Series 40 Axial Piston Pumps
Technical Information

Using this manual

ORGANIZATION AND HEADINGS
To help you quickly find information in this manual, the material is divided into sections, topics, subtopics, and details, with descriptive headings set in red type. Section titles appear at the top of every page in large red type. Topic headings appear in the left hand column in BOLD RED CAPITAL LETTERS. Subtopic headings appear in the body text in bold red type and detail headings in italic red type.

References (example: See Topic xyz, page XX) to sections, headings, or other publications are also formatted in red italic type. In Portable Document Format (PDF) files, these references represent clickable hyperlinks that jump to the corresponding document pages.

TABLES, ILLUSTRATIONS, AND COMPLEMENTARY INFORMATION
Tables, illustrations, and graphics in this manual are identified by titles set in blue italic type above each item. Complementary information such as notes, captions, and drawing annotations are also set in blue type.

References (example: See Illustration abc, page YY) to tables, illustrations, and graphics are also formatted in blue italic type. In PDF files, these references represent clickable hyperlinks that jump to the corresponding document pages.

SPECIAL TEXT FORMATTING
Defined terms and acronyms are set in bold black type in the text that defines or introduces them. Thereafter, the terms and acronyms receive no special formatting.

Black italic type is used in the text to emphasize important information, or to set-off words and terms used in an unconventional manner or alternative context. Red and blue italics represent hyperlinked text in the PDF version of this document (see above).

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Series 40 Axial Piston Pumps
Technical Information

General description

Series 40 is a family of hydrostatic pumps and motors for medium power applications with maximum loads of 345 bar [5000 psi]. These pumps and motors can be applied together or combined with other products in a system to transfer and control hydraulic power.

Series 40 pump + motor transmissions provide an infinitely variable speed range between zero and maximum in both forward and reverse modes of operation. The pumps and motors each come in four frame sizes: M25, M35, M44, and M46.

**Series 40 pumps** are compact, high power density units. All models use the parallel axial piston / slipper concept in conjunction with a tiltable swashplate to vary the pump's displacement. Reversing the angle of the swashplate reverses the flow of fluid from the pump, reversing the direction of rotation of the motor output.

Series 40 - M35, M44, and M46 pumps may include an integral charge pump to provide system replenishing and cooling fluid flow, as well as servo control fluid flow on M46 pumps. M25 pumps are designed to receive charge flow from an auxiliary circuit or from a gear pump mounted on the auxiliary mounting pad. Series 40 pumps feature a range of auxiliary mounting pads to accept auxiliary hydraulic pumps for use in complementary hydraulic systems.

Series 40 - M46 pumps offer proportional controls with either manual, hydraulic, or electronic actuation. An electric three-position control is also available. The M25, M35, and M44 pumps include a trunnion style direct displacement control.

**Series 40 motors** also use the parallel axial piston / slipper design in conjunction with a fixed or tiltable swashplate. The family includes M25, M35, M44 fixed motor units and M35, M44, M46 variable motor units. For complete technical information on Series 40 motors, refer to *Series 40 Motors Technical Information, 520L0636*.

The M35 and M44 variable motors feature a trunnion style swashplate and direct displacement control. The M46 variable motors use a cradle swashplate design and a two-position hydraulic servo control.

The M46 variable motor is available in a cartridge flange version, which is designed to be compatible with CW and CT compact planetary gearboxes. This combination provides a short final drive length for applications with space limitations.
General description

KEY FEATURES

• 4 sizes of variable displacement pumps
• 4 sizes of tandem pumps
• 3 sizes of variable displacement motors
• 3 sizes of fixed displacement motors
• Efficient axial piston design
• Complete family of control systems
• Proven reliability and performance
• Compact, lightweight
• Worldwide sales and service
Series 40 Axial Piston Pumps
Technical Information
General description

**M25 VARIABLE PUMP**

**M35 VARIABLE PUMP**
(M44 SIMILAR)

**M46 VARIABLE PUMP**
A Series 40 - M46 variable pump is shown in a hydraulic circuit with a Series 40 - M35 fixed motor. The pump shown features manual displacement control. The circuit features suction filtration and heat exchanger.
OVERVIEW

Specifications and operating parameters are shown below. For additional information, see Operating parameters, page 13, System design parameters, page 16, Product coding, page 23, Features and options, page 25 and Control options, page 41.

GENERAL

<table>
<thead>
<tr>
<th>Feature</th>
<th>Details</th>
</tr>
</thead>
<tbody>
<tr>
<td>Product line</td>
<td>Series 40 Pumps</td>
</tr>
<tr>
<td>Pump type</td>
<td>In-line, axial piston, variable, positive displacement pumps</td>
</tr>
<tr>
<td>Direction rotation</td>
<td>Clockwise (CW) or counterclockwise (CCW) available</td>
</tr>
<tr>
<td>Installation position</td>
<td>Discretionary, the housing must be filled with hydraulic fluid</td>
</tr>
<tr>
<td>Filtration configuration</td>
<td>Suction or charge pressure filtration</td>
</tr>
<tr>
<td>Other system requirements</td>
<td>Independent braking system, suitable reservoir and heat exchanger</td>
</tr>
</tbody>
</table>

FEATURES

<table>
<thead>
<tr>
<th>Model</th>
<th>Unit</th>
<th>M25 PV</th>
<th>M35 PV</th>
<th>M44 PV</th>
<th>M46 PV</th>
<th>M25 PT</th>
<th>M35 PT</th>
<th>M44 PT</th>
<th>M46 PT</th>
</tr>
</thead>
<tbody>
<tr>
<td>Type of mounting</td>
<td>SAE B</td>
<td>SAE B</td>
<td>SAE B</td>
<td>SAE B</td>
<td>SAE B</td>
<td>SAE B</td>
<td>SAE B</td>
<td>SAE B</td>
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</tr>
<tr>
<td>Port connections</td>
<td>Twin</td>
<td>Twin</td>
<td>Twin</td>
<td>Twin</td>
<td>Twin</td>
<td>Twin</td>
<td>Twin</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Integral charge pump (std)</td>
<td>cm³/rev</td>
<td>11.8 [0.72]</td>
<td>11.8 [0.72]</td>
<td>13.9 [0.85]</td>
<td>-</td>
<td>16.4 [1.00]</td>
<td>16.4 [1.00]</td>
<td>22.9 [1.40]</td>
<td></td>
</tr>
<tr>
<td>System pressure regulation</td>
<td>bar [psi]</td>
<td>140-345 [2030-5000]</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Displacement limiters</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>Option</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>Option</td>
<td></td>
</tr>
<tr>
<td>Input shaft option</td>
<td>Splined, Tapered, or Straight Key</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Auxiliary mounting pad</td>
<td>SAE A</td>
<td>SAE B</td>
<td>SAE A</td>
<td>SAE B</td>
<td>SAE B</td>
<td>SAE A</td>
<td>SAE B</td>
<td>SAE A</td>
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</tr>
<tr>
<td>Control options</td>
<td>DDC</td>
<td>DDC</td>
<td>DDC</td>
<td>MDC, HDC, EDC, FNR</td>
<td>DDC</td>
<td>DDC</td>
<td>DDC</td>
<td>MDC, HDC, EDC, FNR</td>
<td></td>
</tr>
<tr>
<td>Filtration configuration</td>
<td>Suction Filtration or Remote Charge Pressure Filtration</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
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SPECIFICATIONS

<table>
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<tr>
<th>Model</th>
<th>Unit</th>
<th>M25 PV</th>
<th>M35 PV</th>
<th>M44 PV</th>
<th>M46 PV</th>
<th>M25 PT</th>
<th>M35 PT</th>
<th>M44 PT</th>
<th>M46 PT</th>
</tr>
</thead>
<tbody>
<tr>
<td>Pump configuration</td>
<td>Single variable pump</td>
<td>Tandem variable pump</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Displacement</td>
<td>cm³/rev</td>
<td>24.6 [1.50]</td>
<td>35.0 [2.14]</td>
<td>43.5 [2.65]</td>
<td>46.0 [2.81]</td>
<td>24.6 x 2 [1.50 x 2]</td>
<td>35.0 x 2 [2.14 x 2]</td>
<td>43.5 x 2 [2.65 x 2]</td>
<td>46.0 x 2 [2.81 x 2]</td>
</tr>
<tr>
<td>Mass moment of inertia</td>
<td>kg·m² [slug·ft²]</td>
<td>0.0018 [0.00014]</td>
<td>0.0033 [0.00024]</td>
<td>0.0032 [0.00023]</td>
<td>0.0050 [0.00037]</td>
<td>0.0037 [0.00028]</td>
<td>0.0066 [0.00048]</td>
<td>0.0064 [0.00047]</td>
<td>0.0100 [0.00073]</td>
</tr>
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</table>
### Technical Specifications

#### Operating Parameters

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Unit</th>
<th>M25 PV</th>
<th>M35 PV</th>
<th>M44 PV</th>
<th>M46 PV</th>
<th>M25 PT</th>
<th>M35 PT</th>
<th>M44 PT</th>
<th>M46 PT</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Case Pressure</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Continuous</td>
<td>bar [psi]</td>
<td>1.7 [25]</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
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<tr>
<td>Maximum</td>
<td>bar [psi]</td>
<td>5.2 [75]</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
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</tr>
<tr>
<td><strong>Speed Limits</strong></td>
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<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
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<tr>
<td>Rated @ max angle</td>
<td>min⁻¹ (rpm)</td>
<td>4000</td>
<td>3600</td>
<td>3300</td>
<td>4000</td>
<td>4000</td>
<td>3600</td>
<td>3300</td>
<td>4000</td>
</tr>
<tr>
<td>Maximum @ max angle</td>
<td>min⁻¹ (rpm)</td>
<td>5000</td>
<td>4500</td>
<td>4100</td>
<td>4100</td>
<td>5000</td>
<td>4500</td>
<td>4100</td>
<td>4100</td>
</tr>
<tr>
<td>Minimum</td>
<td>min⁻¹ (rpm)</td>
<td>500</td>
<td>500</td>
<td>500</td>
<td>500</td>
<td>500</td>
<td>500</td>
<td>500</td>
<td>500</td>
</tr>
<tr>
<td><strong>System Pressure</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
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<tr>
<td>Continuous</td>
<td>bar [psi]</td>
<td>210 [3000]</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
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<tr>
<td>Maximum</td>
<td>bar [psi]</td>
<td>345 [5000]</td>
<td></td>
<td></td>
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<td></td>
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</tr>
<tr>
<td><strong>Inlet Pressure</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Continuous</td>
<td>bar absolute [in Hg vacuum]</td>
<td>0.8 [6.3]</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Maximum</td>
<td>bar absolute [in Hg vacuum]</td>
<td>0.7 [9.2]</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

#### Fluid Specifications

Ratings and data are based on operation with premium petroleum-based hydraulic fluids containing oxidation, rust, and foam inhibitors.

