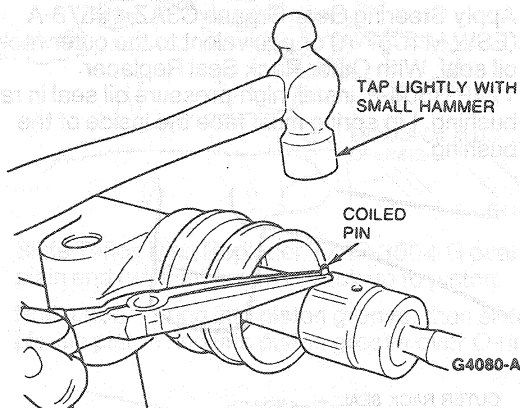


DISASSEMBLY AND ASSEMBLY (Continued)

20. Start bushing, seal facing out, on rack. Pass bushing and seal over protecting sleeve and into housing bore. Place end plate against rack bushing. With Teflon Ring Sizing Tool T78P-3504-M apply hand pressure to end plate and rack bushing until bushing seats in gear housing. If rack bushing will not seat with hand pressure, a 1 1/8-inch deep socket (or larger) and a plastic mallet may be used to tap bushing in place. Install retaining ring (snap ring). Remove protective sleeve.
21. Install rod assemblies. Tighten both tie rod ball joint nuts simultaneously to 75-88 N·m (55-65 lb-ft) by holding one and turning the other.
22. Install coiled pins in ball joint nuts by lightly tapping with hammer until seated.



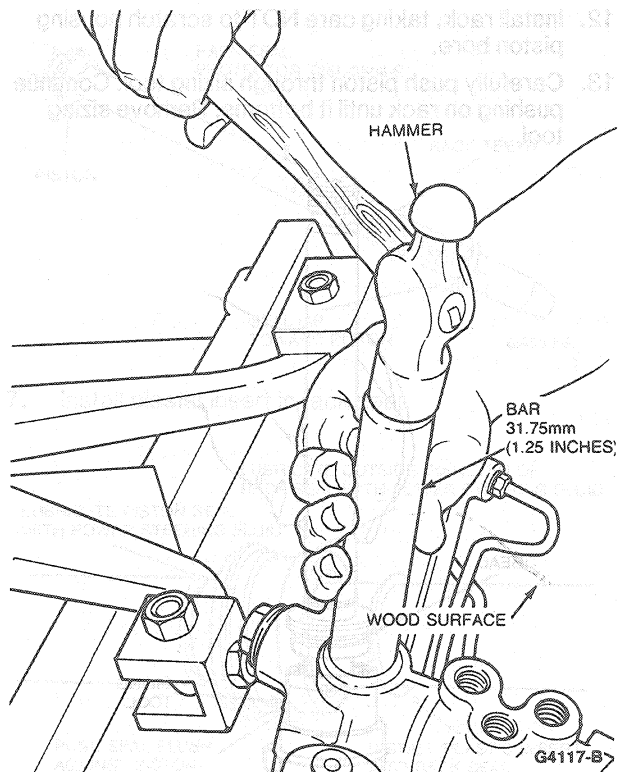
23. Install valve assembly.

NOTE: Do not perform Step 24 if yoke was not removed.

24. Support gear on wood surface at yoke plug opening. Using a 31.75mm (1.25-inch) bar with a flat end and a hammer, flatten expansion plug until flat portion is approximately one-half to three-quarters of the total plug diameter.

NOTE: Do not flatten plug completely or it will fall out.

DISASSEMBLY AND ASSEMBLY (Continued)



25. Install spring, plug, and locknut.

