

B3E061432960W04

- Place copper plates, rag, or similar material in a vise, when securing the mounting bracket portion of the steering gear.

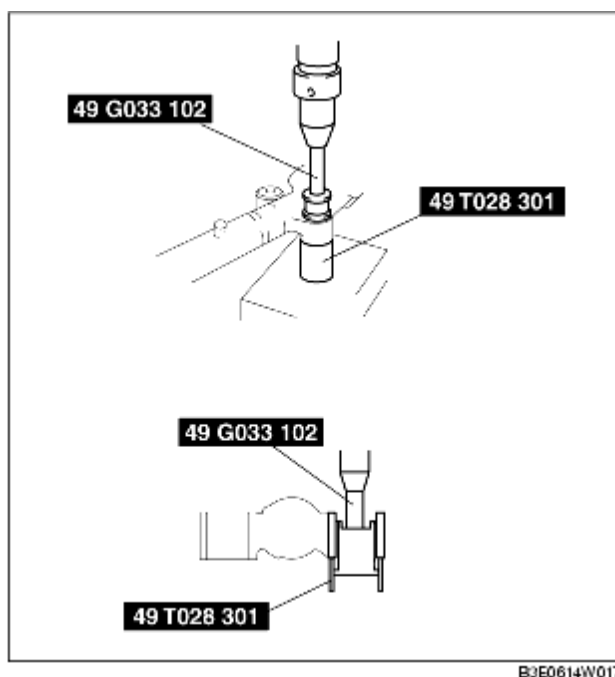
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1	Gear housing
2	Mounting rubber (See Mounting Rubber Assembly Note.)
3	Oil seal (See Oil Seal Assembly Note.)
4	Steering rack (See Steering Rack Assembly Note.)
5	Rack bushing (See Rack Bushing Assembly Note.)
6	Stopper
7	Clip
	Pinion shaft and valve housing component

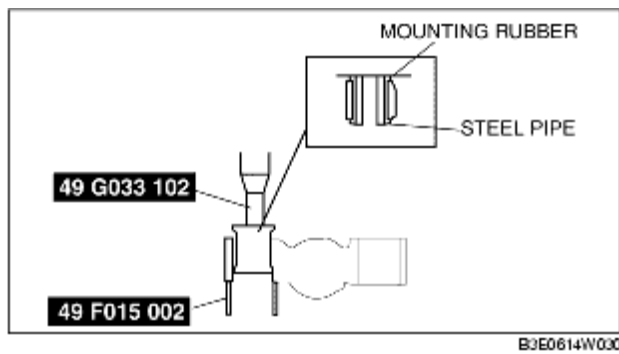
8	(See Pinion Shaft and Valve Housing Component Assembly Note.)
9	Locknut
10	Housing cover (See Housing Cover Assembly Note.)
11	Support yoke
12	Yoke spring
13	Adjusting cover (See Adjusting Cover Assembly Note.)
14	Locknut (on adjusting cover) (See Locknut (on Adjusting Cover) Assembly Note.)
15	Tie rod
16	Boot (See Boot Assembly Note.)
17	Boot band
18	Boot clamp
19	Locknut
20	Tie-rod end
21	Oil pipe
22	Return pipe
23	Floor seal (See Floor Seal Assembly Note.)
24	P/S angle sensor (LF only) (See P/S Angle Sensor Assembly Note (Only for L.H.D.).)

Mounting Rubber Assembly Note

1. Apply soapy water to the rubber part of the mounting rubber.
2. Install the mounting rubber so that two notches of the mounting rubber are parallel to the steering rack.
3. Press the mounting rubber until the mounting rubber end comes out completely from the gear housing using the **SSTs** and a press.