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Unit</th>
<th>Minimum</th>
<th>Continuous</th>
<th>Maximum</th>
</tr>
</thead>
<tbody>
<tr>
<td>Viscosity</td>
<td>mm²/sec (cSt) [SUS]</td>
<td>7 [47]</td>
<td>12-60 [70-278]</td>
<td>1600 [7500]</td>
</tr>
<tr>
<td>Cleanliness</td>
<td>ISO 4406 Class 18/13 or better</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Filtration efficiency</td>
<td>suction filtration</td>
<td>$\beta_{1,\alpha}=75$ ($\beta_{1,\alpha}&gt;1.5$)</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>charge filtration</td>
<td>$\beta_{1,\alpha}=75$ ($\beta_{1,\alpha}&gt;10$)</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>
Series 40 Axial Piston Pumps
Technical Information
Technical Specifications

The following performance graph provides typical volumetric and overall efficiencies for Series 40 pumps. These efficiencies apply for all Series 40 pumps.

Pump performance as a function of operating speed

The performance map provides typical pump overall efficiencies at various operating parameters. These efficiencies also apply for all Series 40 pumps.

Pump performance as a function of operating speed and system pressure
Series 40 Axial Piston Pumps
Technical Information
Operating parameters

FLUIDS

Ratings and performance data are based on operating with premium hydraulic fluids containing oxidation, rust, and foam inhibitors. These include premium turbine oils, API CD engine oils per SAE J183, M2C33F or G automatic transmission fluids (ATF), Dexron II (ATF) meeting Allison C-3 or Caterpillar T0-2 requirements, and certain specialty agricultural tractor fluids. For more information on hydraulic fluid selection, see Sauer-Danfoss publications: 520L0463, Hydraulic Fluids and Lubricants, Technical Information, and 520L465, Experience with Biodegradable Hydraulic Fluids, Technical Information.

VISCOSITY

Maintain fluid viscosity within the recommended range for maximum efficiency and bearing life. **Minimum viscosity** is acceptable only during brief occasions of maximum ambient temperature and severe duty cycle. **Maximum viscosity** is acceptable only at cold start: Limit speeds until the system warms up. See Sauer-Danfoss publications: 520L0463, Hydraulic Fluids and Lubricants, Technical Information

<table>
<thead>
<tr>
<th>Condition</th>
<th>mm²/s (cSt)</th>
<th>SUS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Minimum</td>
<td>7</td>
<td>47</td>
</tr>
<tr>
<td>Continuous</td>
<td>12-60</td>
<td>70-278</td>
</tr>
<tr>
<td>Maximum</td>
<td>1600</td>
<td>7500</td>
</tr>
</tbody>
</table>

TEMPERATURE

Maintain fluid temperature within the limits shown in the table. **Minimum temperature** relates to the physical properties of the component materials. Cold oil will not affect the durability of the motor components. However, it may affect the ability of the motor to transmit power. **Maximum temperature** is based on material properties: Don’t exceed it. Measure maximum temperature at the hottest point in the system. This is usually the case drain.

<table>
<thead>
<tr>
<th>Temperature limits</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Minimum (intermittent, cold start)</td>
<td>- 40° C [- 40° F]</td>
</tr>
<tr>
<td>Continuous</td>
<td>82.2° C [180° F]</td>
</tr>
<tr>
<td>Maximum</td>
<td>104.4° C [220° F]</td>
</tr>
</tbody>
</table>

Ensure fluid temperature and viscosity limits are concurrently satisfied.

CHARGE PRESSURE

All systems require a charge (positive pressure) in the low side of the system loop for proper lubrication and rotating group operation. Maintain low loop (charge) pressure at a minimum of 6 bar [87 psi] above case pressure. For more information, refer to Charge Pump, page 25.

CASE PRESSURE

Maintain case pressure within the limits shown in the table. Ensure housing is filled with hydraulic fluid.

<table>
<thead>
<tr>
<th>Case pressure limits</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Maximum (continuous)</td>
<td>1.7 bar [25 psi]</td>
</tr>
<tr>
<td>Intermittent (cold start)</td>
<td>5.2 bar [75 psi]</td>
</tr>
</tbody>
</table>

Caution

Operating outside of charge and case pressure limits will damage the pump. To minimize this risk, use full size inlet and case drain plumbing, and limit line lengths.
PRESSURE RATINGS

The table, *Operating parameters*, page 11, gives maximum and continuous pressure ratings for each displacement. Not all displacements operate under the same pressure limits. Definitions of the operating pressure limits appear below.

**System pressure** is the differential pressure between system ports A and B. It is the dominant operating variable affecting hydraulic unit life. High system pressure, which results from high load, reduces expected life. Maintain system pressure at or below continuous working pressure during normal operation to achieve expected life.

**Continuous working pressure** is the average, regularly occurring operating pressure. Operate at or below continuous working pressure for satisfactory product life.

**Maximum (peak) working pressure** is the highest intermittent pressure allowed. Do not allow machine load to exceed maximum (peak) working pressure.

All pressure limits are differential pressures referenced to low loop (charge) pressure. Subtract low loop pressure from gauge readings to compute the differential.

### System pressure limits

<table>
<thead>
<tr>
<th>Pressure Limits</th>
<th>bar</th>
<th>psi</th>
</tr>
</thead>
<tbody>
<tr>
<td>Continuous</td>
<td>210</td>
<td>3000</td>
</tr>
<tr>
<td>Maximum</td>
<td>345</td>
<td>5000</td>
</tr>
</tbody>
</table>

SPEED RATINGS

The table, *Operating parameters*, page 11, gives rated and maximum speeds for each displacement. Not all displacements operate under the same speed limits. Definitions of these speed limits appear below.

**Continuous speed** is the maximum recommended operating speed at full power condition. Operating at or below this speed should yield satisfactory product life. Do not exceed maximum motor speed during unloaded, on-road travel over level ground.

**Maximum speed** is the highest operating speed permitted. Exceeding maximum speed reduces pump life and can cause loss of hydrostatic power and braking capacity. Never exceed the maximum speed limit under any operating conditions.

⚠️ Warning

**Unintended vehicle or machine movement hazard.**

The loss of hydrostatic drive line power, in any mode of operation (forward, neutral, or reverse) may cause the system to lose hydrostatic braking capacity. You must provide a braking system, redundant to the hydrostatic transmission, sufficient to stop and hold the vehicle or machine in the event of hydrostatic drive power loss.
INLET PRESSURE

Achieving acceptable pump life and performance requires proper charge pump inlet design. A continuous inlet pressure of not less than 0.8 bar abs. (not more than 6.3 in. Hg vac.) is recommended. Normal pressure less than the minimum inlet pressure of 0.7 bar abs. (greater than 9.2 in. Hg vac.) indicates inadequate inlet design or a restricted filter. Pressures less than 0.7 bar abs. (greater than 9.2 in. Hg vac.) during cold start are possible, but should improve quickly as the fluid warms.

<table>
<thead>
<tr>
<th>Inlet pressure</th>
<th>bar absolute</th>
<th>in. Hg vacuum</th>
</tr>
</thead>
<tbody>
<tr>
<td>Continuous</td>
<td>0.8</td>
<td>6</td>
</tr>
<tr>
<td>Minimum</td>
<td>0.7</td>
<td>9.2 (max)</td>
</tr>
</tbody>
</table>

THEORETICAL OUTPUT

The theoretical maximum flow at rated speed is a simple function of pump displacement and speed. This is a good gauge for sizing a companion motor. This does not take into account losses due to leakage or variations in displacement. Refer to Performance, page 12, for volumetric and overall efficiencies at various operating conditions.
SIZING EQUATIONS

Use these equations to help choose the right pump size and displacement for your application.

**Based on SI units**

**Flow**

\[ Q = \frac{V_g \cdot n \cdot \eta_v}{1000} \] \( \text{liters/min} \)

**Torque**

\[ M = \frac{V_g \cdot \Delta p}{20 \cdot \pi \cdot \eta_m} \] \( \text{N\text{\textperiodcentered}m} \)

**Power**

\[ P = \frac{M \cdot n \cdot \pi}{30000} = \frac{Q \cdot \Delta p}{600 \cdot \eta_t} \] \( \text{kilowatts} \)

**Based on US units**

**Flow**

\[ Q = \frac{V_g \cdot n \cdot \eta_v}{231} \] \( \text{US gallons/min} \)

**Torque**

\[ M = \frac{V_g \cdot \Delta p}{2 \cdot \pi \cdot \eta_m} \] \( \text{lbf\text{\textperiodcentered}in} \)

**Power**

\[ P = \frac{M \cdot n \cdot \pi}{198000} = \frac{Q \cdot \Delta p}{1714 \cdot \eta_t} \] \( \text{horsepower} \)

**Variables**

- \( V_g \) = Displacement per revolution \( \text{cm}^3/\text{rev} \) [\( \text{in}^3/\text{rev} \)]
- \( p_o \) = Outlet pressure \( \text{bar} \) [\( \text{psi} \)]
- \( p_i \) = Inlet pressure \( \text{bar} \) [\( \text{psi} \)]
- \( \Delta p \) = \( p_o - p_i \) (system pressure) \( \text{bar} \) [\( \text{psi} \)]
- \( n \) = Speed \( \text{min}^{-1} \) (rpm)
- \( \eta_v \) = Volumetric efficiency
- \( \eta_m \) = Mechanical efficiency
- \( \eta_t \) = Overall efficiency \( (\eta_v \cdot \eta_m) \)
Ensure fluid entering pump is free of contaminants to prevent damage (including premature wear) to the system. Series 40 pumps require system filtration capable of maintaining fluid cleanliness at ISO 4406-1999 class 22/18/13 or better.

Consider these factors when selecting a system filter:
- Cleanliness specifications
- Contaminant ingression rates
- Flow capacity
- Desired maintenance interval

Locate filter either on the inlet (suction filtration) or discharge (charge pressure filtration) side of the charge pump. Series 40 pumps are available with provisions for either strategy.

Typically, a filter with a beta ratio of $\beta_{10} = 1.5$ to 2.0 is adequate. However, open circuit systems supplied from a common reservoir may have considerably higher requirements. Because each system is unique, only a thorough testing and evaluation program can fully validate the filtration system. For more information, see Sauer-Danfoss publication 520L06467, Design Guidelines for Hydraulic Fluid Cleanliness.

**Suction filtration**
The suction filter is placed in the circuit between the reservoir and the inlet to the charge pump as shown in the accompanying illustration.
FILTRATION (continued)

**Charge filtration**

Provision for charge pressure filtration is available on all Series 40 pumps. The pressure filter is remotely mounted in the circuit after the charge pump, as shown in the accompanying illustration.

Filters used in charge pressure filtration circuits must be rated to at least 34.5 bar [500 psi] pressure. A 100 - 125 µm screen located in the reservoir or in the charge inlet line is recommended when using charge pressure filtration.

