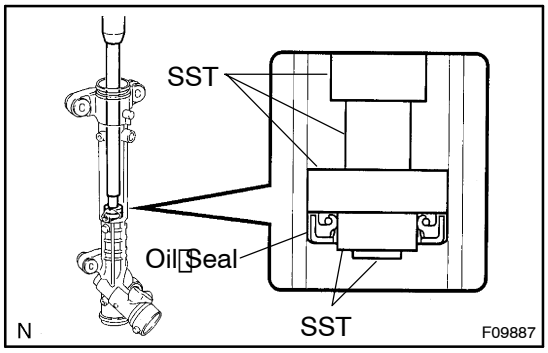
SR0YV–01

REASSEMBLY

NOTICE:

When using a vise, do not overtighten it.

1. COAT PARTS INDICATED BY ARROWS WITH POWER STEERING FLUID OR MOLYBDENUM DISULFIDE LITHIUM BASE GREASE (See page SR–34)



2. INSTALL OIL SEAL

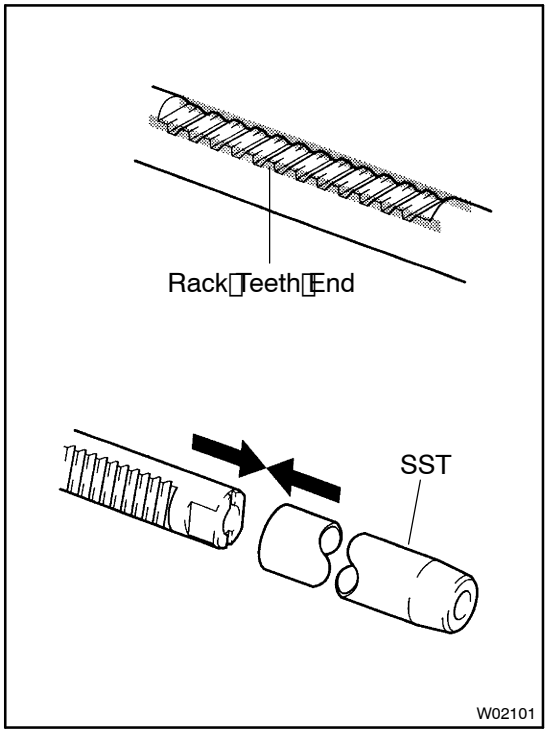
(a) Coat a new oil seal lip with power steering fluid.

(b) Install the oil seal to SST, and press them into the rack housing.

SST 09950–60010 (09951–00240, 09951–00400, 09952–06010), 09950–70010 (09951–07360)

NOTICE:

- **Make sure that the oil seal is installed facing in the correct direction.**
- **Take care that the oil seal does not get reversed as you install it.**



3. INSTALL STEERING RACK

(a) Install SST to the rack.

SST 09631–20051

HINT:

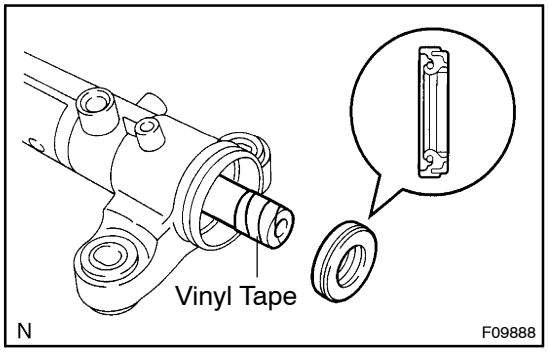
If necessary, scrape the burrs off the rack teeth end and burnish.

(b) Coat SST with power steering fluid.

(c) Install the steering rack into the rack housing.

(d) Remove the SST.

SST 09631–20051



4. INSTALL OIL SEAL

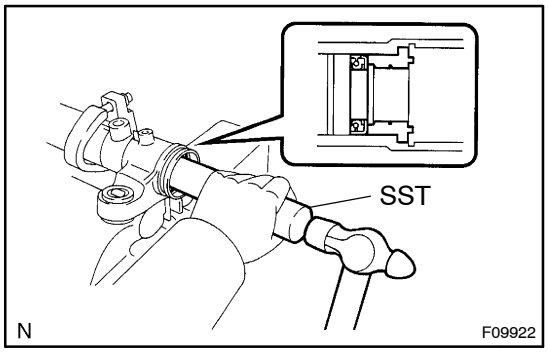
(a) Coat a new oil seal lip with power steering fluid.

(b) To prevent oil seal lip damage, wind vinyl tape on the steering rack end, and apply power steering fluid.

(c) Install the oil seal by pushing it into the rack housing without tilting.

