

## REASSEMBLY

### NOTICE:

When using a vise, do not overtighten it.

1. **COAT WITH POWER STEERING FLUID OR MOLYBDENUM DISULFIDE LITHIUM BASE GREASE**

(See page SR-98)

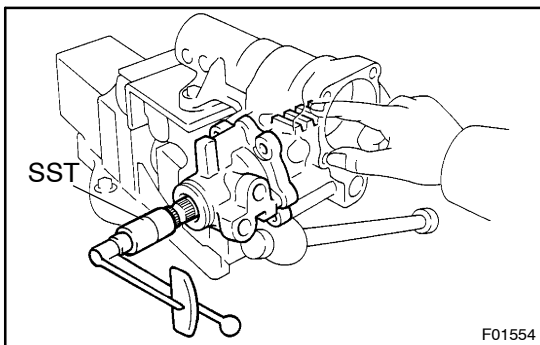
2. **INSTALL WORM GEAR VALVE BODY ASSEMBLY**

- (a) Coat 2 new O-rings with power steering fluid and install them to the gear housing.
- (b) Install the valve body assembly into the gear housing.

### NOTICE:

- **Ensure that the power piston nut does not come off the worm shaft.**
  - **Be careful not to damage the teflon ring.**
- (c) Torque the 4 bolts.

**Torque: 6.1 N·m (620 kgf·cm, 45 ft·lbf)**



- (d) Using SST and a torque wrench, check the valve body assembly rotating torque.

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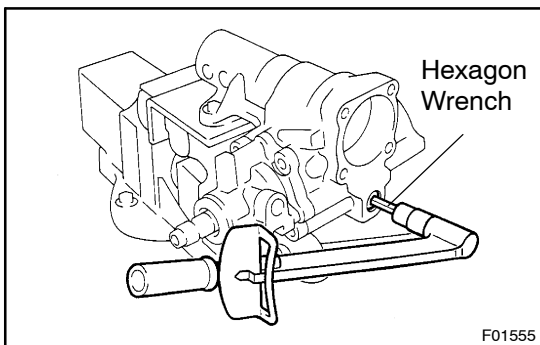
### Rotating torque:

**0.3 – 0.5 N·m (3 – 5.5 kgf·cm, 2.6 – 4.8 in·lbf)**

### HINT:

Hold the worm gear to prevent it from turning.

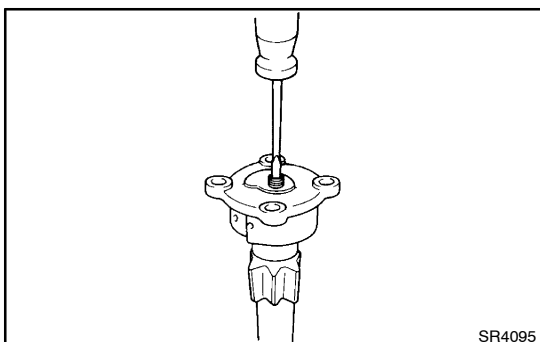
If rotating torque is not correct, replace the worm gear valve body assembly.



3. **INSTALL POWER PISTON PLUNGER GUIDE, POWER PISTON PLUNGER, SPRING AND POWER PISTON PLUNGER GUIDE NUT**

- (a) Coat a new O-ring with power steering fluid and install it to the plunger guide nut.
- (b) Using a hexagon wrench, torque the plunger guide nut.

