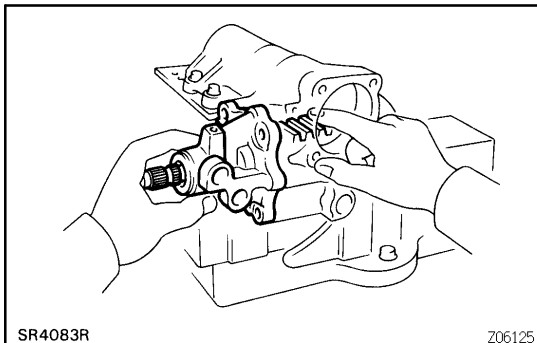
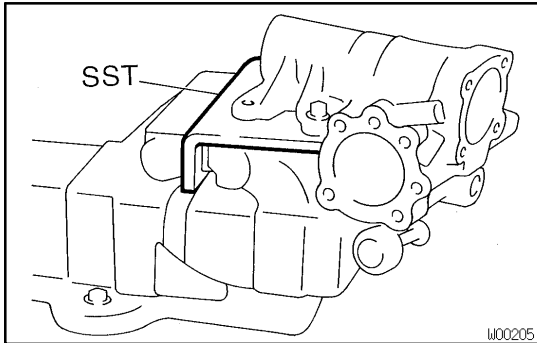


REASSEMBLY

NOTICE:

When using a vise, do not overtighten it.

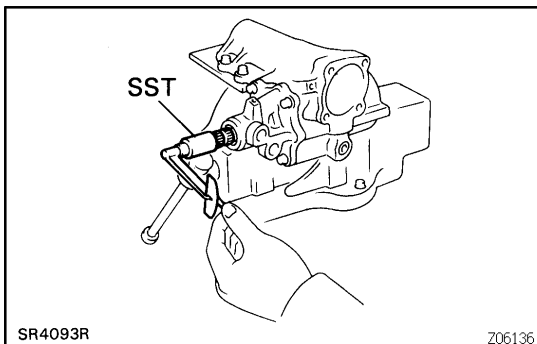
1. **COAT WITH MOLYBDENUM DISULFIDE LITHIUM BASE GREASE** (See page [SR-33](#))
2. **INSTALL WORM GEAR VALVE BODY ASSEMBLY**
 - (a) Coat 2 new O-rings with power steering fluid and install them to the gear housing.
 - (b) Secure the gear housing on SST and clamp SST in vise.
SST 09630-00014 (09631-00142)



- (c) Install the valve body assembly while supporting the worm gear with your fingers so that it does not rotate.
- (d) Torque the 4 bolts.
Torque: 61 N·m (620 kgf·cm, 45 ft·lbf)

NOTICE:

Be careful not to damage the teflon ring.

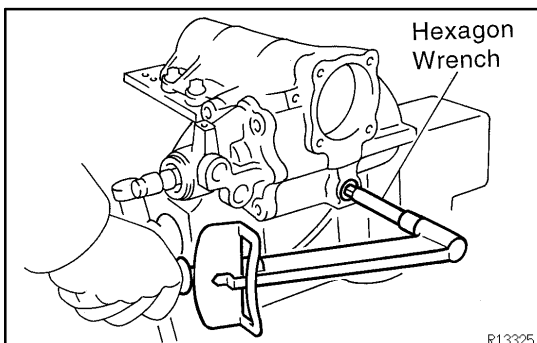


- (e) Using SST and a torque wrench, check the valve body assembly rotating torque.
SST 09616-00010
Rotating torque:
0.3 - 0.5 N·m (3 - 5.5 kgf·cm, 2.6 - 4.8 in.·lbf)

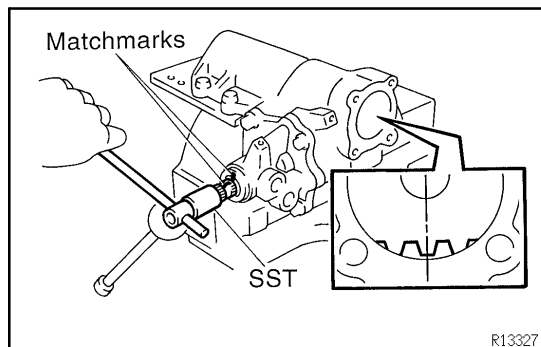
HINT:

Hold the worm gear to prevent it from turning.