A filter bypass valve is necessary to prevent filter damage and to avoid contaminants from being forced through the filter media by high pressure differentials across the filter. In the event of high pressure drop associated with a blocked filter or cold start-up conditions, fluid will bypass the filter. Avoid working with an open bypass for an extended period. We recommend a visual or electrical bypass indicator. Proper filter maintenance is mandatory.
**System design parameters**

**Warning**  
**Unintended vehicle or machine movement hazard.**  
The loss of hydrostatic drive line power, in any mode of operation (forward, neutral, or reverse) may cause the system to lose hydrostatic braking capacity. You must provide a braking system, redundant to the hydrostatic transmission, sufficient to stop and hold the vehicle or machine in the event of hydrostatic drive power loss.

**Loop flushing**  
Closed circuit systems may require loop flushing to meet temperature and cleanliness requirements. A loop flushing valve removes hot fluid from the low pressure side of the system loop for additional cooling and filtering. Ensure the charge pump provides adequate flow for loop flushing and the loop flushing valve does not cause charge pressure to drop below recommended limits.

**Reservoir**  
The reservoir provides clean fluid, dissipates heat, and removes entrained air from the hydraulic fluid. It allows for fluid volume changes associated with fluid expansion and cylinder differential volumes. Minimum reservoir capacity depends on the volume needed to perform these functions. Typically, a capacity of one half the charge pump flow (per minute) is satisfactory for a closed reservoir. Open circuit systems sharing a common reservoir require greater fluid capacity.

Locate the reservoir outlet (suction line) near the bottom, allowing clearance for settling foreign particles. Use a 100 - 125 µm screen covering the outlet port.

Place the reservoir inlet (return lines) below the lowest expected fluid level, as far away from the outlet as possible.

Use a baffle (or baffles) between the reservoir inlet and outlet ports to promote deaeration and reduce fluid surging.

**Case drain usage for tandem pumps**  
On tandem pumps, excess flow from the charge relief valve is routed into the housing of the front pump. In order to ensure adequate case flushing, it is recommended that the rear housing drain ports be used as the case drain.

M43/M44 tandem pumps with the option of opposing port endcaps do not follow the above rule.
**Bearing life** is a function of speed, pressure and swashplate angle plus any external loads. Other life factors include oil type and viscosity.

In vehicle propulsion drives with no external loads, where the speed, pressure, and swashplate angle are often changing, normal bearing B10 (90% survival) life will exceed the hydraulic unit life.

In non-propel drives, such as conveyors or fan drives, the operating speed and pressure may be nearly constant leading to a distinctive duty cycle compared to that of a propulsion drive. In these types of applications, a bearing life review is recommended.

Series 40 pumps are designed with bearings that can accept some incidental external radial and thrust loads. However, any amount of external load will reduce the expected bearing life.

The allowable radial shaft loads are a function of the load position, the load orientation, and the operating pressures of the hydraulic unit. All external shaft loads have an effect on bearing life. In applications where external shaft loads cannot be avoided, the impact on bearing life can be minimized by orienting the load to the 90 or 270 degree position.

The **maximum allowable radial loads** \( R_e \), based on the **maximum external moment** \( M_e \) and the distance \( L \) from the mounting flange to the load, may be determined from the tables below and drawings on the next page.

The maximum allowable radial load is calculated as:

\[
R_e = \frac{M_e}{L}
\]

Avoid thrust loads in either direction.

If continuously applied external radial loads are 25% or more of the maximum allowable, or thrust loads are known to occur, contact your Sauer-Danfoss representative for an evaluation of unit bearing life. Optional high capacity bearings are available.

Tapered output shafts or **clamp-type** couplings are recommended for applications where radial shaft side loads are present.

### Shaft loading parameters

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Definition</th>
</tr>
</thead>
<tbody>
<tr>
<td>( R_e )</td>
<td>Maximum radial load</td>
</tr>
<tr>
<td>( M_e )</td>
<td>Maximum external moment</td>
</tr>
<tr>
<td>( L )</td>
<td>Distance from mounting flange to point of load</td>
</tr>
<tr>
<td>( F_e )</td>
<td>Force of cylinder block</td>
</tr>
<tr>
<td>( T_e )</td>
<td>Thrust load</td>
</tr>
</tbody>
</table>

### Maximum external shaft moments

<table>
<thead>
<tr>
<th>( M_e / N\cdot m ) [in-lbf]</th>
<th>M25</th>
<th>M35/44</th>
<th>M46</th>
</tr>
</thead>
<tbody>
<tr>
<td>101 [890]</td>
<td>121 [1075]</td>
<td>186 [1650]</td>
<td></td>
</tr>
</tbody>
</table>
Hydraulic unit life is defined as the life expectancy of the hydraulic components. It is a function of speed and system pressure; however, system pressure is the dominant operating variable. High pressure, which results from high load, reduces expected life.

Design the hydraulic system to a projected machine duty cycle. Know the expected percentages of time at various loads and speeds. Ask your Sauer-Danfoss representative to calculate an appropriate pressure based on your hydraulic system design. If duty cycle data is not available, input power and pump displacement are used to calculate system pressure.

All pressure limits are differential pressures (referenced to charge pressure) and assume normal charge pressure.

Series 40 pumps will meet satisfactory life expectancy if applied within the parameters specified in this bulletin. For more detailed information on hydraulic unit life see BLN-9884, Pressure and Speed Limits.
**Shock load moment** is the result of an instantaneous jolt to the system. **Continuous load moments** are generated by the typical vibratory movement of the application. Avoid excessive loading of the mounting flange such as adding tandem mounted auxiliary pumps and/or subjecting pumps to high shock loads. Design pump applications to stay within the allowable shock load moment and allowable continuous load moment.

Use the following formulas to estimate overhung load moment for multiple pump mountings:

\[
M_s = G_s (W_1L_1 + W_2L_2 + \ldots + W_nL_n)
\]

\[
M_c = G_c (W_1L_1 + W_2L_2 + \ldots + W_nL_n)
\]

Refer to **Installation drawings**, page 52, to find pump length (L). Refer to the table **Specifications**, page 10, to find pump weight (W). An exact measure of W will depend on the pump’s features.

The tables below show allowable overhung load moment values. If system parameters exceed these values add additional pump support.

Estimated maximum and continuous acceleration factors for some typical Series 40 applications are shown. Applications which experience extreme resonant vibrations may require additional pump support. Typical continuous (vibratory) values can vary significantly due to changes in engine and pump configuration and mounting methods.

### Overhung loading parameters

<table>
<thead>
<tr>
<th>Frame size</th>
<th>Continuous load moment ((M_c)) [N(\cdot)m]</th>
<th>Shock load moment ((M_s)) [N(\cdot)m]</th>
</tr>
</thead>
<tbody>
<tr>
<td>M25 PV</td>
<td>361 [3200]</td>
<td>617 [5470]</td>
</tr>
<tr>
<td>M25 PT</td>
<td>361 [3200]</td>
<td>559 [4950]</td>
</tr>
<tr>
<td>M35 PV</td>
<td>517 [4600]</td>
<td>832 [7400]</td>
</tr>
<tr>
<td>M35 PT</td>
<td>517 [4600]</td>
<td>754 [6700]</td>
</tr>
<tr>
<td>M46 PV</td>
<td>517 [4600]</td>
<td>832 [7400]</td>
</tr>
<tr>
<td>M46 PT</td>
<td>517 [4600]</td>
<td>754 [6700]</td>
</tr>
</tbody>
</table>

### Shaft loading parameters

![Shaft loading parameters diagram]

<table>
<thead>
<tr>
<th>Application</th>
<th>Continuous (vibratory) acceleration ((G_c))</th>
<th>Maximum (shock) acceleration ((G_s))</th>
</tr>
</thead>
<tbody>
<tr>
<td>Skid steer loader</td>
<td>6</td>
<td>10</td>
</tr>
<tr>
<td>Trencher (rubber tires)</td>
<td>6</td>
<td>8</td>
</tr>
<tr>
<td>Asphalt paver</td>
<td>6</td>
<td>6</td>
</tr>
<tr>
<td>Windrower</td>
<td>6</td>
<td>5</td>
</tr>
<tr>
<td>Aerial lift</td>
<td>6</td>
<td>4</td>
</tr>
<tr>
<td>Turf care vehicle</td>
<td>6</td>
<td>4</td>
</tr>
<tr>
<td>Vibratory roller</td>
<td>6</td>
<td>10</td>
</tr>
</tbody>
</table>

* Applications which experience extreme resonant vibrations require additional pump support.
Series 40 Axial Piston Pumps
Technical Information
Product coding

MODEL CODE

Series 40 variable pump

Name plate

Model code modules

Displacement

Product

Type

C: Swashplate group
D: Seal group
E: Input shaft
F: Rotation
G: Charge pump displacement
H: Charge pressure relief setting
J: Filtration
K: Displacement limiters
L: Bypass valve
M: System pressure protection
N: Control
P: Control handle position
R: Control orifice diameters
S: Auxiliary mounting pad
T: Special hardware
Model code

The model code is a modular description of a specific product and its options. To create an order code to include the specific options desired, see the *Series 40 Pump Model Code Supplement* or the *Series 40 Price Book*.
Charge flow is required on all Series 40 units applied in closed circuit installations to make up for internal leakage, maintain positive pressure in the main circuit, provide flow for cooling, replace any leakage losses from external valving or auxiliary systems, and on M46 units, to provide flow and pressure for the control system.

Maintain rated charge pressure under all conditions of operation to prevent damage to the transmission.

All Series 40 pumps (except M25 pumps) may be equipped with integral charge pumps. These charge pump sizes have been selected to meet the needs of a majority of Series 40 applications.

Many factors influence the charge flow requirements and the resulting charge pump size selection. These factors include system pressure, pump speed, pump swashplate angle, type of fluid, temperature, size of heat exchanger, length and size of hydraulic lines, control response characteristics, auxiliary flow requirements, hydraulic motor type, etc. In most Series 40 applications a general guideline is that the charge pump displacement should be equal to or greater than 10% of the total displacement of all units in the system.

The total charge flow requirement is the sum of the charge flow requirements of each of the components in the system. Use the information provided on the following pages to make a charge pump selection for a given application.
System features and conditions that may invalidate the 10% of displacement rule include (but are not limited to):

- Operation at low input speeds (below 1500 RPM)
- Shock loading
- Excessively long system lines
- Auxiliary flow requirements
- Use of low speed high torque motors

If a charge pump of sufficient displacement to meet the 10% of displacement rule is not available or if any of the above conditions exist which could invalidate the 10% rule, contact your Sauer-Danfoss representative. A charge pump sizing worksheet is available in BLN-9885, Selection of Driveline Components.

