

## DISASSEMBLY AND ASSEMBLY (Continued)

- O-Ring Tool T7 1P-19703-C
- Outer Rack Seal Replacer T74P-3504-F
- Teflon Ring Replacer T74P-3504-G
- Rack Seal Protector Sleeve T74P-3504-J
- Rack Oil Seal Remover T78P-3504-J
- Rack Bushing Holding Tool T78P-3504-L
- Teflon Ring Sizing Tool T78P-3504-M
- Rack Seal Protector T85L-3504-B
- Pinion Housing Yoke Locknut Wrench T86P-3504-E
- Yoke Plug Torque Gauge T88P-3504-A

## Disassembly

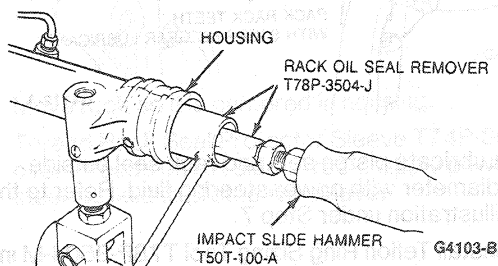
1. Remove tie rod and socket assemblies from both ends of the rack. Loosen yoke plug lock nut and yoke plug to relieve preload on rack. Remove valve assembly from gear housing as outlined. Refer to Input Shaft and Valve Assembly, Disassembly.

NOTE: Yoke cannot be removed at this time.

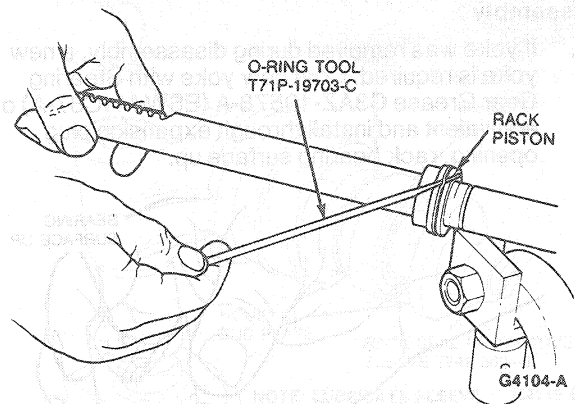
2. Remove yoke plug and spring.
  3. Working from RH side of gear (opposite pinion end), push rack in just far enough to facilitate removal of snap ring.
  4. Remove snap ring from right end of housing.
- CAUTION: Do not hammer on the rack, aluminum rack bushing or housing. Damage may occur.**
5. Slowly pull rack out of RH side of housing until rack piston contacts aluminum rack bushing. Apply pulling effort on rack until bushing is withdrawn from housing. Remove rack from the housing.

NOTE: On the first attempt, the nylon ring may pull out of the seal, leaving the seal in the gear. Repeat the procedure, and the seal will come out.

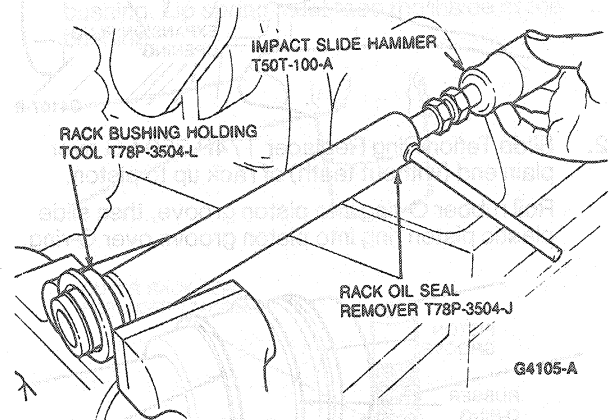
6. To remove internal high-pressure rack oil seal, insert Rack Oil Seal Remover T78P-3504-J into housing until it bottoms. Activate expander with a wrench until expander fully tightens. Remove tool with oil seal from housing using Impact Slide Hammer T50T-100-A threaded into expander end. Discard seal.



7. Remove plastic O-ring and rubber O-ring from rack piston with O-Ring Tool T7 1P-19703-C.



8. Insert rack bushing into Rack Bushing Holding Tool T78P-3504-L, seal end first. Place tool and bushing in vise. With Rack Oil Seal Remover T78P-3504-J and Impact Slide Hammer T50T-100-A, remove seal.



9. Remove rubber O-rings from rack bushing.
10. Inspect rack yoke while still in gear housing. If it is in good condition, do not remove it.
11. If yoke needs replacing, use a drift or punch to knock it out, along with expansion plug.