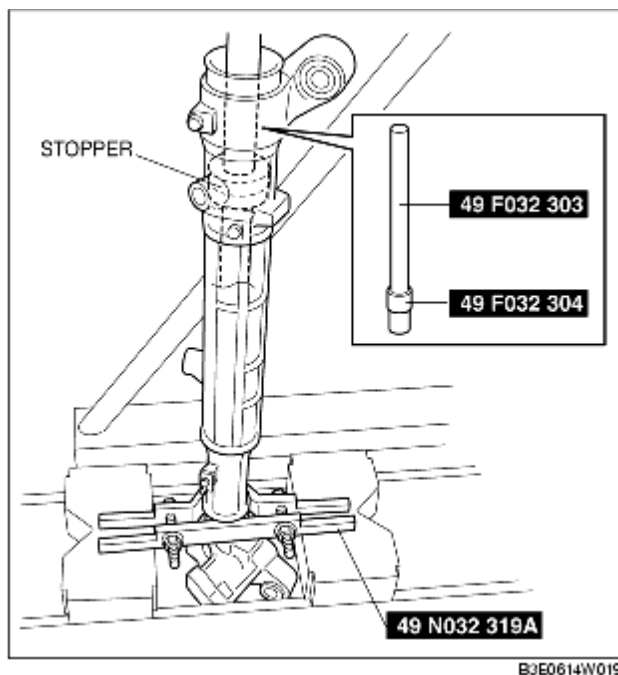


4. Reverse the gear housing, then press the mounting rubber until the mounting rubber end comes out completely from the other side. At this time, make sure that the mounting rubber and steel pipe are aligned.



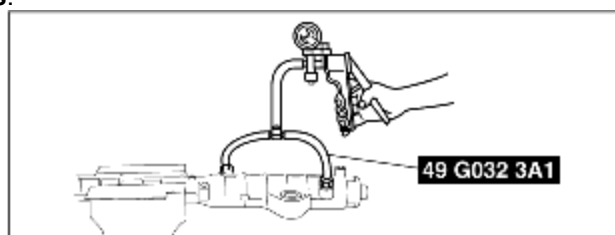
Oil Seal Assembly Note

1. Apply ATF to the lip of a new oil seal.
2. Install the **SST** (49 N032 319A) to the gear housing with the raised part facing up as shown in the figure.
3. Set the stopper into the gear housing to hold the **SSTs** as shown in the figure.



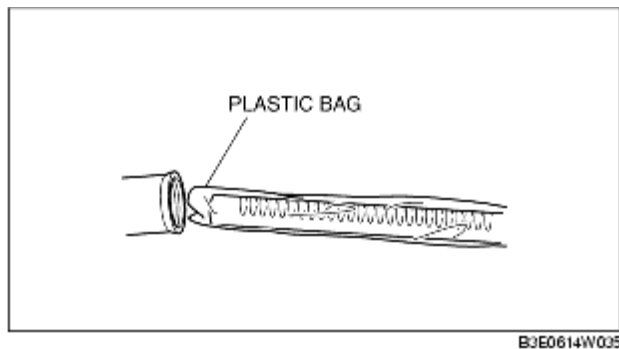
4. Install the oil seal using the **SSTs** (49 F032 303, 49 F032 304) and a press.
5. Inspect airtightness.

- (1) Connect the **SST** to the power cylinder section of the gear housing.
- (2) Apply **53.3 kPa {400 mmHg, 15.8 inHg}** vacuum with a vacuum pump and verify that it is held for **30 s**.



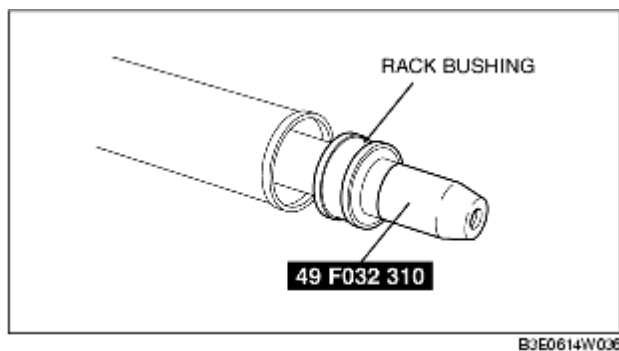
Steering Rack Assembly Note

1. Apply multipurpose grease to the rack teeth.
2. Install a plastic bag to the rack teeth and insert the steering rack in the gear housing.