NOTICE:

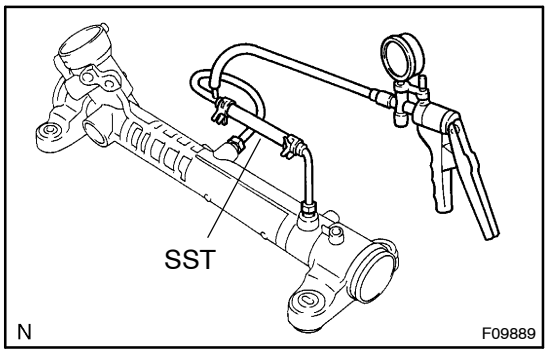
- **Make sure that the oil seal is installed facing in the correct direction.**
- **Be careful not to damage the oil seal lip.**



5. INSTALL CYLINDER END STOPPER

(a) Using SST and a hammer, drive in the cylinder end stopper.
SST 09612–22011

(b) Using snap ring pliers, install a new snap ring to the rack housing.



6. AIR TIGHTNESS TEST

(a) Install SST to the rack housing.
SST 09631–12071

(b) Apply 53 kPa (400 mmHg, 15.75 in.Hg) of vacuum for about 30 seconds.

(c) Check that there is no change in the vacuum.

If there is a change in the vacuum, check the installation of the oil seals.

7. INSTALL CONTROL VALVE ASSEMBLY

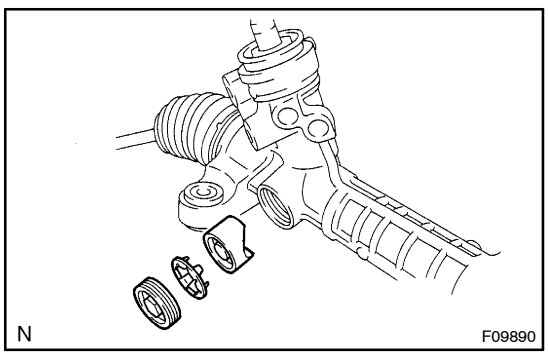
NOTICE:

Be careful not to damage the teflon rings and oil seal lips.

8. INSTALL RACK HOUSING CAP

(a) Coat a new O–ring with power steering fluid, and install it to the rack housing cap.

(b) Install the rack housing cap.
Torque: 74 N·m (750 kgf·cm, 54 ft·lbf)

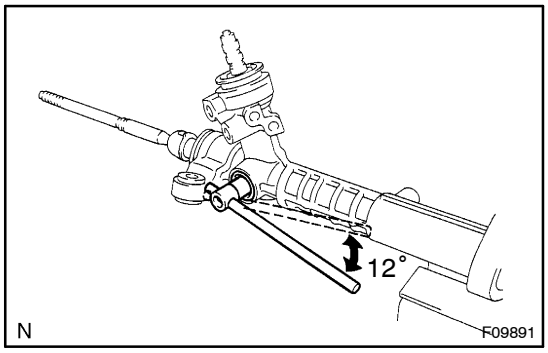


9. INSTALL RACK GUIDE SUB–ASSEMBLY, CONICAL SPRING WASHER AND RACK GUIDE SPRING CAP

(a) Install the rack guide sub–assembly and conical spring washer.

(b) Apply sealant to 2 or 3 threads of the rack guide spring cap.
Sealant:
Part No. 08833–00080, THREE BOND 1344, LOCTITE 242 or equivalent

(c) Temporarily install the rack guide spring cap.

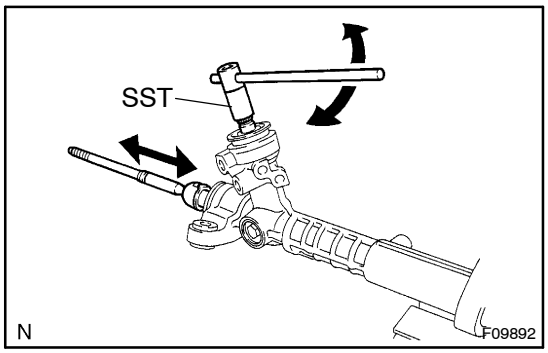


10. ADJUST TOTAL PRELOAD

(a) To prevent the steering rack teeth from damaging the oil seal lip, temporarily install the RH and LH rack ends.

