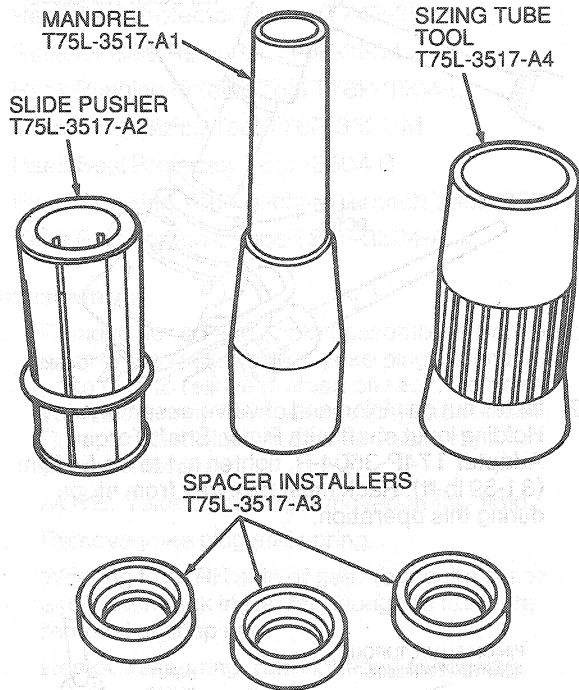


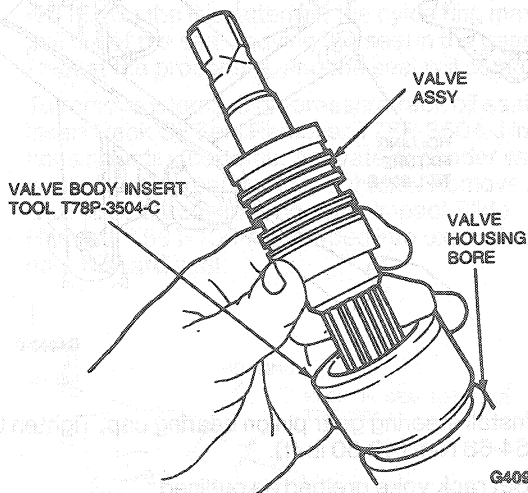
DISASSEMBLY AND ASSEMBLY (Continued)

The complete set of tools needed to perform the above operations is shown in the illustration. The Tool Kit is T75L-3517-A.



G2742-D

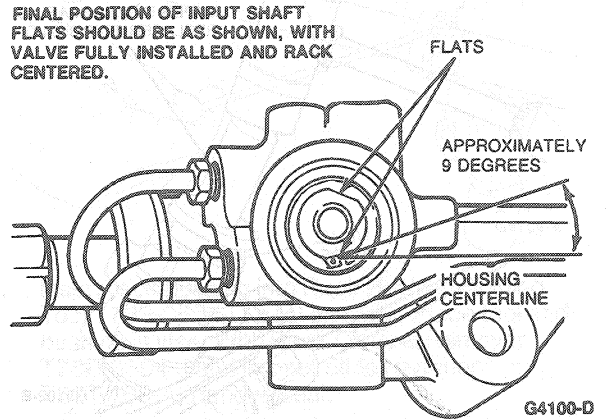
12. Center rack in housing so that equal amounts of rack shaft stick out of each end of housing. Position rack teeth so they will mesh with pinion.
13. Position Valve Body Insert Tool T78P-3504-C in valve housing bore.



G4098-B

NOTE: If pinion is off one tooth, it will be obvious, since one tooth equals 45 degrees.

14. Insert valve assembly with flats on input shaft in position shown.



15. Using Pinion Shaft Torque Adapter T74P-3504-R count total turns, stop-to-stop (2.5 turns). From one stop, back off half the total (1-1/4 turns). The position should be as shown in illustration under Step 14. If it is approximately 45 degrees (one tooth) away from position, pull valve assembly out far enough to disengage pinion teeth and install to obtain proper position.
16. Install bearing assembly in valve bore and seat with Upper Pinion Bearing Seal Replacer T78P-3504-D.
17. Apply a film of Steering Grease C3AZ-19578-A (ESW-M1C87-A) or equivalent to input shaft seal, and install with lip toward valve.