M25 pumps do not allow for integral charge pumps. Other Series 40 pumps are also available without charge pumps. When an integral charge pump is not used, an external charge supply is required to ensure adequate charge pressure and cooling.
Series 40 Axial Piston Pumps
Technical Information
Features and options

**CHARGE RELIEF VALVE**

An integral charge pressure relief valve provides a relief outlet for charge pressure. This valve, in effect, sets charge pressure. Flow through the valve is ported to case.

The charge relief valve for the M25, M35, and M44 PV/PT is a flat poppet style valve. The M46 PV/PT uses a cone-style poppet valve.

The nominal charge relief setting is referenced to case pressure. It is factory set at 1800 min⁻¹ (rpm) with the pump in neutral position. A proper charge relief setting takes into account input speeds and control requirements.

The charge pressure setting for pumps without an internal charge pump is set with an externally supplied charge flow of 19 l/min [5 US gal/min] on pumps and 38 l/min [10 US gal/min] on tandem pumps. These units must have adequate charge flow supplied to the charge inlet in order to maintain charge pressure at all times.

Incorrect charge pressure settings may result in the inability to build required system pressure and/or inadequate loop flushing flows. Ensure correct charge pressure under all conditions of operation to maintain pump control performance.

The charge relief valve is factory set. If necessary, it can be field adjusted with shims.

*Charge relief valve specs*

<table>
<thead>
<tr>
<th></th>
<th>M25</th>
<th>M35</th>
<th>M44</th>
<th>M46</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Type</strong></td>
<td>Flat poppet valve</td>
<td>Cone poppet valve</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Available setting</strong></td>
<td>7.5-14 bar [110-200 psi]</td>
<td>19.5-26.2 bar [285-380 psi]</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Adjustment</strong></td>
<td>Via shims inside of valve cartridge*</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

*Shimming offers adjustment over a limited range, a spring change may be required to make a larger adjustment.

*Charge relief valve locations*

M25 PV

M35 & M44 PV

M46 PV
Charge check and high pressure relief valves maintain circuit pressure in the proper range. The check valves allow charge flow to replenish the low pressure side of the working loop. The high pressure relief valves provide pressure protection to the high pressure side of the working loop. There are two cartridge style valves to handle each side of the working loop with flow in either direction.

High pressure relief valves are available in a range of settings. You may specify individual port pressure settings. If high pressure relief valves are not desired, pumps may be equipped with charge circuit check valves only.

**Caution**

High pressure relief valves are intended for transient overpressure protection and are not intended for continuous pressure control. Flow over relief valves for extended periods of time may result in severe heat build up. High flows over relief valves may result in pressure levels exceeding the nominal valve setting and potential damage to system components.

### Check/high relief valve specs

<table>
<thead>
<tr>
<th>Type</th>
<th>Cartridge-style poppet valve</th>
</tr>
</thead>
<tbody>
<tr>
<td>Setting</td>
<td>140-345 bar (2030-5000 psi)</td>
</tr>
<tr>
<td>Option</td>
<td>Check only - no relief valve</td>
</tr>
</tbody>
</table>

### High pressure relief valve locations

- **M25 PV**
  - High pressure/check valve
- **M46 PV**
  - High pressure relief valve
- **Bypass valve**
- **M35 & M44PV**
Series 40 - M46 PV or PT units are designed with optional mechanical displacement (stroke) limiters located in the servo piston. You can limit maximum displacement of the pump to a certain per-cent of its maximum displacement to near zero in either direction.

Displacement limits are fixed physical stops inside the pump and are not externally adjustable. It is possible to configure an M46 pump with an externally adjustable displacement limiter screw on one side only. The screw is located on the side of the servo piston opposite the neutral adjustment screw.

⚠️ Warning
Take care in adjusting displacement limiters to avoid an undesirable condition of output flow or speed. Retorque the sealing lock nut after every adjustment to prevent an unexpected change in output conditions and to prevent external leakage during pump operation.

One full revolution of the adjustment screw produces a change in displacement of approximately 4 cm/rev [0.24 in/rev]. Full unit displacement is attained with the adjustment screw at its maximum extension from servo cover. All pumps are shipped with the limiter set for maximum pump displacement. An anti-tamper seal sleeve is provided.

Series 40 - M25, M35, and M44 pumps do not have displacement limiters.

*M46 Displacement limiter*
Auxiliary mounting pads are available on all Series 40 pumps. A sealed cover is included as standard equipment on all mounting pads.

An O-ring seals the auxiliary pump mounting flange to the pad. The drive coupling is lubricated with oil from the main pump case.

Spline specifications and torque ratings are shown in the accompanying table.

- All auxiliary mounting pads meet SAE J744 specifications.
- Do not exceed the maximum pump input shaft rating shown in the Shaft availability and torque ratings table on page 33.
- Applications subject to severe vibratory or high G loading require an additional structural support. This is necessary to prevent leaks and possible mounting flange damage. Refer to Mounting flange loads, p. 22, for additional information.

The drawing and table below show the dimensions of the auxiliary pump mounting flanges and shafts. Auxiliary pump mounting flanges and shafts with the dimensions noted are compatible with the auxiliary mounting pads on the Series 40 pumps.
AUXILIARY MOUNTING PADS AND AUXILIARY PUMPS
(continued)

Auxiliary mounting pads on Series 40 pumps

M25 PV

M3S & M44 PV

M46 PV

A Pad

B Pad

P100 593E
Series 40 pumps are available with a variety of splined, straight keyed, and tapered shaft ends. Nominal shaft sizes and torque ratings are shown in the table on the next page.

Torque ratings assume no external radial loading. **Continuous torque** ratings for splined shafts are based on splined tooth wear, and assume the mating spline has a minimum hardness of $R_c 55$ and full spline depth with good lubrication.

**Maximum torque** ratings are based on shaft torsional strength and assume a maximum of 200,000 load reversals.

**Recommended mating splines for Series 40 splined output shafts should be in accordance with ANSI B2.1 Class 5.** Sauer-Danfoss external splines are modified Class 5 Fillet Root Side Fit. The external splined Major Diameter and Circular Tooth Thickness dimensions are reduced in order to assure a clearance fit with the mating spline. Other shaft options may exist. Contact your Sauer-Danfoss representative for availability.
### M25 VARIABLE PUMP

<table>
<thead>
<tr>
<th>Code</th>
<th>Description</th>
<th>Torque rating</th>
<th>Continuous torque rating</th>
<th>Drawing</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>Maximum torque rating N•m [lbf•in]</td>
<td>Continuous torque rating N•m [lbf•in]</td>
<td></td>
</tr>
<tr>
<td>Y</td>
<td>Ø 22.20 mm [0.874 in] Straight keyed</td>
<td>140 [1240]</td>
<td>—</td>
<td><img src="image1" alt="Drawing Y" /></td>
</tr>
</tbody>
</table>

- 6.35 [0.250] Sq. key
- 0.38 [0.015] min. R on edges
- 2.84 max. [0.112]
- 22.20 dia. [0.874]
- Mounting flange (ref.)
- Coupling must not protrude beyond this surface

| A    | 13-tooth 16/32 pitch (ANSI B92.1 1970 - Class 5) | 140 [1240] | 85 [750] | ![Drawing A](image2) |

- 33.32 max [1.312]
- 16.5 [0.65] Full spline length
- 21.72 [0.855] dia.
- 20.638 [0.8125] Pitch dia
- 30° pressure angle
- 13 teeth, 16/32 pitch fillet root side fit per ANSI B92.1 class 5
- Also mates with flat root side fit

| C    | Ø 25.4 mm [1.000 in] 1:8 taper (SAE J501) | 140 [1240] | — | ![Drawing C](image3) |

- 6.35 [0.250] Sq. key
- 0.38 [0.015] min. R on edges
- 26.9 [1.06]
- 3/4-16 UNF-2B thd.
- 22.22 (0.875) Gauge dia.
- 38.1 [1.500] taper per foot per SAE J501
- 25.4 [1.000] nominal shaft dia.
- Except for 24.61 [0.969] dia as shown
- Coupling must not protrude beyond 25.40 [1.000] max.

Other shaft options may exist. Contact your Sauer-Danfoss representative for availability and for specific installation drawings.

Dimensions in mm [in]
### M25 TANDEM PUMP

<table>
<thead>
<tr>
<th>Code</th>
<th>Description</th>
<th>Torque rating</th>
<th>Continuous torque rating</th>
<th>Drawing</th>
</tr>
</thead>
<tbody>
<tr>
<td>Y</td>
<td>Ø 22.20 mm [0.874 in] Straight keyed</td>
<td>140 [1240]</td>
<td>—</td>
<td>![Diagram Y](P104 406E)</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Maximum torque rating N•m [lbf•in]</td>
<td>Continuous torque rating N•m [lbf•in]</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Ø 22.20 mm [0.874 in] Straight keyed</td>
<td>140 [1240]</td>
<td>—</td>
<td>![Diagram Y](P104 406E)</td>
</tr>
<tr>
<td>A</td>
<td>13-tooth 16/32 pitch (ANSI B92.1 1970 - Class 5)</td>
<td>140 [1240]</td>
<td>85 [750]</td>
<td>![Diagram A](P104 407E)</td>
</tr>
<tr>
<td>C</td>
<td>Ø 25.4 mm [1.000 in] 1:8 taper (SAE J501)</td>
<td>140 [1240]</td>
<td>—</td>
<td>![Diagram C](P104 405E)</td>
</tr>
</tbody>
</table>

Other shaft options may exist. Contact your Sauer-Danfoss representative for availability and for specific installation drawings.

Dimensions in mm [in]
### M35/44 VARIABLE PUMP

<table>
<thead>
<tr>
<th>Code</th>
<th>Description</th>
<th>Torque rating</th>
<th>Drawing</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>Maximum torque rating N-m [lbf-in]</td>
<td>Continuous torque rating N-m [lbf-in]</td>
</tr>
<tr>
<td>Y</td>
<td>Ø 22.20 mm [0.874 in] Straight keyed</td>
<td>226 [2000]</td>
<td>—</td>
</tr>
<tr>
<td>N</td>
<td>Ø 25.4 mm [1.000 in] 1:8 taper (SAE J501)</td>
<td>497 [4400]</td>
<td>—</td>
</tr>
</tbody>
</table>

**Shaft option**

<table>
<thead>
<tr>
<th>Shaft dia.</th>
<th>Full spline Major dia.</th>
<th>Pitch dia.</th>
<th>No. teeth</th>
</tr>
</thead>
<tbody>
<tr>
<td>T</td>
<td>U</td>
<td>V</td>
<td>W</td>
</tr>
<tr>
<td>G</td>
<td>21.97 [0.865]</td>
<td>18.5 [0.73]</td>
<td>24.89 [0.980]</td>
</tr>
<tr>
<td>A</td>
<td>18.8 [0.74]</td>
<td>16.5065</td>
<td>21.72 [0.855]</td>
</tr>
</tbody>
</table>

Other shaft options may exist. Contact your Sauer-Danfoss representative for availability and for specific installation drawings.
## M35/44 TANDEM PUMP

### Shaft options

<table>
<thead>
<tr>
<th>Code</th>
<th>Description</th>
<th>Torque rating</th>
<th>Continuous torque rating</th>
<th>Drawing</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>Maximum torque rating N•m [lbf•in]</td>
<td>Continuous torque rating N•m [lbf•in]</td>
<td></td>
</tr>
<tr>
<td>Y</td>
<td>Ø 22.20 mm [0.874 in] Straight keyed</td>
<td>226 [2000]</td>
<td>—</td>
<td><img src="#" alt="Diagram Y" /></td>
</tr>
<tr>
<td>N</td>
<td>Ø 25.4 mm [1.000 in] 1:8 taper (SAE J501)</td>
<td>497 [4400]</td>
<td>—</td>
<td><img src="#" alt="Diagram N" /></td>
</tr>
</tbody>
</table>

Other shaft options may exist. Contact your Sauer-Danfoss representative for availability and for specific installation drawings.