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

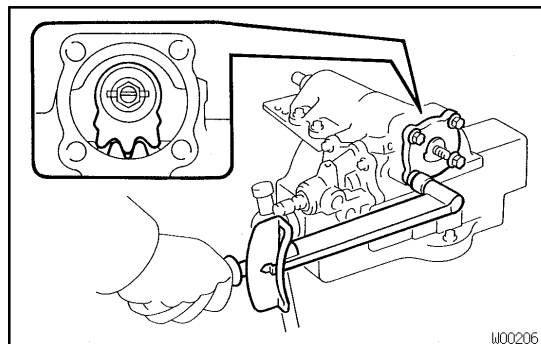


3. **INSTALL POWER PISTON PLUNGER GUIDE, POWER PISTON PLUNGER, COMPRESSION SPRING AND POWER PISTON PLUNGER GUIDE NUT**
 - (a) Coat a new O-ring with power steering fluid.
 - (b) Install the O-ring to the plunger guide nut and install the plunger guide nut with a hexagon wrench (10 mm).
Torque: 20 N·m (205 kgf·cm, 15 ft·lbf)



4. DETERMINE CENTER POSITION

- Using SST, turn the worm gear valve body shaft so full lock in both directions and determine the exact center.
SST 09616-00010
- Place matchmarks on the worm gear valve body shaft and worm gear valve body housing to show neutral position.



5. INSTALL CROSS SHAFT AND SIDE COVER

- Coat a new O-ring with power steering fluid and install it on the side cover.
- Assemble the cross shaft to the side cover.

HINT:

Fully loosen the cross shaft adjusting screw.

- Install and push the cross shaft into the gear housing so that the center teeth mesh together.
- Torque the 4 bolts in a diagonal pattern.

Torque: 61 N·m (620 kgf·cm, 45 ft·lbf)

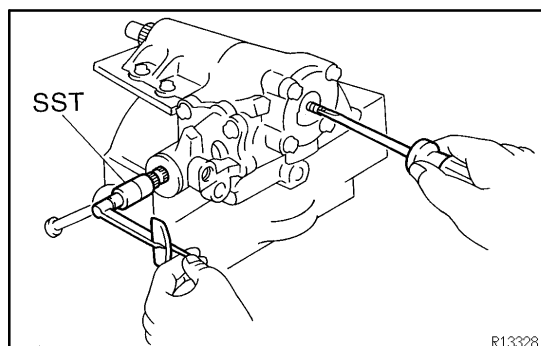
6. ADJUST TOTAL PRELOAD

- Install SST with a torque wrench on the worm gear valve body shaft.
SST 09616-00010
- Turn the cross shaft adjusting screw until the preload is within specification.

Preload (Turning):

0.74 - 10.8 N·m (7.5 - 11.0 kgf·cm, 6.5 - 9.6 in·lbf)

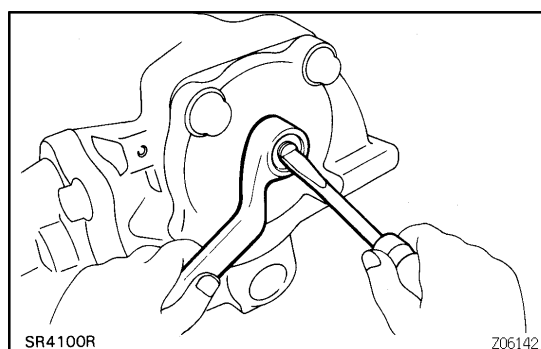
7. INSTALL NEW SEAL WASHER



8. INSTALL ADJUSTING SCREW LOCK NUT

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

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



9. CHECK TOTAL PRELOAD

Using SST and a torque wrench, check total preload.

SST 09616-00010

Total preload (Turning):

0.74 - 1.08 N·m (7.5 - 11.0 kgf·cm, 6.5 - 9.6 in·lbf)

