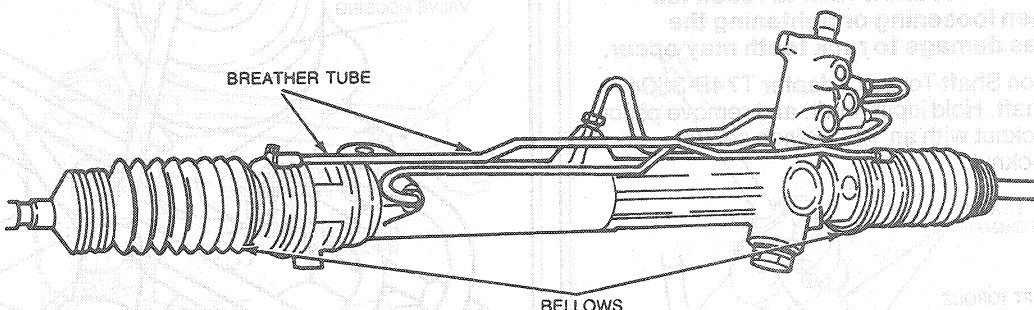


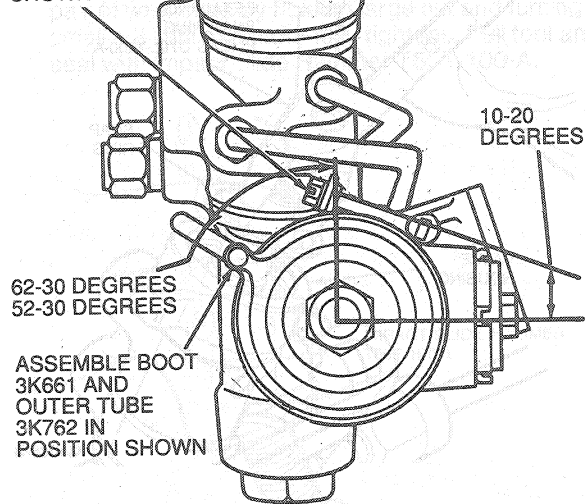
**DISASSEMBLY AND ASSEMBLY (Continued)**

7. Install bellows and breather tube. Ensure breather tube is positioned as shown.



8. Install screw-type clamps and position screw axis as shown. Tighten to 2.2-3.4 N-m (20-30 lb-in).

N803259-S100  
CLAMP 66.5 ROUND  
TANG SCREW HOSE  
TIGHTEN SCREW TO  
2.2-3.4 N-m  
(20-30 LB-IN) IN  
POSITION  
SHOWN



9. Install new clamps retaining bellows to tie rods.  
10. Apply Disc Brake Caliper Slide Grease D7AZ-19590-A (ESA-M1C172-A) or equivalent to tie rod threads.  
11. Install tie rod outer ends.

**Input Shaft and Valve Assembly**

**Tools Required:**

- Impact Slide Hammer T50T-100-A

- Bench Mounted Holding Fixture T57L-500-B
- Puller Attachment T58L-101-B
- Pinion Shaft Torque Adapter T74P-3504-R
- Seal Installation Kit T75L-3517-A-1, A2, A3 and A4
- Valve Body (Screw) T78P-3504-B
- Valve Body Insert Tool T78P-3504-C
- Lower Pinion Bearing Replacer T78P-3504-G
- Upper Pinion Bearing Seal Replacer T78P-3504-D
- Retaining Ring Pliers D79L-7000-A
- Valve Body Puller (Bridge) T86P-3504-D
- Lower Pinion Seal Remover T86P-3504-F
- Lower Pinion Seal Replacer T86P-3504-G
- Lower Pinion Seal Remover Guide T86P-3504-J

**Disassembly**

1. Thoroughly clean areas of input shaft valve housing, yoke locknut and plug, and pinion bearing plug.
2. Mount gear in the Bench Mounted Holding Fixture T57L-500-B. Drill out mounting holes in holding fixture with a 9/16-inch drill to allow gear assembly retaining bolts to fit.
3. Do not remove transfer tubes (RH and LH turn lines), unless they are leaking or damaged. If these lines are removed, new Teflon® seals must be installed.

