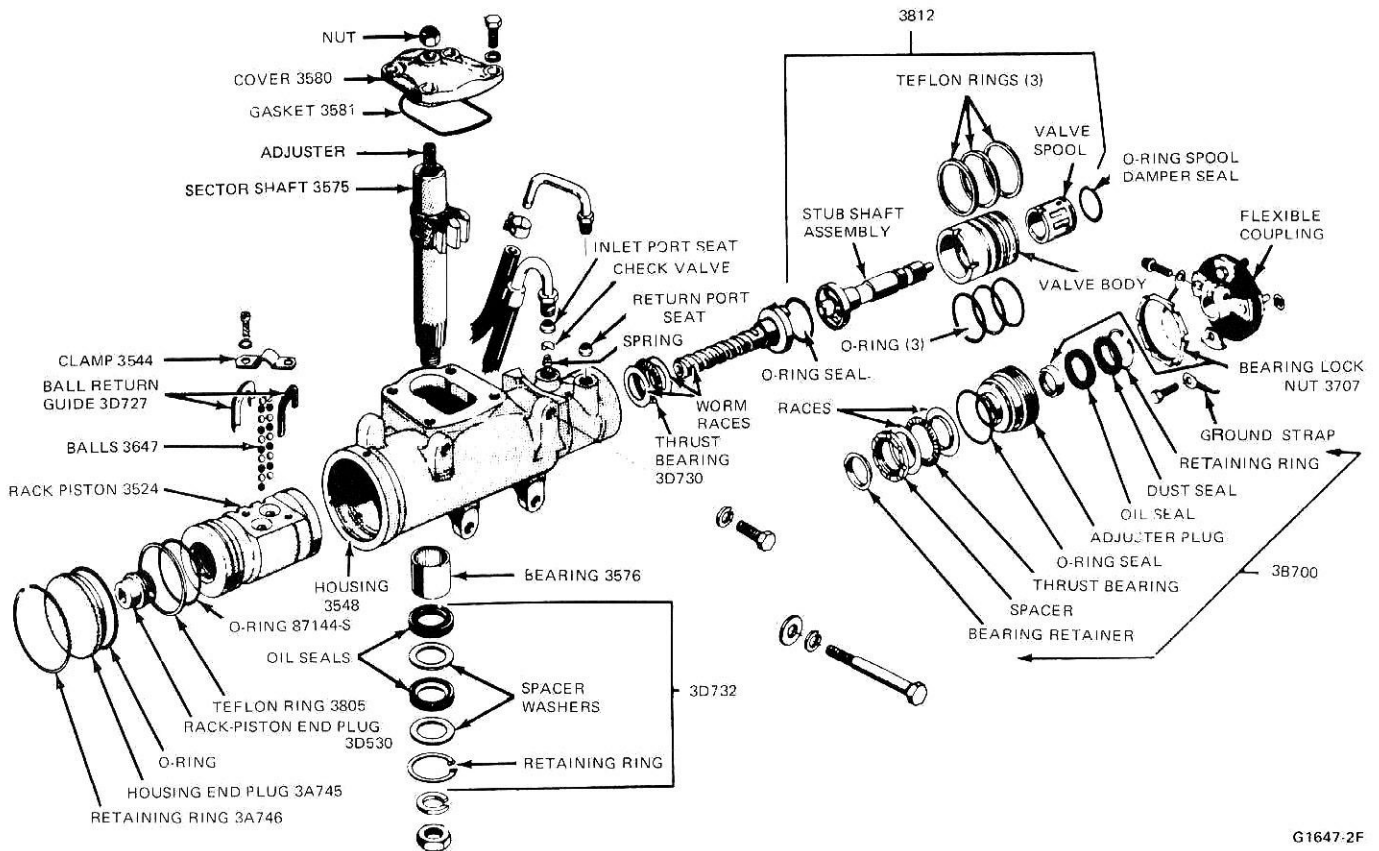
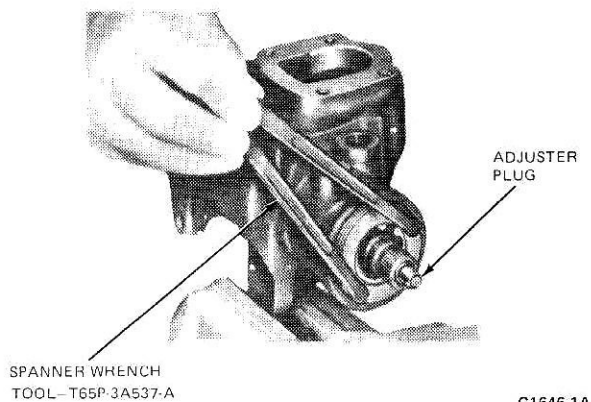




