

## CLEANING AND INSPECTION (Continued)

**Steering Pump, Power****Cleaning**

Wash all parts except seals in a chlorinated solvent and dry with compressed air.

**Inspection**

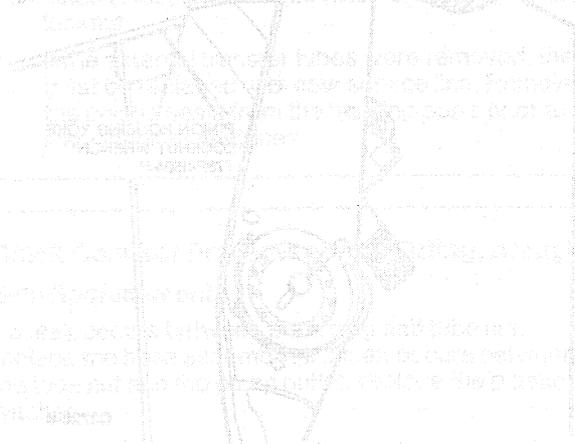
To determine when to replace power steering pump components, follow these guidelines.

**NOTE:** Some components must be replaced regardless of condition.

1. Reuse outlet fitting if corners are not rounded and threads are intact.
2. Replace all seals except the rotor shaft seal. Do not remove rotor shaft seal if it does not leak.
3. Reuse reservoir assembly if O-ring surfaces are not damaged.
4. Reuse housing or housing assembly if O-ring and snap ring surfaces are not damaged.
5. Reuse upper and lower pressure plates if there is no scoring on wear surface. Polish phosphate coating, if necessary, but do not remove it.
6. Reuse rotor and cam assembly if wear is limited to removal of phosphate coating on cam contour. Do not disassemble unit. Push rotor part-way through cam insert, being careful not to dislodge slippers and springs. Check cam ID for scoring or burring. Check rotor faces and OD for scoring and chipping.

**Do not service or refinish the upper and lower pressure plates, cam or rotor assembly. If wear or burring is evident, replace them with new components.**

7. Install a new rotor and cam assembly if slippers are worn. Replace springs if they are bent or broken.



8. Reuse rotor shaft if thrust faces, bushing diameter and shaft seal diameter are not excessively worn or scored.
9. Reuse housing and bushing assembly if all threaded holes are not damaged beyond service, and bushing diameter is not scored or worn 0.01mm (0.0005-inch) over 18mm (0.6897-inch) maximum. Service threaded holes by drilling out the damaged threads and installing helicoil inserts. If bushing is scored or excessively worn, install a new housing and bushing assembly.
10. Reuse valve body if valve bore is free of nicks and scoring. Valve must fall freely in valve bore. Replace valve housing and/or valve if valve sticks in bore.

## ADJUSTMENTS

**Rack Yoke Plug Clearance****Tools Required:**

- Bench Mounted Holding Fixture T57L-500-B
- Pinion Shaft Torque Adapter T74P-3504-R
- Pinion Housing Yoke Locknut Wrench T78P-3504-H
- Seal Installer D90P-3517-A3

**Steering Gear Removed**

**NOTE:** The rack yoke clearance adjustment is not a normal service adjustment. It is only required when the input shaft and valve assembly is removed.

1. Clean exterior of the steering gear thoroughly.

2. Loosen the yoke plug locknut with the Pinion Housing Yoke Locknut Wrench T78P-3504-H.
3. Insert a 3/16-inch diameter rod into the yoke plug hole. Tighten the yoke plug locknut with the Pinion Housing Yoke Locknut Wrench T78P-3504-H. Position the rod so that it is parallel to the yoke plug hole.
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