Dimensions in mm [in]
# M46 VARIABLE PUMP

<table>
<thead>
<tr>
<th>Code</th>
<th>Description</th>
<th>Torque rating</th>
<th>Drawing</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>Maximum torque rating N·m [lbf·in]</td>
<td>Continuous torque rating N·m [lbf·in]</td>
</tr>
<tr>
<td>V</td>
<td>Ø 25.37 mm [0.999 in] Straight keyed</td>
<td>362 [3200]</td>
<td>—</td>
</tr>
<tr>
<td>W</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>N</td>
<td>Ø 25.4 mm [1.000 in] 1:8 taper (SAE J501)</td>
<td>497 [4400]</td>
<td>—</td>
</tr>
<tr>
<td>P</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>R</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>S</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Other shaft options may exist. Contact your Sauer-Danfoss representative for availability and for specific installation drawings.

Dimensions in mm [in]
## Series 40 Axial Piston Pumps
### Technical Information

#### Shaft options

**M46 VARIABLE PUMP**

<table>
<thead>
<tr>
<th>Code</th>
<th>Description</th>
<th>Torque rating</th>
<th>Code description</th>
<th>Drawing</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>Maximum torque rating N•m [lbf•in]</td>
<td>Continuous torque rating N•m [lbf•in]</td>
<td></td>
</tr>
</tbody>
</table>

**Shaft option**

<table>
<thead>
<tr>
<th>Shaft option</th>
<th>Length S</th>
<th>Shaft dia. T</th>
<th>Full spline U</th>
<th>Major dia. V</th>
<th>Pitch dia. W</th>
<th>No. teeth Y</th>
</tr>
</thead>
<tbody>
<tr>
<td>G, H, J &amp; K</td>
<td>37.7 [1.485]</td>
<td>22.3 (0.88)</td>
<td>23.4 (0.92)</td>
<td>24.89 [0.9800]</td>
<td>23.81 [0.9375]</td>
<td>15</td>
</tr>
<tr>
<td>A, B &amp; D</td>
<td>32.9 [1.297]</td>
<td>20.3 (0.80)</td>
<td>16.26 (0.64)</td>
<td>21.72 [0.8550]</td>
<td>20.64 [0.8125]</td>
<td>13</td>
</tr>
<tr>
<td>E, X &amp; Z</td>
<td>54.74 [2.155]</td>
<td>22.3 (0.88)</td>
<td>39.88 (1.57)</td>
<td>24.89 [0.9800]</td>
<td>23.81 [0.9375]</td>
<td>15</td>
</tr>
<tr>
<td>Z</td>
<td>31.82 [1.249]</td>
<td>22.3 (0.88)</td>
<td>36.83 (1.45)</td>
<td>24.89 [0.9800]</td>
<td>23.81 [0.9375]</td>
<td>15</td>
</tr>
</tbody>
</table>

Dimensions in mm [in]

Other shaft options may exist. Contact your Sauer-Danfoss representative for availability and for specific installation drawings.
## M46 TANDEM PUMP

<table>
<thead>
<tr>
<th>Code</th>
<th>Description</th>
<th>Torque rating</th>
<th>Drawing</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>Maximum torque rating</td>
<td>Continuous torque rating</td>
</tr>
<tr>
<td></td>
<td></td>
<td>N•m [lbf•in]</td>
<td>N•m [lbf•in]</td>
</tr>
<tr>
<td>J</td>
<td>Ø 25.37 mm [0.999 in] Straight keyed</td>
<td>362 [3200]</td>
<td>—</td>
</tr>
<tr>
<td></td>
<td>6.35 [0.250] sq. key 44.45 [1.75] long 0.38 [0.015] min. R on edges</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>25.37 [0.999] dia. 69.47 [2.735]</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Mounting flange (ref.) 7.47 [0.294]</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Coupling must not protrude beyond this surface</td>
<td></td>
<td></td>
</tr>
<tr>
<td>C</td>
<td>Ø 25.4 mm [1.000 in] 1:8 taper (SAE J501)</td>
<td>497 [4400]</td>
<td>—</td>
</tr>
<tr>
<td></td>
<td>42.8 [1.685]</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>6.35 [0.250] Sq. key 19.05 [0.75] long 0.38 [0.015] min. R on edges</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>0.750-16 UNF-2 thd. 2.84 [0.112] max</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>22.2 [0.875] Gauge dia.</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>1.50 taper per foot per SAE standard J501</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>24.5 [1.000] Nominal shaft dia.</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>33.3 [1.311] gauge dim</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Other shaft options may exist. Contact your Sauer-Danfoss representative for availability and for specific installation drawings.

Dimensions in mm [in]
Series 40 Axial Piston Pumps
Technical Information
Shaft options

### M46 TANDEM PUMP

<table>
<thead>
<tr>
<th>Code</th>
<th>Description</th>
<th>Torque rating</th>
<th>Continuous torque rating</th>
<th>Drawing</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>Maximum torque rating N•m [lbf•in]</td>
<td>Continuous torque rating N•m [lbf•in]</td>
<td></td>
</tr>
<tr>
<td>T</td>
<td>Ø 25.4 mm [1.000 in] 1:8 taper (SAE J501)</td>
<td>497 [4400]</td>
<td>—</td>
<td>[Diagram](P104 421E)</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>A</td>
<td>15-tooth 16/32 pitch (ANSI B92.1 1970 - Class 5)</td>
<td>362 [3200]</td>
<td>153 [1350]</td>
<td>[Diagram](P104 416E)</td>
</tr>
<tr>
<td>B</td>
<td>19-tooth 16/32 pitch (ANSI B92.1 1970 - Class 5)</td>
<td>734 [3500]</td>
<td>305 [2700]</td>
<td></td>
</tr>
</tbody>
</table>

#### Torque rating

<table>
<thead>
<tr>
<th>Code</th>
<th>Description</th>
<th>Maximum torque rating N•m [lbf•in]</th>
<th>Continuous torque rating N•m [lbf•in]</th>
</tr>
</thead>
<tbody>
<tr>
<td>T</td>
<td>Ø 25.4 mm [1.000 in] 1:8 taper (SAE J501)</td>
<td>497 [4400]</td>
<td>—</td>
</tr>
<tr>
<td>B</td>
<td>19-tooth 16/32 pitch (ANSI B92.1 1970 - Class 5)</td>
<td>734 [3500]</td>
<td>305 [2700]</td>
</tr>
</tbody>
</table>

#### Shaft options

<table>
<thead>
<tr>
<th>Shaft option</th>
<th>Max. coupling engagement</th>
<th>Shaft dia.</th>
<th>Full spline Major dia.</th>
<th>Pitch dia.</th>
<th>No teeth</th>
</tr>
</thead>
<tbody>
<tr>
<td>S</td>
<td>T</td>
<td>U</td>
<td>V</td>
<td>W</td>
<td>Y</td>
</tr>
<tr>
<td>A</td>
<td>37.7 [1.49]</td>
<td>22.4</td>
<td>23.4</td>
<td>24.89</td>
<td>20.638</td>
</tr>
<tr>
<td>B</td>
<td>37.7 [1.49]</td>
<td>28.7</td>
<td>24.1</td>
<td>31.24</td>
<td>30.163</td>
</tr>
</tbody>
</table>

Dimensions in mm [in]

Other shaft options may exist. Contact your Sauer-Danfoss representative for availability and for specific installation drawings.
Series 40 Axial Piston Pumps
Technical Information
Control options

**DIRECT DISPLACEMENT CONTROL (DDC) M25, M35/44 VARIABLE PUMPS**

The Direct Displacement Control (DDC) can be located on either side of a Series 40 - M25, M35, or M44 pump. It provides a simple, positive method of control. Movement of the control shaft causes a proportional swashplate movement, thus varying the pump's displacement from full displacement in one direction to full displacement in the opposite direction.

Some applications (generally vehicle propel) require a provision for non-linear control input to reduce control sensitivity near neutral. Damping or frictional forces may be necessary to produce desirable control feel.

Neutral position is not factory set, nor is there any internal neutral return mechanism. The application must include provisions for all control linkage and neutral return functionality.

With no external forces applied to the swashplate trunnion, internal hydraulic forces may not return the swashplate to the neutral position under all conditions of operation.

The DDC is available on variable pumps and tandem pumps.

**External control handle requirements**

Maximum allowable trunnion torque is 79.1 N·m [700 in·lbf] for M25, M35, and M44. Minimum torque necessary to hold the swashplate at a zero angle for neutral is 2.3 N·m [20 in·lbf]. Maximum trunnion angle is 15° for M25 and 16° for M35 and M44.

**DDC on Left Side of M35 Pump**

<table>
<thead>
<tr>
<th>DDC input specs</th>
</tr>
</thead>
<tbody>
<tr>
<td>Max torque</td>
</tr>
<tr>
<td>Min torque</td>
</tr>
<tr>
<td>Max angle</td>
</tr>
</tbody>
</table>

**Pump flow direction**

<table>
<thead>
<tr>
<th>Input shaft rotation</th>
<th>CW</th>
<th>CCW</th>
<th>Left</th>
<th>CW</th>
<th>CCW</th>
<th>Left</th>
<th>CW</th>
<th>CCW</th>
</tr>
</thead>
<tbody>
<tr>
<td>Trunnion location</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Trunnion rotation</td>
<td>CW</td>
<td>CCW</td>
<td>CW</td>
<td>CCW</td>
<td>CW</td>
<td>CCW</td>
<td>CW</td>
<td>CCW</td>
</tr>
<tr>
<td>PV or front PV</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Port A Flow</td>
<td>Out</td>
<td>In</td>
<td>In</td>
<td>Out</td>
<td>In</td>
<td>Out</td>
<td>In</td>
<td>Out</td>
</tr>
<tr>
<td>Port B Flow</td>
<td>In</td>
<td>Out</td>
<td>Out</td>
<td>In</td>
<td>Out</td>
<td>In</td>
<td>In</td>
<td>Out</td>
</tr>
<tr>
<td>Rear PT</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Port C (A) Flow</td>
<td>In</td>
<td>Out</td>
<td>Out</td>
<td>In</td>
<td>Out</td>
<td>In</td>
<td>In</td>
<td>Out</td>
</tr>
<tr>
<td>Port D (B) Flow</td>
<td>Out</td>
<td>In</td>
<td>In</td>
<td>Out</td>
<td>In</td>
<td>Out</td>
<td>In</td>
<td>Out</td>
</tr>
</tbody>
</table>
The Manual Displacement Control (MDC) converts a mechanical input signal to a hydraulic signal with a spring centered 4-way servo valve, and ports hydraulic pressure to either side of a double acting servo piston. The MDC provides output flow to the servo piston in proportion to the angular position of the control handle. The servo piston tilts the cradle swashplate, thus varying the pump’s displacement from full displacement in one direction to full displacement in the opposite direction.

