

*Powering Business Worldwide*

# EATON

Powering Business Worldwide

## The Power of One Eaton

Celebrating  
**100** YEARS  
Ideals that Endure



Char-Lynn®



BOSTON  
WEATHERHEAD

Winner®

ARROW  
HOSE & TUBING INC.  
DURO  
DYNE

HANSEN™  
GROMELLE™

1911

1968

1971

1999

2000

2001

2002

2004

2005

2006

2007

2008

2010

2011

Airflex®

Aeroquip  
VICKERS  
HYDROKRAFT™



Walterscheid®

Synflex®

Integrated  
Hydraulics



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There's a certain energy at Eaton. It's the power of integrating the competencies of some of the world's most respected names to build a brand you can trust to meet every power management need. The energy created supports our commitment to powering business worldwide.

As the world's demand for high-efficiency hydraulic systems for mobile and stationary applications increase, Eaton is helping to solve these challenges more reliably, efficiently, and sustainably. Our goal is simple; to provide unique solutions across a wide range of markets that keep businesses on the leading edge of change. Visit [Eaton.com/hydraulics/fusion](http://Eaton.com/hydraulics/fusion).

**That's the power of One Eaton.**

# Serving eight key segments - sharing one focus



## Alternative Energy

Making energy sources technically practical and economically sound requires the kind of control made possible by high-quality components. When Eaton is on the inside, you will experience the reliable, consistent performance to create and capture energy—making renewable energy an every-day energy.



## Discrete Manufacturing

Produce at peak efficiency with the superior precision and repeatability of Eaton products. Eaton hydraulic components provide the precise control and consistent operation required for virtually every step in your manufacturing operation. With Eaton, we'll help you redefine the meaning of raw productivity.



## Oil & Gas

As the oil & gas industry continues to face further globalization and consolidation, large-scale organizations that can meet your needs in every corner of the world are more difficult to find. At Eaton, our portfolio of products is only surpassed by our tremendous reach.



## Processing

Whatever your industry, no matter which processes you manage, Eaton parts and systems help keep you up and running. Our components make equipment more efficient and easier to use, so you get optimal machine performance and maximum productivity.



## Agriculture & Forestry

There's a reason farming and forestry are called "working the land." These segments involve some of the hardest work and longest hours of any sector in the economy. Your productivity and profitability depend on the way you manage time and tasks.



## Commercial Vehicles

Eaton technologies can make your driving operation more successful. Greater comfort and productivity help increase driver retention, while reduced emissions, leaks, and noise improve environmental performance. Increased efficiencies overall mean lower costs and higher net revenue.



## Material Handling

Eaton hydraulic systems provide the precise control and consistent operation required for material handling and utility work. With a broad selection of products and solutions built in, Eaton helps make you a master of your domain.



## Construction & Mining

When you work on a large scale, even the details are big. You need to trust every part of the equipment that lets you handle construction and mining jobs. For reliable components that deliver consistent performance in extreme conditions, turn to Eaton.

## Eaton is a leading diversified power management company

Eaton provides reliable, efficient and safe power management for a growing number of industries.

### Understanding and helping our customers succeed

- Listening and understanding to requirements and business drivers
- Delivering solutions with value propositions to solve the critical business needs