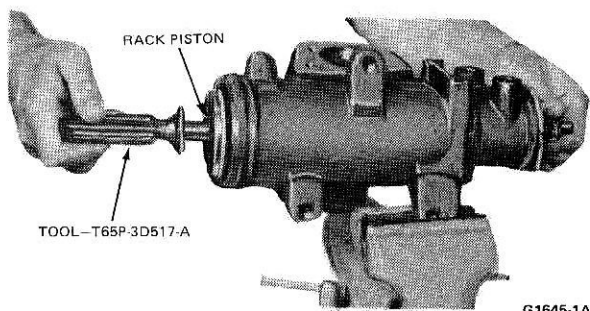
G1647-2F

FIG. 17 Steering Gear Disassembled



G1646-1A

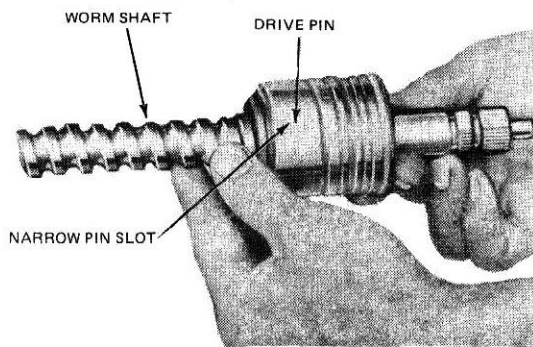
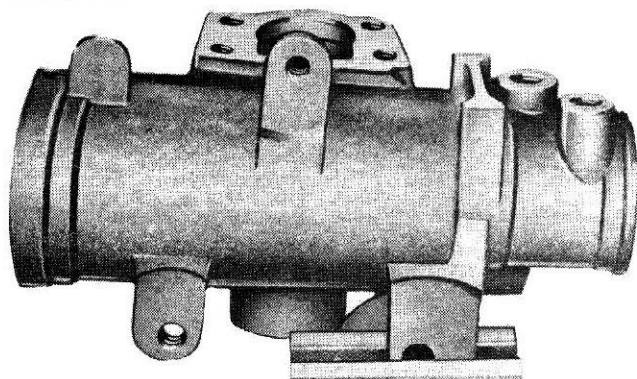
FIG. 18 Removing Adjuster Plug



G1645-1A

FIG. 19 Removing Rack Piston

- O-ring seal between the valve body and the worm head. Lubricate the Teflon ring and lower cap O-ring with power steering fluid.
- Position the valve assembly and worm shaft as a unit in the housing (Fig. 20). **Do not push against the stub shaft. Pressure on the shaft may cause the shaft and cap to pull out of the valve body, allowing the spool seal to slip into valve body fluid grooves.** Install the assembly by pushing with finger tips on the outer diameter of the valve body housing. Be sure the Teflon rings do not bind inside the housing. The valve assembly is correctly seated when the fluid return hole in the gear housing is fully visible.
 - Place Tool T65P-3A537-B over the end of the stub shaft (Fig. 21).
 - Lubricate a new adjuster plug O-ring with power steering fluid and install it in the adjuster plug groove.
 - Install the adjuster plug over the end of the stub shaft and tighten it just enough to be sure all parts are properly seated. Remove Tool T65P-3A537-B.
 - Install the adjuster plug locknut loosely on the plug.
 - Adjust the input shaft preload according to the procedure given under Adjustments in this Part.
 - Install Tool T65P-3805-A in the steering gear housing. Position the rack-piston as shown in Fig. 22. Be sure that Tool T65P-3D517-A is contacting the worm shaft. Push the rack-piston inward until it contacts the worm shaft, keeping pressure applied to Tool T65P-3D517-A. Turn the stub shaft clockwise until the middle rack groove is aligned