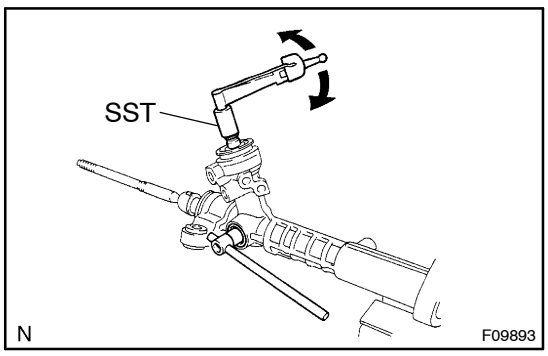
(b) Torque the rack guide spring cap.
Torque: 25 N·m (250 kgf·cm, 18 ft·lbf)

(c) Return the rack guide spring cap 12°.

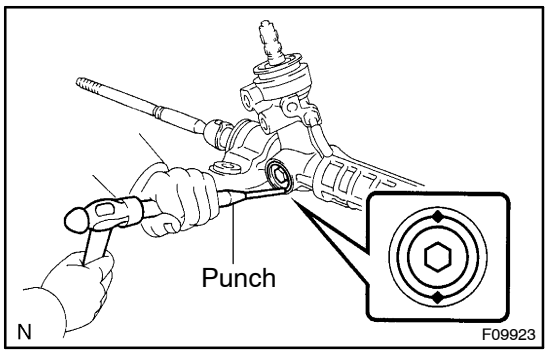


(d) Using SST, turn the control valve shaft right and left 1 or 2 times.
SST 09616–00010

(e) Loosen the rack guide spring cap until the rack guide spring is not functioning.



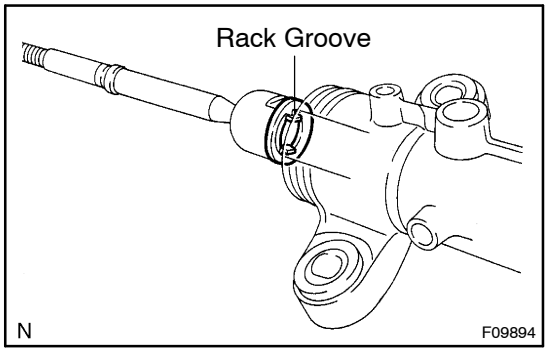
(f) Using SST and torque wrench, tighten the rack guide spring cap until the preload is within the specification.
SST 09616–00010
Preload (turning):
0.9 – 1.3 N·m (9 – 13 kgf·cm, 8.0 – 11.5 in.·lbf)



(g) Using a punch and a hammer, stake 2 parts in opposing positions on the rack guide spring cap.

(h) Recheck the total preload.
Preload (turning):
0.9 – 1.3 N·m (9 – 13 kgf·cm, 8.0 – 11.5 in.·lbf)

(i) Remove the RH and LH rack ends.

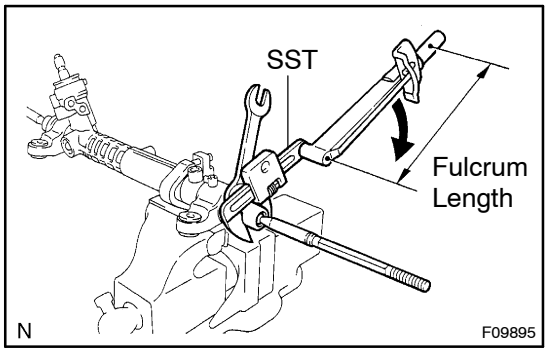


11. INSTALL RH AND LH CLAW WASHERS AND RACK ENDS

(a) Install a new claw washer, and temporarily install the rack end.

HINT:

Align the claws of the claw washer with the steering rack grooves.



(b) Using a spanner, hold the steering rack steadily and using SST, torque the rack end.

SST 09922–10010

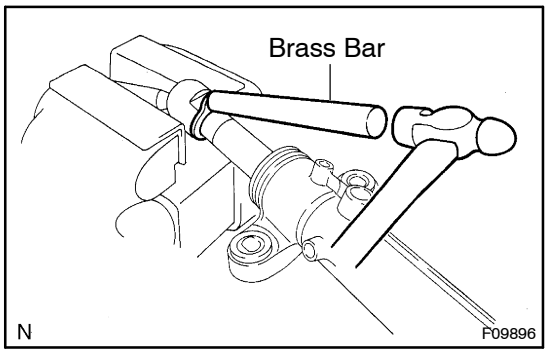
Torque: 62 N·m (630 kgf·cm, 46 ft·lbf)

NOTICE:

Use SST 09922–10010 in the direction shown in the illustration.

HINT:

Use a torque wrench with a fulcrum length of 380 mm (14.96 in.).

