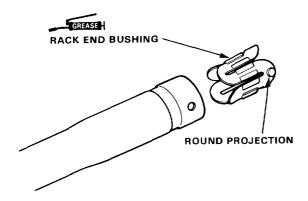# Gearbox

Reassembly

1. Apply a thin coat of grease to the inside surface of the rack end bushing.
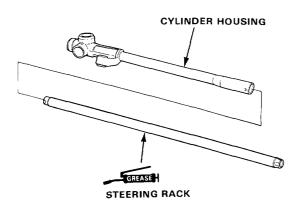
   Grease quantity: 1—3g

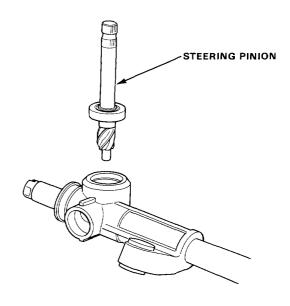   > **CAUTION: Do not fill the slots with grease; they must remain open to serve as air passages.**

2. Install the rack end busing by aligning the round projections on the busing with the holes in the cylinder housing.

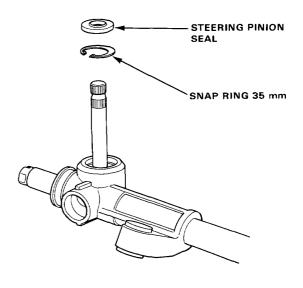   **RACK END BUSHING**

   ROUND PROJECTION

3. Apply grease to the steering rack.

4. Install the steering rack into the cylinder housing carefully to avoid damaging the steering rack sliding surface.

   CYLINDER HOUSING

   STEERING RACK

5. Install the steering pinion in the gear housing.

   STEERING PINION

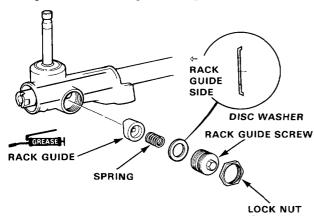6. Install the 35 mm snap ring securely in the gear housing groove.

7. Grease the Steering pinion seal, and install it on the gear housing.

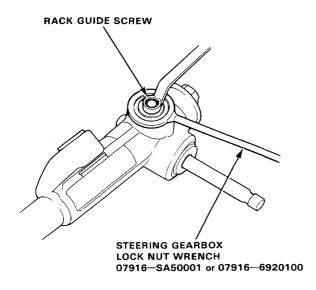   **STEERING PINION SEAL**

   SNAP RING 35 mm

8. Coat the rack guide with grease.

9. Install the rack guide, spring, disc washer and rack guide screw on the gear housing.

RACK GUIDE SIDE
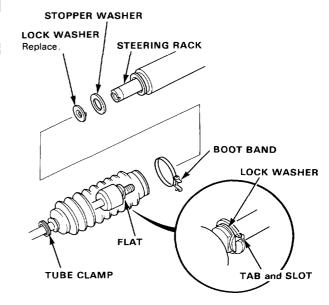
DISC WASHER

RACK GUIDE SCREW

GREASE

RACK GUIDE

SPRING

LOCK NUT

— Tighten, loosen and re-tighten the rack guide screw two times, to 5 N·m (0.5 kg-m, 3.6 lb-ft) then back it off $15^{\circ} {}^{+0}_{-5}$. (front wheels pointed straight ahead).

— Tighten the locknut on the rack guide screw to the 68 N·m (6.8 kg-m, 49 lb-ft).

10. Tighten the lock nut while holding the rack guide screw with the special tool.

RACK GUIDE SCREW

STEERING GEARBOX
LOCK NUT WRENCH
07916—SA50001 or 07916—6920100

11. Screw each tie-rod into the rack while holding the lock washer so its tabs are in the slots in the rack end.

NOTE: Install the stopper washer with the chamfered side facing out.

12. Tighten the tie-rod securely, then bend the lock washer back against the flat on the flange as shown.

STOPPER WASHER

LOCK WASHER
Replace.

STEERING RACK

BOOT BAND

LOCK WASHER

TUBE CLAMP

FLAT

TAB and SLOT

13. Install the boots and secure with boot band and tube clamp.

14. Check that the boots are not twisted or collapsed by sliding the rack.

15. Install the tie-rod ends on the tie-rods. Do not tighten the locknuts until after tie-rod adjustment.

16. Fill the tie-rod boots with grease and install; replace boots that are cut or split.

17. Bleed air from the boots by gently squeezing them from the bottom up.

18. Use the special tool's bolt to adjust the depth of the tool's large end. Align the large end of the tool with the groove on the boot. Slide the clip into position over the tool.

BALL JOINT BOOT
CLIP GUIDE B
07974—SA50800

CIRCLIP

GREASE