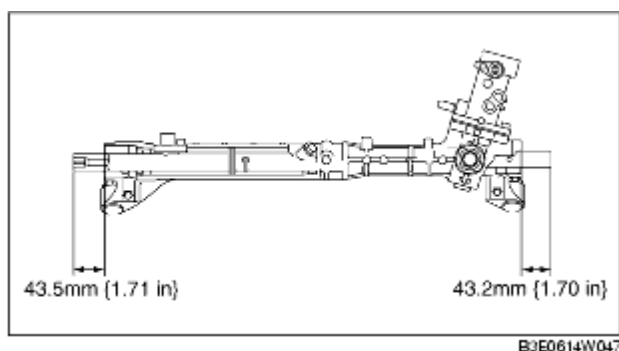
Rack Bushing Assembly Note

1. After installing the **SST** to the steering rack end, assemble the rack bushing to the rack housing.



Pinion Shaft and Valve Housing Component Assembly Note

1. Set the rack in the center with the measurement between rack housing end and rack end as shown in the figure.



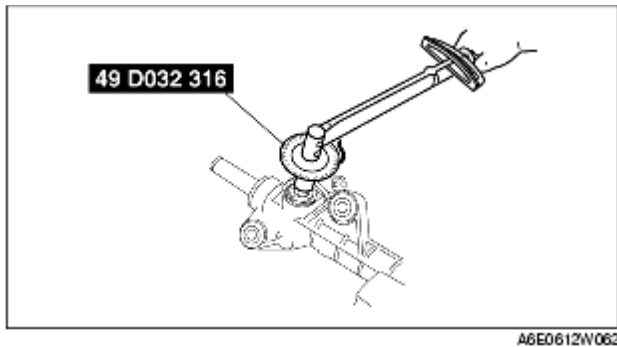
2. When the pinion shaft position is as shown in the figure with the rack in the center, insert the pinion shaft and valve housing component.

Housing Cover Assembly Note

1. Apply silicone sealant to the threads of the housing cover.
2. Assemble the housing cover.

Adjusting Cover Assembly Note

1. Apply sealant to the threads of the adjusting cover.
2. Using the **SST**, tighten the adjusting cover with a tightening torque of **20.0 N·m {2.0 kgf·m, 14.8 ft·lbf}**.



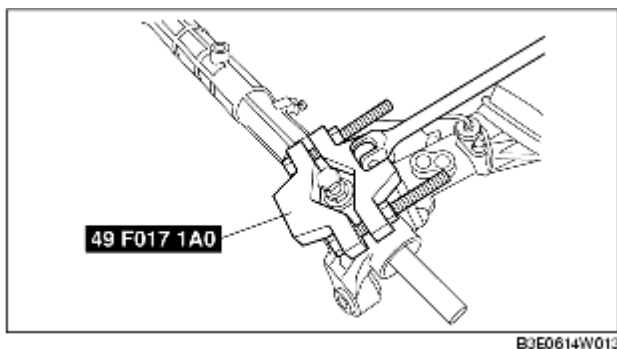
3. Using the **SST**, loosen the adjusting cover to **25-30°**.

Locknut (on Adjusting Cover) Assembly Note

Caution

- Be sure that the adjusting cover will not turn together with the locknut.

1. Fix the adjusting cover and tighten the locknut.



2. Measure the pinion torque using the torque wrench.

Standard
Center of rack $\pm 90^\circ$
0.88-1.48 N·m
{8.98-15.0 kgf·cm, 7.79-13.0 in·lbf}

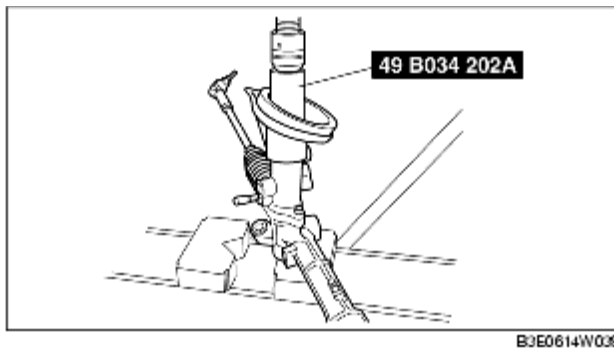
3. If not as specified, remove the locknut and adjust the adjust cover.

Boot Assembly Note

1. Apply silicone grease to the rubber lip groove.
2. Assemble the boot.

Floor Seal Assembly Note

1. Assemble a new floor seal using the **SST** and a press.



P/S Angle Sensor Assembly Note (Only for L.H.D.)

1. For L.H.D., assemble a new P/S angle sensor in the order shown in the figure.