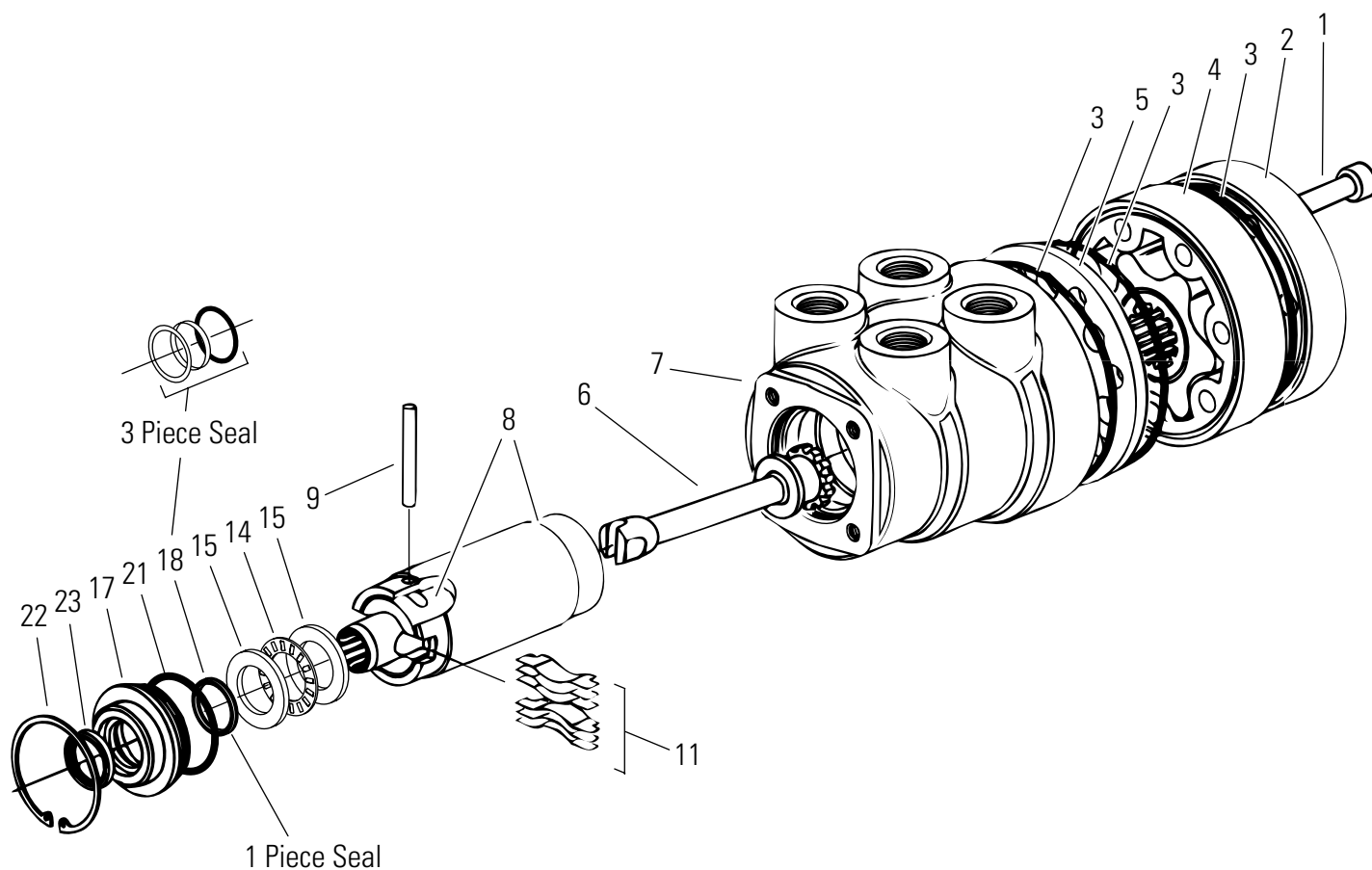
### Knowing what's important to our customers and integrating that knowledge into the fabric of our business

- ...to deliver innovative, quality products
- ...to respond fast
- ...to provide dedicated customer service and support around the globe

### Our strength is global reach with local responsiveness and support

- Customers served in more than 150 countries
- Diverse channels ensure reliable availability and support
- Design and engineering teams provide support for standard products and custom solutions
- Eaton experts offer efficient product and application training