Due to normal operating force changes, the swashplate tends to drift from the position preset by the machine operator. Drift, sensed by the feedback linkage system connecting the swashplate to the control valve, activates the valve and supplies pressure to the servo piston, maintaining the swashplate in its preset position.

**Features:**
- The MDC is a high gain control: with only a small movement of the control handle (input signal) the control valve moves to a full open position porting maximum flow to the servo cylinder. This is a high response control system with low input forces.
- Mechanical feedback senses swashplate reactions to load.
- Precision parts provide repeatable, accurate displacement settings with a given input signal.
- To facilitate self centering, both ends of the double-acting servo piston are drained to case when a mechanical input signal is not present. The servo piston is coupled to a spring centering mechanism.

**Benefits:**
- Simple-low cost design.
- Pump output is maintained regardless of load.
- Pump will return to neutral after prime mover shuts down.
- Pump returns to neutral if external control linkage becomes disconnected from the control handle or if there is a loss of charge pressure.
**Series 40 Axial Piston Pumps**

**Technical Information**

**Control options**

**MDC on M46 PV**

*Handle up* option shown

**MDC with NSS M46 PV**

**MDC Hydraulic schematic**

**Pump flow direction with MDC control**

<table>
<thead>
<tr>
<th>MDC on M46 PV</th>
<th>MDC with NSS M46 PV</th>
<th>MDC Hydraulic schematic</th>
<th>Pump flow direction with MDC control</th>
</tr>
</thead>
</table>

**Response Time**

The time required for the pump output flow to change from neutral to full flow (acceleration) or full flow to neutral (deceleration) is a function of the size of the supply orifice in the control inlet passage and the size of the drain orifice in the control sleeve.

A range of orifice sizes is available to assist in matching the rate of swashplate response to the acceleration and deceleration requirements of the application. The table at right shows some sample response times under certain conditions. (These figures assume 1775 min⁻¹ (rpm), 140 bar [2000 psi] system pressure, and 20 bar [290 psi] charge pressure.) Test system pressure to determine the proper orifice sizes for the desired response.

**MDC Response time**

<table>
<thead>
<tr>
<th>Orifice diameter*</th>
<th>Average response time</th>
</tr>
</thead>
<tbody>
<tr>
<td>mm [in]</td>
<td>[seconds]</td>
</tr>
<tr>
<td>Supply</td>
<td>Drain</td>
</tr>
<tr>
<td>Acceleration</td>
<td>Deceleration</td>
</tr>
<tr>
<td>0.9 [0.036]</td>
<td>0.8 [0.031]</td>
</tr>
<tr>
<td>0.9 [0.036]</td>
<td>1.2 [0.046]</td>
</tr>
<tr>
<td>1.4 [0.054]</td>
<td>1.2 [0.046]</td>
</tr>
<tr>
<td>None</td>
<td>6.4 [0.050]</td>
</tr>
</tbody>
</table>

*Contact Sauer-Danfoss for special orifice combinations.

Refer to pump installation drawing for port locations.
External control handle requirements
Rotation of the control handle to reach full pump displacement is 20°. Maximum handle rotation is 25°. There is a neutral deadband of ±1.5° (±3.0° with NSS option). A nominal control handle torque of 1.2 N•m [11 in•lbf] is required to begin handle rotation (1°) and 1.7 N•m [15 in•lbf] is required to reach full stroke (20° handle rotation). An optional high rate return spring is available which requires 2.5 N•m [22 in•lbf] and 3.4 N•m [30 in•lbs] to reach 1° and 20° respectively. The maximum allowable handle input torque is 17 N•m [150 in•lbf].

Handle direction
The MDC handle can be configured in either the up or down positions. The up position is shown on the previous page. The down position is oriented 180° of the up position.

Neutral start switch (NSS)
This safety feature is an option to prevent start-up when the pump is not in neutral. It provides an electrical switch contact which is closed when the control handle is in its neutral (0°) position. The switch contact will open when the control handle is rotated 1.5 to 2° clockwise (CW) or counterclockwise (CCW) from neutral. The switch is rated at 5 amperes inductive load at 12 or 24 Vdc. The NSS should be wired in series with the engine starting circuit and is intended to verify the neutral position of the pump before allowing the engine to start.

This switch is available with screw terminals (no connector) or with a Packard Weather-Pack™ 2-way sealed connector.

Pump displacement vs control lever rotation

<table>
<thead>
<tr>
<th>Handle configuration</th>
<th>Swashplate position (ref. above chart)</th>
<th>Swashplate movement begins (point A) degrees</th>
<th>Full displacement reached (point B) degrees</th>
</tr>
</thead>
<tbody>
<tr>
<td>Standard</td>
<td>1.5°</td>
<td>20°</td>
<td></td>
</tr>
<tr>
<td>with NSS</td>
<td>3.0°</td>
<td>20°</td>
<td></td>
</tr>
</tbody>
</table>

NSS specifications

<table>
<thead>
<tr>
<th>Switch position on neutral</th>
<th>Closed</th>
</tr>
</thead>
<tbody>
<tr>
<td>Neutral play</td>
<td>±1.5°–2°</td>
</tr>
<tr>
<td>VDC</td>
<td>12 or 24</td>
</tr>
<tr>
<td>Rated current (A)</td>
<td>5</td>
</tr>
<tr>
<td>Connector type</td>
<td>Screw or Weather-Pack™</td>
</tr>
</tbody>
</table>
The Hydraulic Displacement Control (HDC) is a two stage design which uses a hydraulic input signal to operate a spring centered 4-way servo valve, which ports hydraulic pressure to either side of a double acting servo piston. The servo piston tilts the cradle swashplate, thus varying the pump’s displacement from full displacement in one direction to full displacement in the opposite direction.

The HDC provides output flow in proportion to a hydraulic command signal. This allows for remote control of the machine with a hydraulic pressure source rather than with mechanical linkage. With no command signal, the control returns to neutral position.

**Features**

- The hydraulic displacement control is a high gain control: with only a small change in the input signal pressure level, the servo valve moves to a full open position, porting maximum flow to the servo cylinder.
- Internal mechanical stops on the servo valve allow rapid changes in input signal pressure without damaging the control mechanism.
- Precision parts provide repeatable, accurate displacement settings with a given input signal.
- Both ends of the double-acting servo piston are drained to case when input signal pressure is not present. The servo piston is coupled to a spring centering mechanism.

**Benefits**

- Simple, low-cost design.
- Pump will return to neutral after prime mover shuts down.
- Pump will return to neutral if external hydraulic input signal fails or if there is a loss of charge pressure.

**HDC Hydraulic Schematic**
Pump flow direction with HDC control

<table>
<thead>
<tr>
<th>Input Shaft Rotation</th>
<th>CW</th>
<th>CCW</th>
</tr>
</thead>
<tbody>
<tr>
<td>PV or front PT</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Higher pressure into control port:</td>
<td>X1</td>
<td>X2</td>
</tr>
<tr>
<td>Port A flow</td>
<td>Out</td>
<td>In</td>
</tr>
<tr>
<td>Port B flow</td>
<td>In</td>
<td>Out</td>
</tr>
<tr>
<td>Rear PT</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Higher pressure into control port:</td>
<td>X1</td>
<td>X2</td>
</tr>
<tr>
<td>Port C flow</td>
<td>In</td>
<td>Out</td>
</tr>
<tr>
<td>Port D flow</td>
<td>Out</td>
<td>In</td>
</tr>
<tr>
<td>High servo gauge port</td>
<td>M4</td>
<td>M5</td>
</tr>
</tbody>
</table>

Refer to pump installation drawing for port locations.

Response time
The time required for the pump output flow to change from neutral to full flow (acceleration) or full flow to neutral (deceleration) is a function of the size of the orifices in the servo passages.

A range of orifice sizes is available to assist in matching the rate of swashplate response to the acceleration and deceleration requirements of the application. The table below shows some sample response times under certain conditions. (These figures assume 1775 min⁻¹ (rpm), 140 bar [2000 psi] system pressure, and 20 bar [290 psi] charge pressure.) Test system response to determine the proper orifice selection for the desired response.

Control input signal requirements
The standard command signal range required to stroke the pump between neutral and full stroke is 1.3 to 11.7 bar [19 to 170 psi] differential. The maximum command pressure must not exceed 27.5 bar [400 psi].

HDC options
The HDC can be tailored to respond to a higher signal pressure. Optional heavy spring packs are available that operate in the 3 to 14 bar [44 to 200 psi] range and the 5 to 15 bar [70 to 220 psi] range.

HDC response time

<table>
<thead>
<tr>
<th>Orifice diameter* (mm [in])</th>
<th>Average response time (seconds)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Acceleration</td>
</tr>
<tr>
<td>0.9 [0.037]</td>
<td>1.6</td>
</tr>
<tr>
<td>1.4 [0.055]</td>
<td>0.9</td>
</tr>
<tr>
<td>None</td>
<td>0.4</td>
</tr>
</tbody>
</table>

*Contact Sauer-Danfoss for special orifice combinations

Pump displacement vs hydraulic signal

Signal pressure

Pump displacement

Signal pressure

100%
The Electrical Displacement Control (EDC) is a three stage control similar to the HDC, but it uses an electrohydraulic Pressure Control Pilot (PCP) valve to control the pilot pressure. The PCP valve converts an electrical input signal to a hydraulic signal to operate a spring centered 4-way servo valve, which ports hydraulic pressure to either side of a double acting servo piston. The servo piston tilts the cradle swashplate, thus varying the pump's displacement from full displacement in one direction to full displacement in the opposite direction.

The EDC provides output flow in proportion to a DC electrical command signal (current). This control is suited for applications where remote or automatic control of system function is required, or where closed loop feedback is needed. With no electrical command signal, the control returns to the neutral position.