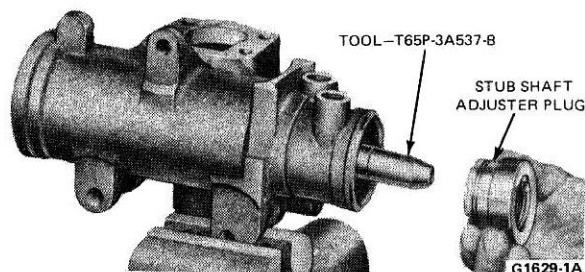


G1630-2A

FIG. 20 Installing Valve and Worm Shaft in Housing

with the center of the sector shaft roller bearing. Remove the tool from the housing.

11. Lubricate a **new** O-ring with power steering fluid and place it in the sector shaft cover.
12. Thread the sector shaft cover on the adjusting screw until it bottoms, then loosen it one and one-half turns.
13. Install the sector shaft so the center gear tooth meshes with the center groove in the rack-piston.

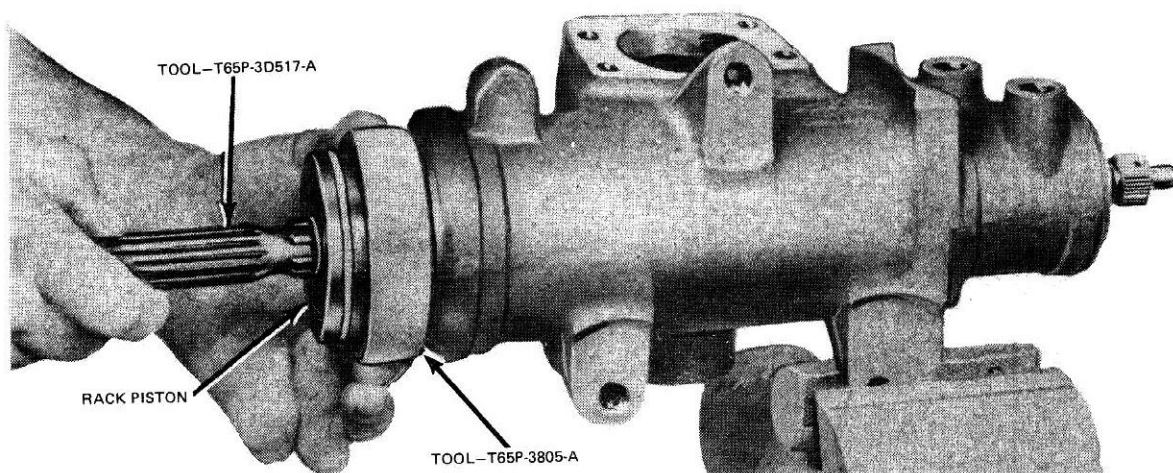


G1629-1A

FIG. 21 Installing Adjuster Plug

Be sure the cover O-ring is in place before pushing the cover down on the housing.

14. Install the cover screws and lock washers. Torque to 30 to 35 ft-lbs.
15. Install a new adjuster lock nut and tighten halfway on the adjuster screw.
16. Install the end plug in the rack-piston. Torque the plug to 50 to 100 ft-lbs.
17. Lubricate a new housing end plug O-ring and install it in the housing.
18. Place the end plug in the gear housing and seat it against the O-ring seal. It may be necessary to tap the end plug lightly with a soft-faced mallet to seat it properly.
19. Snap the retainer ring in place. Tap lightly on the ring to be sure it seats securely in the housing.
20. Adjust the over-center mesh load of the sector according to the procedure given under Adjustments in this Part.



