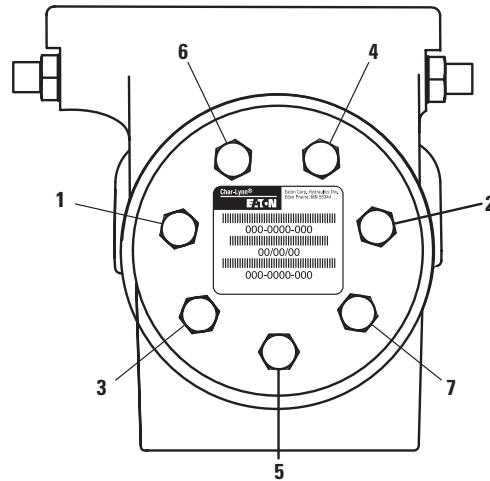


Figure 29

Eaton
 14615 Lone Oak Road
 Eden Prairie, MN 55344
 USA
 Tel: 952 937-9800
 Fax: 952 974-7722
 www.hydraulics.eaton.com

Eaton
 20 Rosamond Road
 Footscray
 Victoria 3011
 Australia
 Tel: (61) 3 9319 8222
 Fax: (61) 3 9318 5714

Eaton
 Dr.-Reckeweg-Str. 1
 D-76532 Baden-Baden
 Germany
 Tel: (49) 7221 682-0
 Fax: (49) 7221 682-788