**Features:**
- The EDC is a high gain control: with only a small change in the input current, the servo valve moves to a full open position thus porting maximum flow to the servo cylinder.
- Oil filled PCP valve case lengthens control life by preventing moisture ingestion and dampening component vibrations.
- Internal mechanical stops on the servo valve allow rapid changes in input signal voltages without damaging the control mechanism.
- Precision parts provide repeatable accurate displacement settings with a given input signal.
- Both ends of the double acting servo piston are drained to case when input signal current is not present. The servo piston is coupled to a spring centering mechanism.

**Benefits:**
- Simple, low-cost design.
- Pump will return to neutral after prime mover shuts down.
- Pump will return to neutral if external electrical input signal fails or if there is a loss of charge pressure.

### HDC Signal requirement for swashplate position

<table>
<thead>
<tr>
<th>Configuration</th>
<th>Swashplate movement begins (point A)</th>
<th>Full displacement reached (point B)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>bar</td>
<td>psi</td>
</tr>
<tr>
<td>Standard</td>
<td>1.3±0.5</td>
<td>19±7</td>
</tr>
<tr>
<td>Option</td>
<td>3.0±0.7</td>
<td>44±10</td>
</tr>
<tr>
<td>Option</td>
<td>5.0±0.7</td>
<td>70±10</td>
</tr>
</tbody>
</table>

### HDC Input specs

<table>
<thead>
<tr>
<th>Max. input pressure</th>
<th>bar</th>
<th>psi</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>27.5</td>
<td>400</td>
</tr>
</tbody>
</table>
**Series 40 Axial Piston Pumps**

**Technical Information**

**Control options**

---

**EDC on M46 PV**

**Pump flow direction with EDC control**

<table>
<thead>
<tr>
<th></th>
<th>Input shaft rotation</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>CW</td>
</tr>
<tr>
<td>PV or front PT</td>
<td>A</td>
</tr>
<tr>
<td>Port A Flow</td>
<td>Out</td>
</tr>
<tr>
<td>Port B Flow</td>
<td>In</td>
</tr>
<tr>
<td>Rear PT</td>
<td>A</td>
</tr>
<tr>
<td>Positive signal to pin:</td>
<td>A</td>
</tr>
<tr>
<td>Port C flow</td>
<td>In</td>
</tr>
<tr>
<td>Port D flow</td>
<td>Out</td>
</tr>
<tr>
<td>High servo gauge port</td>
<td>M4</td>
</tr>
</tbody>
</table>

**EDC Signal required for swash**

<table>
<thead>
<tr>
<th>Coil configuration</th>
<th>Swashplate position (ref about chart)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Swashplate movement begins (point A) mA</td>
</tr>
<tr>
<td>Single coil</td>
<td>16 ± 5</td>
</tr>
<tr>
<td>Dual coil in series</td>
<td>1.5 ± 3</td>
</tr>
<tr>
<td>Dual coil in parallel</td>
<td>23 ± 6</td>
</tr>
</tbody>
</table>

---

**EDC Hydraulic Schematic**
Response time
The time required for the pump output flow to change from neutral to full flow (acceleration) or full flow to neutral (deceleration) is a function of the size of the orifices in the servo passages.

A range of orifice sizes is available to assist in matching the rate of swashplate response to the acceleration and deceleration requirements of the application. The table below shows some sample response times under certain conditions. (These figures assume 1775 min⁻¹ (rpm), 140 bar [2000 psi] system pressure, and 20 bar [290 psi] charge pressure.) Test system response to determine the proper orifice selection for the desired response.

Control input signal requirements
The required pump command current signal is 16 mA (nominal) threshold and a maximum of 90 mA (nominal) to provide full pump displacement with a 12 VDC source. The maximum command current must be less than 250 mA to prevent damage to the input coil.

Electrical displacement control options
The standard EDC is a single coil, Packard Weather-Pack™ connector device, with an oil filled case. Options include:

- Dual coil - A dual coil control allows utilization of two command sources, the resulting signal being the algebraic sum of the two. Dual coils allow operation of a machine from either the operator’s station or the ground.
- MS connectors - MS connectors provide a mechanical, threaded retention interface between the connector halves. Most military applications require MS connectors.

For further information refer to Sauer-Danfoss publication 95-8988.

### EDC response time

<table>
<thead>
<tr>
<th>Orifice diameter* [mm [in]]</th>
<th>Average response time (seconds)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Acceleration</td>
</tr>
<tr>
<td>0.9 [0.037]</td>
<td>1.6</td>
</tr>
<tr>
<td>1.4 [0.055]</td>
<td>0.9</td>
</tr>
<tr>
<td>None</td>
<td>0.4</td>
</tr>
</tbody>
</table>

*Contact Sauer-Danfoss for special orifice combinations.

### EDC Input specs

<p>| | |</p>
<table>
<thead>
<tr>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Coils</td>
<td>Single or dual</td>
</tr>
<tr>
<td>Connectors</td>
<td>Weather-Pack™ or MS</td>
</tr>
<tr>
<td>Coils resistance</td>
<td>23 Ohms</td>
</tr>
<tr>
<td>Max input current</td>
<td>250 mA</td>
</tr>
</tbody>
</table>

For further information refer to Sauer-Danfoss publication 95-8988.
THREE-POSITION ELECTRICAL CONTROL (FNR)

The three-position Forward-Neutral-Reverse (FNR) is a two stage control that uses a solenoid operated 3-position, 4-way valve to move pump displacement from neutral to maximum displacement in either direction.

When a solenoid is energized, charge pressure is directed to one end of the pump servo control cylinder, which results in the pump going to maximum displacement. The direction of pump output flow is determined by which solenoid is energized. (See the accompanying table on next page.)

Features and benefits
- Electric control.
- If voltage is lost, the control returns pump to neutral.
- Simple, low-cost design.
- Ideal for applications that do not require proportional control.

FNR Hydraulic schematic

FNR Control on M46 PV

Pump flow direction with FNR control

<table>
<thead>
<tr>
<th>Input shaft rotation</th>
<th>CW</th>
<th>CCW</th>
</tr>
</thead>
<tbody>
<tr>
<td>PV or front PT</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Solenoid energized</td>
<td>A</td>
<td>B</td>
</tr>
<tr>
<td>Port A flow</td>
<td>Out</td>
<td>In</td>
</tr>
<tr>
<td>Port B flow</td>
<td>In</td>
<td>Out</td>
</tr>
<tr>
<td>Rear PT</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Solenoid energized</td>
<td>A</td>
<td>B</td>
</tr>
<tr>
<td>Port C flow</td>
<td>In</td>
<td>Out</td>
</tr>
<tr>
<td>Port D flow</td>
<td>Out</td>
<td>In</td>
</tr>
<tr>
<td>High servo gauge port</td>
<td>M4</td>
<td>M5</td>
</tr>
</tbody>
</table>

Refer to dimensions for solenoid and port locations
Series 40 Axial Piston Pumps
Technical Information
Control options

Response time
The time required for the pump output flow to change from neutral to full flow (acceleration) or full flow to neutral (deceleration) is a function of the size of the orifices in the servo passages.

A range of orifice sizes is available to assist in matching the rate of swashplate response to the acceleration and deceleration requirements of the application. The table below shows some sample response times under certain conditions. (These figures assume 1775 min⁻¹ (rpm), 140 bar [2000 psi] system pressure, and 20 bar [290 psi] charge pressure.) Test system response to determine the proper orifice selection for the desired response.

Control input signal requirements
The solenoids are available in versions for 12 or 24 VDC. Maximum power consumption is 30 Watts. They are available with terminals for a DIN 43650 connector or with a Packard Weather-Pack™ 2-way sealed connector.

<table>
<thead>
<tr>
<th>Orifice diameter (mm [in])</th>
<th>Average response time (seconds)</th>
<th>FNR response time</th>
<th>FNR input specifications</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Acceleration</td>
<td>Deceleration</td>
<td>VDC</td>
</tr>
<tr>
<td>0.9 [0.037]</td>
<td>1.3</td>
<td>0.9</td>
<td>12 or 24</td>
</tr>
<tr>
<td>1.4 [0.055]</td>
<td>0.5</td>
<td>0.4</td>
<td>30 W</td>
</tr>
<tr>
<td>None</td>
<td>0.1</td>
<td>0.1</td>
<td>DIN 43650 or Weather-Pack™</td>
</tr>
</tbody>
</table>
**Series 40 Axial Piston Pumps**

**Technical Information**

**Installation drawings**

### M25 VARIABLE PUMP DIMENSIONS

**Auxiliary mounting flange**

*All ports are SAE straight thread o-ring ports per SAE J514, unless otherwise specified. Shaft rotation is determined by viewing pump from input shaft end. Contact your SAUER-DANFOSS representative for specific installation drawings.*

<table>
<thead>
<tr>
<th>Auxiliary mounting flange</th>
<th>Spline pitch dia.</th>
<th>Number of teeth</th>
<th>Shaft clearance</th>
<th>Coupling clearance</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>P</td>
<td>N</td>
<td>Y</td>
<td>M</td>
</tr>
<tr>
<td>SAE A Option A</td>
<td>14.30</td>
<td>9</td>
<td>34.5</td>
<td>22.6</td>
</tr>
<tr>
<td></td>
<td>(0.563)</td>
<td></td>
<td>(1.36)</td>
<td></td>
</tr>
<tr>
<td>SAE A Option D</td>
<td>17.46</td>
<td>11</td>
<td>39.6</td>
<td>25.9</td>
</tr>
<tr>
<td></td>
<td>(0.688)</td>
<td></td>
<td>(1.56)</td>
<td></td>
</tr>
</tbody>
</table>

Dimensions in mm [in]

*Dimensions in mm [in]*
M25 VARIABLE PUMP
DIMENSIONS
(continued)

- All ports are SAE straight thread o-ring ports per SAE J514, unless otherwise specified.
- Shaft rotation is determined by viewing pump from input shaft end.
- Contact your SAUER-DANFOSS representative for specific installation drawings.