**Torque: 20 N·m (205 kgf·cm, 15 ft·lbf)**

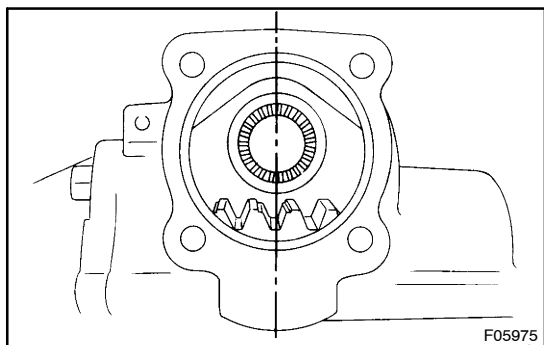


4. **INSTALL SECTOR SHAFT AND SIDE COVER**

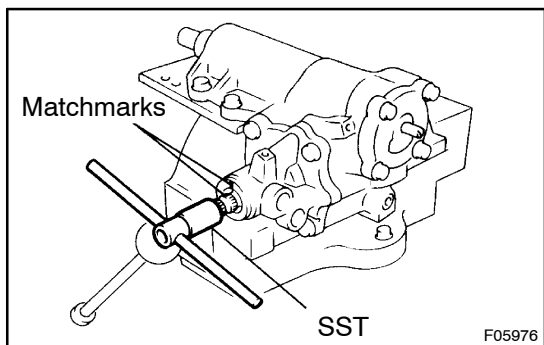
- (a) Coat a new O-ring with power steering fluid and install it to the side cover.
- (b) Using a screwdriver, assemble the sector shaft to the side cover.

### HINT:

Fully loosen the sector shaft adjusting screw.

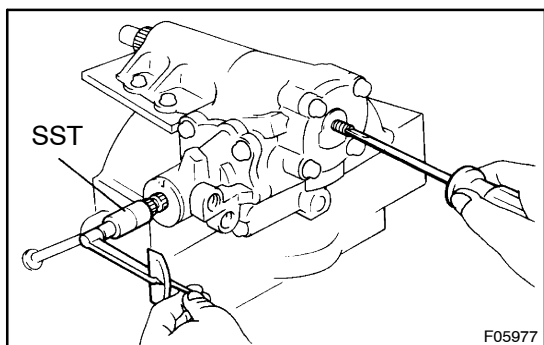


- (c) Set the worm gear at the center of the gear housing.
- (d) Install and push the sector shaft into the gear housing so that the center teeth mesh together.
- (e) Torque the 4 bolts in a diagonal pattern.  
**Torque: 6 1 N·m (620 kgf·cm, 45 ft·lbf)**



## 5. DETERMINE CENTER POSITION

- (a) Using SST, turn the worm gear valve body shaft so full lock in both directions and determine the exact center.  
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- (b) Place matchmarks on the worm gear valve body shaft and gear housing to show neutral position.



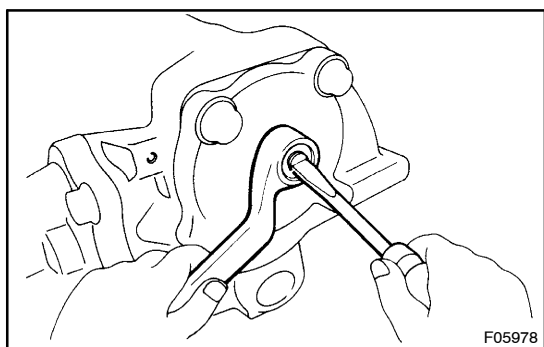
## 6. ADJUST TOTAL PRELOAD

- (a) Install SST with a torque wrench on the worm gear valve body shaft.  
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- (b) Turn the adjusting screw until the preload is within the specification.

**Preload (Turning):**

**0.74 – 1.08 N·m (7.5 – 1 1 kgf·cm, 6.5 – 9.5 in·lbf)**

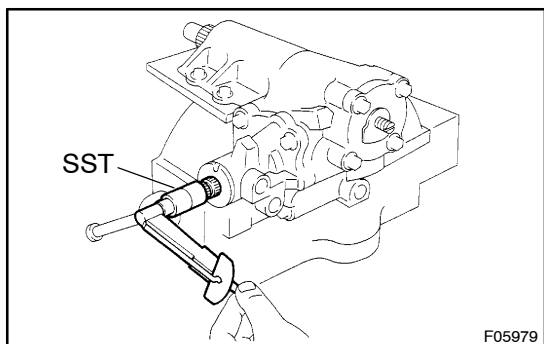
## 7. INSTALL NEW SEAL WASHER



## 8. INSTALL ADJUSTING SCREW LOCK NUT

Torque the lock nut while holding the sector shaft adjusting screw.

**Torque: 46 N·m (470 kgf·cm, 34 ft·lbf)**



## 9. CHECK TOTAL PRELOAD

Using SST and a torque wrench, check the total preload.

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**Total preload (Turning):**

**0.74 – 1.08 N·m (7.5 – 1 1 kgf·cm, 6.5 – 9.5 in·lbf)**