G1302-2A

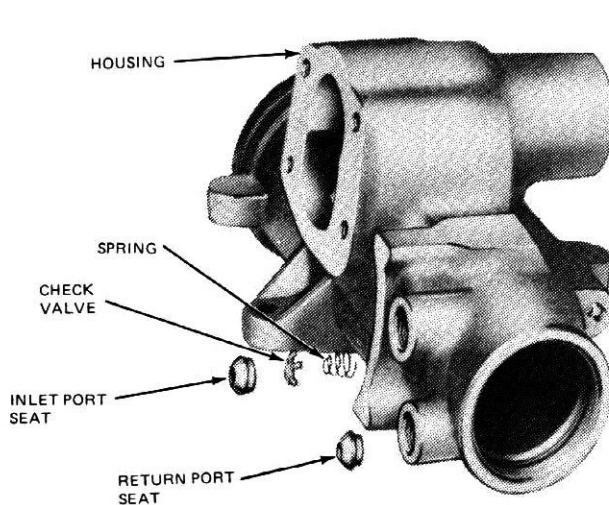
FIG. 22 Installing Rack Piston

21. After obtaining proper mesh load, torque the sector shaft adjustment screw lock nut to 27 to 37 ft-lbs.

STEERING GEAR HOUSING

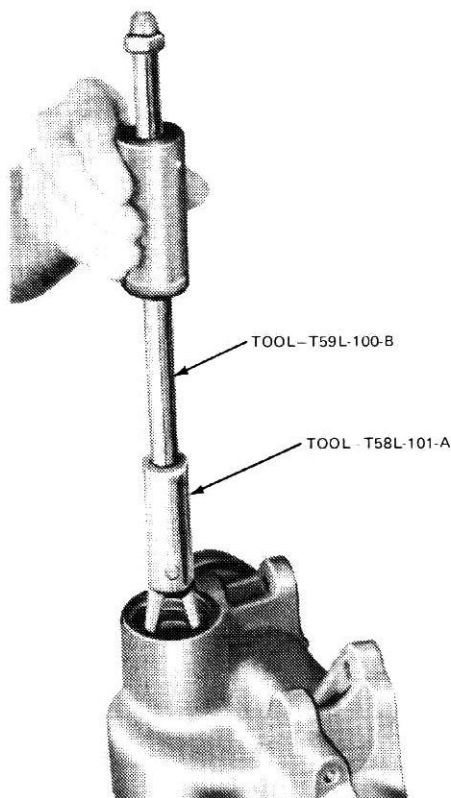
Disassembly and Assembly

1. Remove the snap ring (Fig. 23) that secures the sector shaft seals in the lower end of the housing. Remove the lower spacer washer.



2. Remove the lower seal (double lip), spacer washer and upper seal (single lip) using Tools T58L-101-A and T59L-100-B (Fig. 24).
3. Check the housing bearing for wear and damage and remove, if necessary. Working from the lower end of the housing (Fig. 25) press the bearing out of the housing. Discard the bearing.
4. Working from the upper end of the housing, press in a new bearing until the upper end is 0.030 inch

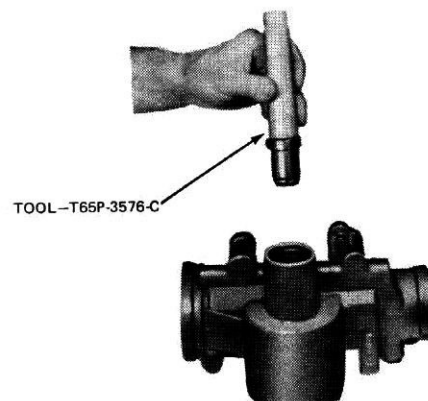
FIG. 23 Steering Gear Housing Disassembled



G1642-1A

FIG. 24 Removing Sector Shaft Seals

- below the housing bore. Press the bearing, on the stamped end only.
5. Lubricate **new** sector shaft seals (Fig. 23) in power steering fluid. Install the single lip seal first, then a back-up washer. Using Tool T65P-3D642-A (Fig. 26), drive the seal and washer far enough into the housing to provide clearance for the other seal and back-up washer and the retaining ring. **Do not let the seal bottom on the end of the counterbore.**
 6. Install the double lip seal and second back-up washer. Using Tool T65P-3D642-A, drive the seal and back-up washer into the housing only far enough to provide clearance for the retaining ring. Install the retaining ring with snap ring pliers. **Be sure the ring seats properly.**



G1641-1B

FIG. 25 Removing Sector Shaft Bearings