Dimensions in mm [in]

P100 602E
*All ports are SAE straight thread o-ring ports per SAE J514, unless otherwise specified.
Shaft rotation is determined by viewing pump from input shaft end.
Contact your SAUER-DANFOSS representative for specific installation drawings.
Dimensions in mm [in]
**Series 40 Axial Piston Pumps**  
Technical Information  
Installation drawings

**Pump and control**

---

**M25 TANDEM PUMP DIMENSIONS (continued)**

---

*All ports are SAE straight thread o-ring ports per SAE J514, unless otherwise specified.  
Shaft rotation is determined by viewing pump from input shaft end.  
Contact your SAUER-DANFOSS representative for specific installation drawings.*

---

Dimensions in mm [in]
**M25 U DIMENSIONS**

**Transmission**

*All ports are SAE straight thread o-ring ports per SAE JS14, unless otherwise specified. Shaft rotation is determined by viewing pump from input shaft end. Contact your SAUER-DANFOSS representative for specific installation drawings.*

Dimensions in mm [in]

*Contact your SAUER-DANFOSS representative for specific installation drawings.*

---

**Series 40 Axial Piston Pumps**

**Technical Information**

**Installation drawings**
**Series 40 Axial Piston Pumps**

**Technical Information**

**Installation drawings**

---

**M35/44 VARIABLE PUMP**

**DIMENSIONS**

<table>
<thead>
<tr>
<th>Auxiliary mounting flange</th>
<th>Spline pitch dia. P</th>
<th>No. teeth N</th>
<th>Shaft clearance Y</th>
<th>Coupling clearance M</th>
</tr>
</thead>
<tbody>
<tr>
<td>SAE A Option A</td>
<td>14.30 [0.563]</td>
<td>9</td>
<td>33.0 [1.30]</td>
<td>9.1 [0.36]</td>
</tr>
<tr>
<td>SAE A Option D</td>
<td>17.46 [0.688]</td>
<td>11</td>
<td>39.1 [1.54]</td>
<td>9.1 [0.36]</td>
</tr>
<tr>
<td>SAE B Option B</td>
<td>20.72 [0.813]</td>
<td>13</td>
<td>42.9 [1.69]</td>
<td>22.3 [0.91]</td>
</tr>
</tbody>
</table>

*All ports are SAE straight thread o-ring ports per SAE J514, unless otherwise specified. Shaft rotation is determined by viewing pump from input shaft end. Contact your SAUER-DANFOSS representative for specific installation drawings.*

Dimensions in mm [in]
M35/44 VARIABLE PUMP
DIMENSIONS (continued)

Pump, filtration/charge pump option, control

*All ports are SAE straight thread o-ring ports per SAE JS14, unless otherwise specified.
Shaft rotation is determined by viewing pump from input shaft end.
Contact your SAUER-DANFOSS representative for specific installation drawings.

Dimensions in mm [in]
Charge pump options, auxiliary mounting flanges

<table>
<thead>
<tr>
<th>Auxiliary mounting flange</th>
<th>Spline pitch dia.</th>
<th>No. teeth</th>
<th>Shaft clearance</th>
<th>Coupling clearance</th>
</tr>
</thead>
<tbody>
<tr>
<td>SAE A</td>
<td>14.30 (.563)</td>
<td>9</td>
<td>33.0 [.130]</td>
<td>9.1 [.36]</td>
</tr>
<tr>
<td>SAE A</td>
<td>17.46 (.688)</td>
<td>11</td>
<td>39.1 [.154]</td>
<td>9.1 [.36]</td>
</tr>
<tr>
<td>SAE B</td>
<td>20.72 [.813]</td>
<td>13</td>
<td>42.9 [.169]</td>
<td>22.3 [.91]</td>
</tr>
</tbody>
</table>

*All ports are SAE straight thread o-ring ports per SAE J514, unless otherwise specified.

Shaft rotation is determined by viewing pump from input shaft end.

Contact your SAUER-DANFOSS representative for specific installation drawings.

Dimensions in mm [in]

**SAE A Auxiliary mounting flange**
- **Options A and D**

**SAE B Auxiliary mounting flange**
- **Option B**
M35/44 TANDEM PUMP DIMENSIONS (continued)

**Pumps, filtration/charge pump options, control**

*All ports are SAE straight thread o-ring ports per SAE J514, unless otherwise specified. Shaft rotation is determined by viewing pump from input shaft end. Contact your SAUER-DANFOSS representative for specific installation drawings.

Dimensions in mm [in]

---

**Top view (with charge pump and suction filtration):**

**Left side view (with charge pump and suction filtration):**

**Bottom view (with charge pump and suction filtration):**

---

**M35 Control trunion detail:**

* Dimensions in mm [in]
Series 40 Axial Piston Pumps
Technical Information
Installation drawings

M46 VARIABLE PUMP
DIMENSIONS

Auxiliary mounting flanges

Rear view (no pads shown)

M46 PV auxiliary mounting flange and coupling options

<table>
<thead>
<tr>
<th>Auxiliary mounting flange</th>
<th>Spline pitch dia. P</th>
<th>Number of teeth N</th>
<th>Minimum clearance Y</th>
</tr>
</thead>
<tbody>
<tr>
<td>SAE A Option A</td>
<td>14.30 [0.563]</td>
<td>9</td>
<td>36.6 [1.44]</td>
</tr>
<tr>
<td>SAE A Option D</td>
<td>17.46 [0.688]</td>
<td>11</td>
<td>42.4 [1.67]</td>
</tr>
<tr>
<td>SAE B Option B</td>
<td>20.72 [0.813]</td>
<td>13</td>
<td>46.0 [1.81]</td>
</tr>
</tbody>
</table>

*All ports are SAE straight thread o-ring ports per SAE J514, unless otherwise specified.
Shaft rotation is determined by viewing pump from input shaft end.
Contact your SAUER-DANFOSS representative for specific installation drawings.

Dimensions in mm [in]
Series 40 Axial Piston Pumps
Technical Information
Installation drawings

M46 VARIABLE PUMP
DIMENSIONS (continued)

Pump, filtration/charge pump options, MDC, displacement limiter

*All ports are SAE straight thread o-ring ports per SAE J514, unless otherwise specified.
Shaft rotation is determined by viewing pump from input shaft end.
Contact your SAUER-DANFOSS representative for specific installation drawings.
M46 TANDEM PUMP
DIMENSIONS

Auxiliary mounting flange

Rear view
no auxiliary mounting flange

SAE A Auxiliary mounting flange
options A and D

SAE B Auxiliary mounting flange
Option B

Rear mounting boss
Option B

M46 PT auxiliary mounting flange and coupling options

<table>
<thead>
<tr>
<th>Auxiliary mounting flange</th>
<th>Spline pitch dia. P</th>
<th>Number of teeth N</th>
<th>Minimum clearance Y</th>
</tr>
</thead>
<tbody>
<tr>
<td>SAE A Option A</td>
<td>14.30 [0.563]</td>
<td>9</td>
<td>35.6 [1.40]</td>
</tr>
<tr>
<td>SAE A Option D</td>
<td>17.46 [0.688]</td>
<td>11</td>
<td>38.1 [1.50]</td>
</tr>
<tr>
<td>SAE B Option B</td>
<td>20.72 [0.813]</td>
<td>13</td>
<td>47.5 [1.87]</td>
</tr>
</tbody>
</table>

*All ports are SAE straight thread o-ring ports per SAE J514, unless otherwise specified.

Shaft rotation is determined by viewing pump from input shaft end.

Contact your SAUER-DANFOSS representative for specific installation drawings.

Dimensions in mm [in]
Series 40 Axial Piston Pumps
Technical Information
Installation drawings

M46 TANDEM PUMP
DIMENSIONS
(continued)

Pumps, filtration/charge pump options, MDC, displacement limiters

M46 PT adjustable displacement limiters (option)

Shaft rotation | CW | CCW
---|---|---
Displacement limiter number | 2 | 3 | 2 | 3
Limits flow out of port | B | D | A | C

*All ports are SAE straight thread o-ring ports per SAE J514, unless otherwise specified. Shaft rotation is determined by viewing pump from input shaft end. Contact your SAUER-DANFOSS representative for specific installation drawings.

Dimensions in mm [in]
**Series 40 Axial Piston Pumps**
**Technical Information**

***Installation drawings***

**M46 CONTROL MODULE**

**DIMENSIONS**

M46 PV/PT manual displacement control handle

- 19.05 [0.75]
- 10.08 [0.397]
- 29.5 [1.16] dia. (2)

Mounting flange location (ref.)

- 141.5 [5.57] x 145.1 [5.71]
- 132.3 [6.39] x 171.7 [6.76]

- 4.75 [0.187] R
- 19.05 [0.75] R
- 105.9 [4.17] R

With heavy spring

- 50.8 [2.00] R
- 29.5 [1.16] R

**M46 PV/PT manual displacement control with neutral start switch**

- 20° 20° 20° 20°

Side view

Variable pump with MDC and NSS

- 20° 20° 20° 20°

Side view tandem pump with MDC and NSS

- 20° 20° 20° 20°

View X front view

Variable pump with MDC and NSS

- 21.34 [0.84] (2) places

Switch with weather pack two-way connector

- 105.9 [4.17] (2) places

- 145.1 [5.71]

- Dimensions in mm [in]

*All ports are SAE straight thread o-ring ports per SAE J514, unless otherwise specified.
Shaft rotation is determined by viewing pump from input shaft end.
Contact your SAUER-DANFOSS representative for specific installation drawings.*
M46 CONTROL MODULE
DIMENSIONS
(continued)

*All ports are SAE straight thread o-ring ports per SAE J514, unless otherwise specified.
Shaft rotation is determined by viewing pump from input shaft end.
Contact your SAUER-DANFOSS representative for specific installation drawings.

Dimensions in mm [in]
**Series 40 Axial Piston Pumps**

**Technical Information**

**Installation drawings**

**M46 CONTROL MODULE**

**DIMENSIONS**

(continued)

- Sauer-Danfoss mating parts kit part no. K83377 (male terminals)
- Packard Weather-Pack 2-way tower connector (female terminals)
- Sauer-Danfoss mating parts kit part no. 803379 (male terminals)
- Packard Weather-Pack 4-way tower connector (female terminals)

- Packard "Weather Pack" shroud connector on 76 mm (3 in) lead wires
  2-way (single coil PCP) mates with Packard 12015792 connector
  4-way (Dual Coil PCP) mates with Packard 12015797 connector

**View V**

- Side view
- Variable pump with EDC
  (Packard Weather-Pack connector)

**View U**

- Side view
- Tandem pump with EDC
  (MS connector)

**View X**

- Front view
- Variable pump with EDC
  (Packard Weather-Pack connector)

---

*All ports are SAE straight thread o-ring ports per SAE J514, unless otherwise specified.

Shaft rotation is determined by viewing pump from input shaft end.

Contact your SAUER-DANFOSS representative for specific installation drawings.

Dimensions in mm [in]
*All ports are SAE straight thread o-ring ports per SAE J514, unless otherwise specified. Shaft rotation is determined by viewing pump from input shaft end. Contact your SAUER-DANFOSS representative for specific installation drawings.

Dimensions in mm [in]
Series 40 Axial Piston Pumps
Technical Information
Schematics

**SERIES 40 PVARIABLE PUMP SCHEMATICS**

**M25 PV**

![Diagram of M25 PV pump schematic]

**M35/44 PV**

![Diagram of M35/44 PV pump schematic]

**M46 PV**

![Diagram of M46 PV pump schematic]
Sauer-Danfoss is a comprehensive supplier providing complete systems to the global mobile market.

Sauer-Danfoss serves markets such as agriculture, construction, road building, material handling, municipal, forestry, turf care, and many others.

We offer our customers optimum solutions for their needs and develop new products and systems in close cooperation and partnership with them.

Sauer-Danfoss specializes in integrating a full range of system components to provide vehicle designers with the most advanced total system design.

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