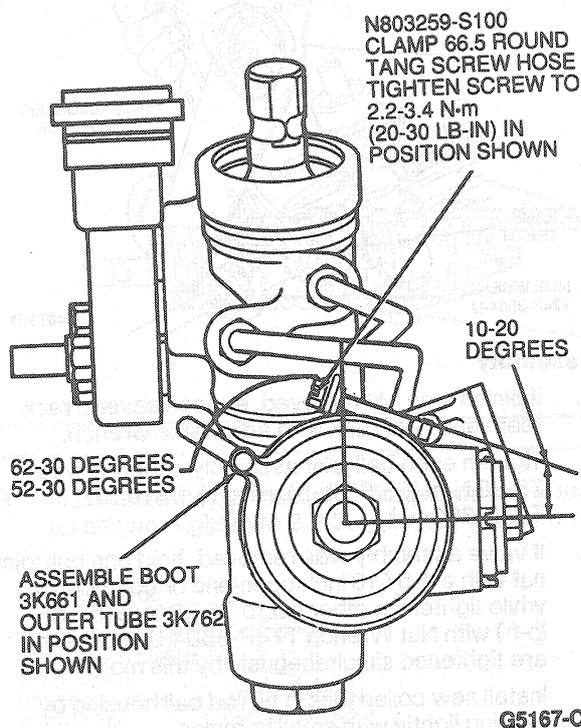
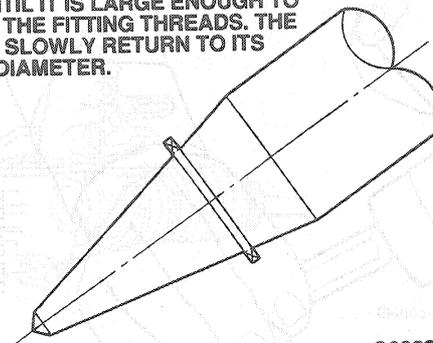


DISASSEMBLY AND ASSEMBLY (Continued)

10. Install tie rod outer ends.



STRETCH PLASTIC SEAL OVER A TEFLON SEAL INSTALLER (D90P-3517-A3) OR A TAPERED TOOL, SUCH AS A CENTER PUNCH, UNTIL IT IS LARGE ENOUGH TO SLIP OVER THE FITTING THREADS. THE SEAL WILL SLOWLY RETURN TO ITS ORIGINAL DIAMETER.



Steering Gear

Take the following precautions when servicing the steering gear:

1. Use a clean work bench and tools.
2. Thoroughly clean the exterior of the unit with solvent. Drain off excess hydraulic fluid.
3. Handle all parts carefully to avoid nicks, burrs, scratches and dirt.
4. Do not use solvent on seals.
5. Impact tools must not be used during any of the operations.

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, replace the hose assembly. If a leak occurs at the tube nut threads, replace the plastic washer. The following procedure should be used:

1. Check to ensure that nuts are tightened to specification. Do not over-tighten.
2. Unscrew tube nut, and replace plastic seal washer. To facilitate assembly of new TFE seal, a tapered shaft may be required to stretch the washer, so it may be slipped over tube nut threads.

Tie Rod Ends, Bellows and Ball Joint Sockets

Tools Required:

- Bench Mounted Holding Fixture T57L-500-B
- Nut Wrench T74P-3504-U

Disassembly

NOTE: Drill out mounting holes in holding fixture with a 9/16-inch drill to allow the gear assembly mounting bolts to fit.

1. Mount gear assembly in Bench Mounted Holding Fixture T57L-500-B.
2. Remove tie rod ends.
3. Remove four clamps retaining bellows to gear housing and tie rods. Discard clamps if damaged or excessively corroded.

CAUTION: Use care not to damage bellows.

4. Remove bellows along with breather tube.
5. If pinion requires removal, remove pinion before proceeding. Refer to Input Shaft and Valve Disassembly.