# 25 Series Steering Control Units



Actual Displacement cm <sup>3</sup> /r [in <sup>3</sup> /r]	Ref. No. 4 Gerotor Part No.	Width mm [in.]	Ref. No.1 Socket Head Cap Screw Part No.	Length mm [in.]
490 [30]	21519-001	23,1 [.91]	16148-824	63,5 [2.50]
625 [38]	21519-002	29,2 [1.15]	16148-826	69,8 [2.75]
795 [48]	21519-003	36,8 [1.45]	16148-830	76,2 [3.00]
985 [60]	21519-004	46,0 [1.81]	16148-834	88,9 [3.50]
1230 [75]	21519-005	57,6 [2.27]	16148-836	95,2 [3.75]

<b>Ref. No.</b>	<b>Part Number</b>	<b>Description</b>	<b>Qty. Per Unit</b>
1	*	Screw, Cap	7
2	21509-000	Cap, End	1
X	3	250001-048	Seal, O-ring 120,4 mm [4.74 in.] ID
4	*	Gerotor	1
5	21847-000	Plate, Wear	1
6	21514-000	Drive	1
7	NSS	Housing	1
8	NSS	Sleeve, Control	1
	NSS	Spool, Control	1
9	14451-000	Pin, Centering	1
**11	NSS	Spring, Centering	6
14	5544-000	Bearing, Needle Thrust	1
15	8329-000	Bearing Race	2
17	21513-000	Retainer, Front	1
X	18	9233-001	Seal, 25,4 mm [1.00 in.] ID
X	21	250001-136	Seal, O-ring, 50,5 mm [1.99 in.] ID
	22	14296-000	Ring, Retaining
X	23	844-000	Seal, Dust, 31,7 mm [1.25 in.] OD
	64468-000	Seal Kit — Contains Parts Indicated by X.	

\* See Chart on Page 2 for Information on Specific Models

\*\* Ref. 11 Sold only in Kit form, Spring Kit No. 64428-001 Includes 8 Springs, 6 Springs are Required for 25 Series Steering Control Units (8 Springs Used on 35 Series and 40 Series Open Center Steering Control Units Only).

NSS Not Sold Separately

## 25 Series SCU

System	Signal	Load Circuit	Rated Flow l/min [GPM]	O-ring Port Size	Actual Displacement cm <sup>3</sup> /r [in <sup>3</sup> /r] – Product Number				
				490 [30]	625 [38]	795 [48]	985 [60]	1230 [75]	
Open Center	N/A	Non Load Reaction	95 [25]	1– 1/16-12	251-1001	251-1002	251-1003	251-1004	251-1005
Closed Center	N/A	Non Load Reaction	95 [25]	1– 1/16-12	252-1001	252-1002	252-1003	252-1004	252-1005
				1– 1/16-12	252-1008**	252-1009**	252-1012**	252-1013**	252-1006**
Load Sensing	Dynamic	Non Load Reaction	95 [25]	1– 1/16-12	253-1001	253-1002	253-1003	253-1004	253-1005

\*\* Closed Center Units with Neutral Bleed 2,3 l/min [.6 GPM] at 172 bar [2500 PSI]

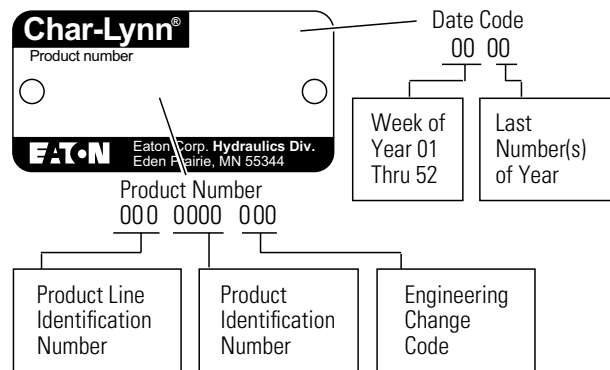
### How to Order Replacement Parts

Each Order Must Include the Following:

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

For More Detailed Information Contact Eaton Corp. Hydraulics Division 15151 Highway 5 Eden Prairie, MN 55344.

- Specifications and performance data, Catalog No. 11-872
- When servicing Steering Control Unit refer to Repair Information No. 7-306. This repair manual lists tools required, and step by step disassembly and reassembly procedures.



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