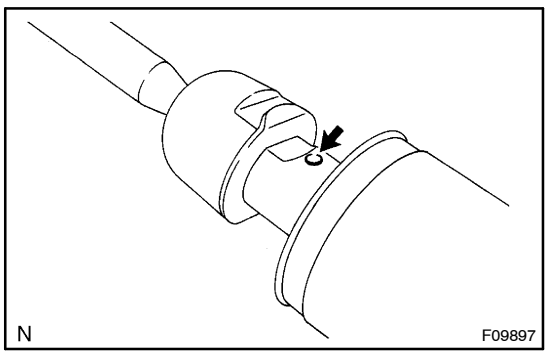


(c) Using a brass bar and a hammer, stake the washer.

NOTICE:

Avoid any impact on the steering rack.

(d) Employ the same manner described above to the other side.



12. INSTALL RH AND LH RACK BOOTS, WIRES AND CLIPS

(a) Ensure that the steering rack hole is not clogged with grease.

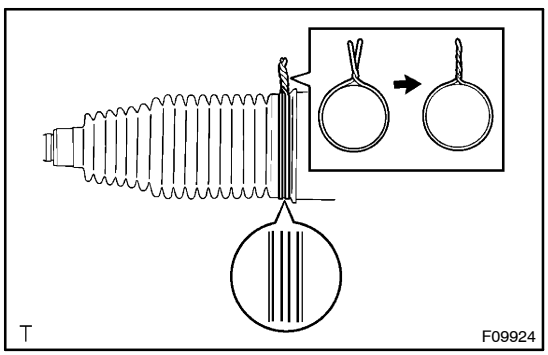
HINT:

If the hole is clogged, the pressure inside the boot will change after it is assembled and the steering wheel is turned.

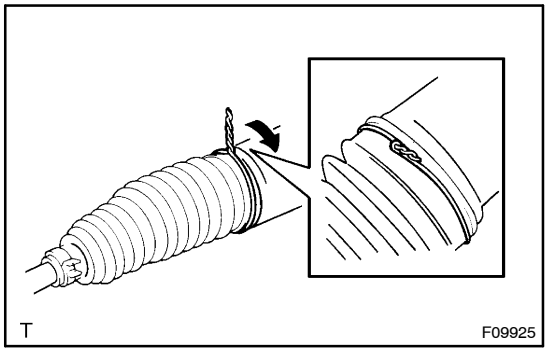
(b) Install the boot, clip and a new wire.

NOTICE:

Be careful not to damage or twist the boot.

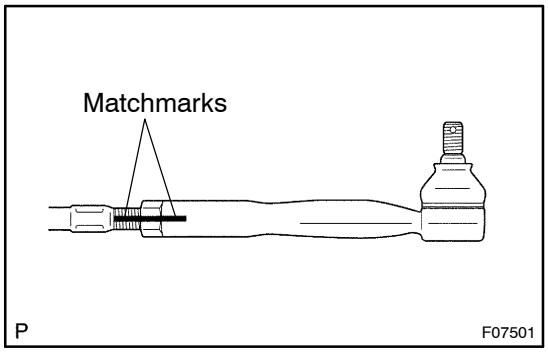


(c) After winding and tightening the wire around the circumference of the boot twice, twist it several times, and install it.



(d) As shown in the illustration, bend the wire to the circular direction to prevent damage to the boot.

(e) Employ the same manner described above to the other side.



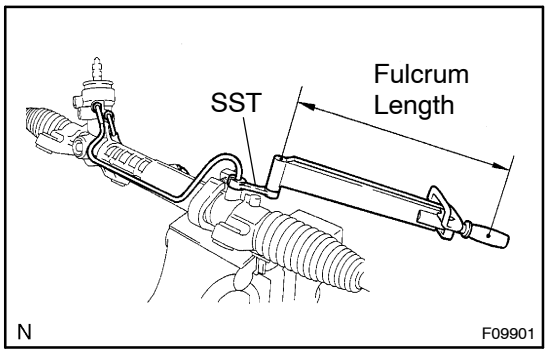
13. INSTALL RH AND LH TIE ROD ENDS AND LOCK NUTS

(a) Screw the lock nut and tie rod end onto the rack end until the matchmarks are aligned.

(b) After adjusting toe–in, torque the nut (See page SA–4).

Torque: 74 N·m (750 kgf·cm, 54 ft·lbf)

(c) Employ the same manner described above to the other side.



14. INSTALL 2 TURN PRESSURE TUBES

Using SST, install the 2 turn pressure tubes.

SST 09633–00020

Torque: 20 N·m (200 kgf·cm, 14 ft·lbf)

HINT:

- Use a torque wrench with a fulcrum length of 300 mm (11.81 in.).
- This torque value is effective in case that SST is parallel to a torque wrench.