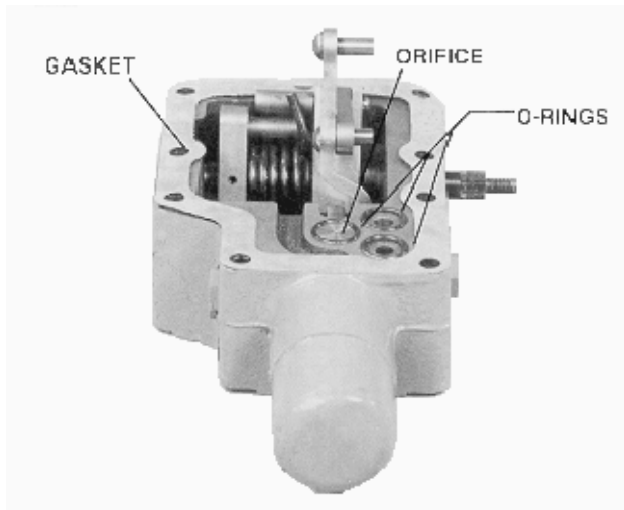


Service Kit Instructions

Series 20

Manual displacement control (MDC) installation instructions

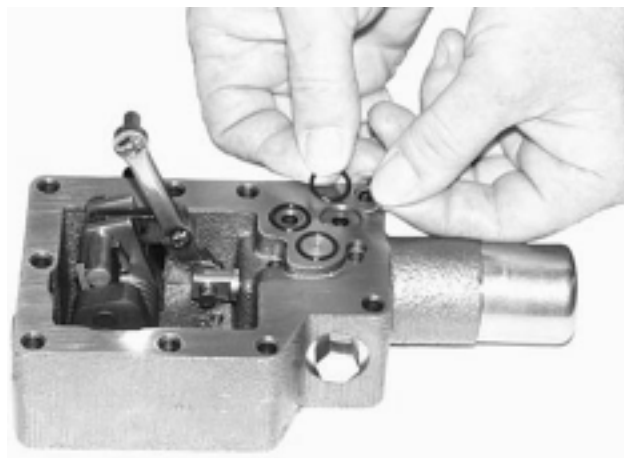


Purpose:

On the new series 20 MDC from Sauer-Danfoss, the trepan groove has been removed from the two servo ports on the control valve. As a result, washers must be installed in the two servo ports on the MDC. The two washers (P/N 917310) are included in all MDC kits.

Procedure:

Place the O-rings into servo port openings. Install washers into the center of the servo port openings. To insure that the washers stay in place during the installation of the control, it is suggested to cover the washers with petroleum jelly before installing them. In preparation for installing the control, clean the gasket mating surfaces, place a new gasket on the housing, and place the orifice plate in the control.



Engage the pin on the control link in the mating hole in the small link attached to the swashplate. Slide the pin all the way into the swashplate link. Swing the control into place against the housing, being certain the orifice and O-ring are in place, then install cap screws and washers. Torque cap screws to 8-11 lbf·ft. Install control handle over serrated shaft, assemble lock washer and hex. nut. Torque to 100 lbf·in. maximum. This procedure applies to controls used on variable displacement pumps (excluding Open Circuit) and motors.

