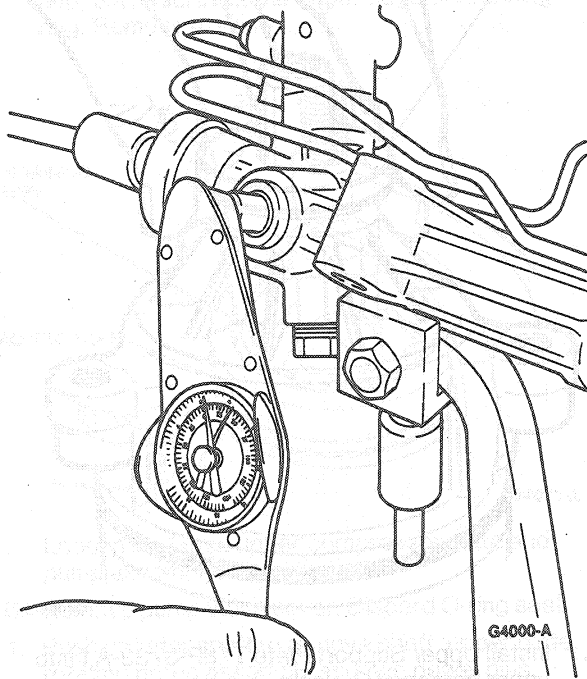
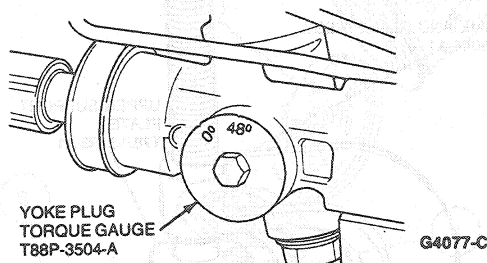


## DISASSEMBLY AND ASSEMBLY (Continued)

26. With rack at center of travel, tighten yoke plug to 5-5.6 N-m (45-50 lb-in). Clean threads of yoke plug prior to tightening to prevent a false reading.



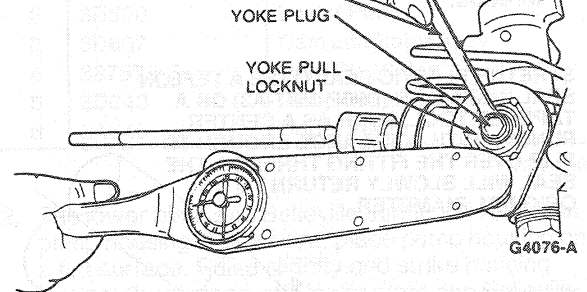
27. Install Yoke Plug Torque Gauge T88P-3504-A. Mark location of zero degree mark on housing. Back off adjuster so 48 degree mark lines up with zero degree mark.



**CAUTION:** Do not allow yoke plug to move while tightening or preload will be affected.

28. Place Pinion Housing Yoke Locknut Wrench T86P-3504-E on yoke plug locknut. While holding yoke plug, tighten locknut to 54-68 N-m (40-50 lb-ft). Refer to illustration following Step 5. Check input shaft torque after tightening locknut.

PINION HOUSING YOKE  
LOCKNUT WRENCH  
T86P-3504-E



29. If external transfer tubes were removed, they must be replaced with new service lines. Clean out Teflon® seal shreds from housing ports prior to installation of new lines.
30. Fully extend LH end of rack, so rack teeth are exposed. Using 57 grams (2 oz) of Steering Gear Grease C3AZ-19578-A (ESW-M1C87-A) or equivalent, pack rack teeth and pack any remaining grease into left end of gear housing. Return rack to center position.
31. Apply Steering Gear Grease C3AZ-19578-A (ESW-M1C87-A) or equivalent to groove in tie rods where bellows clamp to tie rods. This is required to keep bellows from twisting during toe-in adjustment.
32. Install bellows and pressure equalizer tube. Install clamps retaining bellows to gear housing.
33. Install clamps retaining bellows to tie rods.
34. Install jam nuts and tie rod ends on tie rods.

### Pressure and Return Line Fitting

#### Tools Required:

- Teflon Seal Installer D90P-3517-A3

#### Seal Replacement

If a leak occurs between the tubing and the tube nut, the entire hose assembly, with a new fitting must be replaced. If a leak occurs between the tube nut and the aluminum gear housing, replace the plastic washer. The following procedure should be used:

1. Check fittings to determine which fitting is leaking and whether leak is between tube and tube nut or between tube nut and gear housing.
2. Check to ensure that nuts are tightened to specification. Do not over-tighten.