

STEERING GEAR AND LINKAGE ASSEMBLY

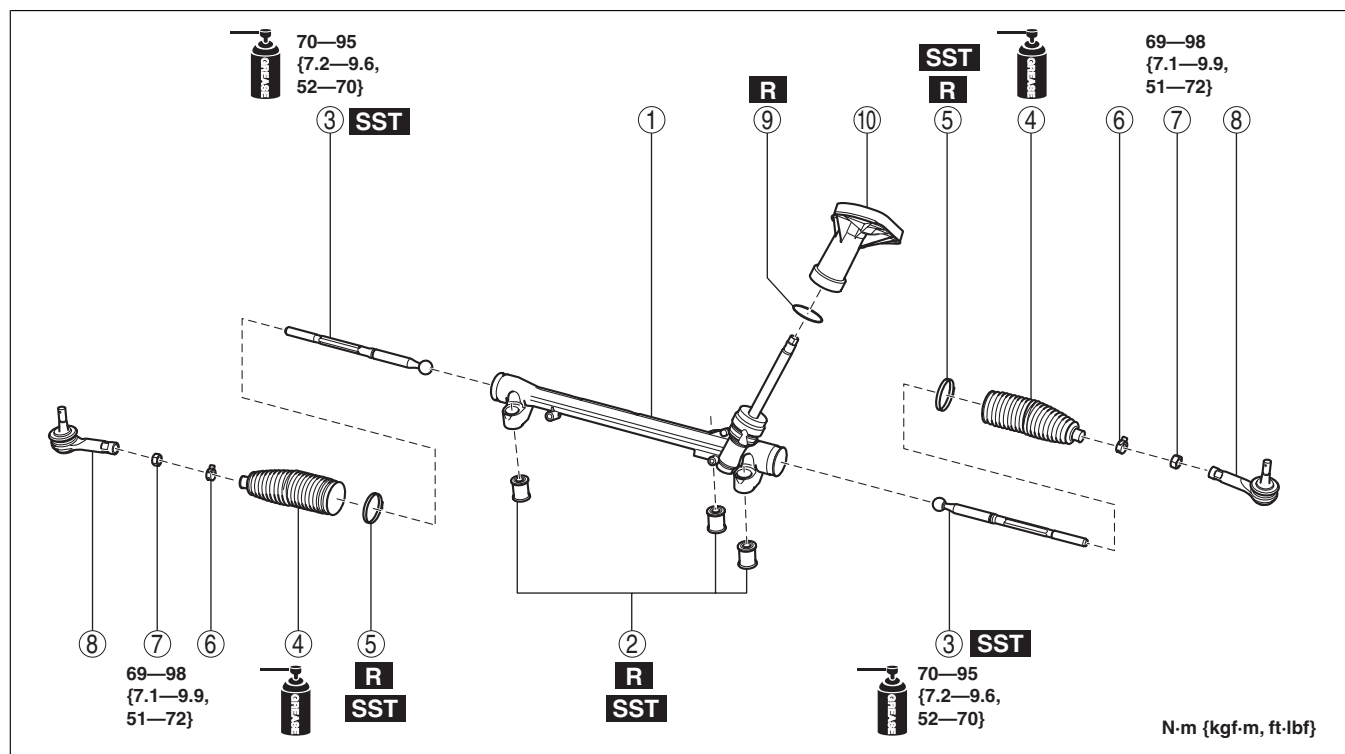
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Caution

- To prevent damage to the steering gear, secure it to the vise using a copper plate or clean cloth.

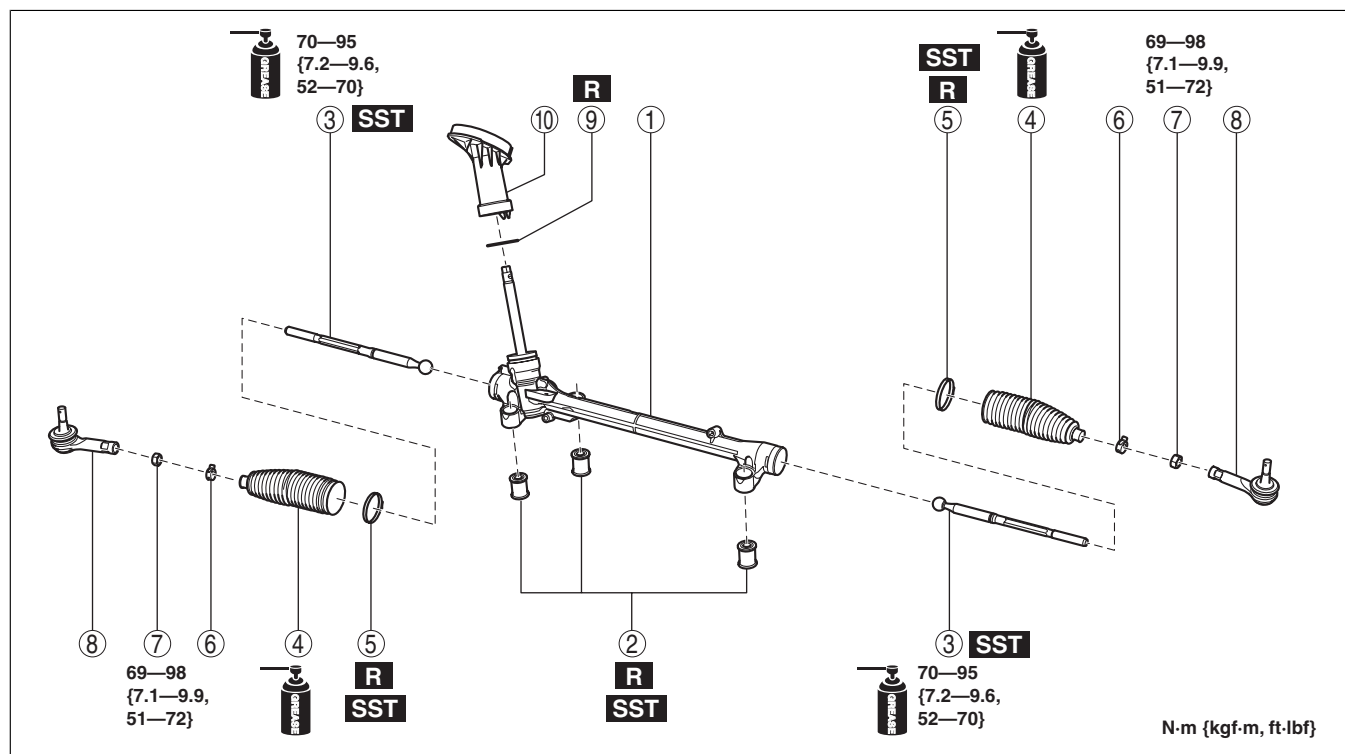
1. Assemble in the order shown in the figure.

L.H.D.



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R.H.D.



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1 Steering gear

2 Mounting rubber
(See Mounting Rubber Assembly Note.)

3	Tie rod (See Tie Rod Assembly Note .)
4	Boot
5	Boot band (See Boot Band Assembly Note .)
6	Boot clamp

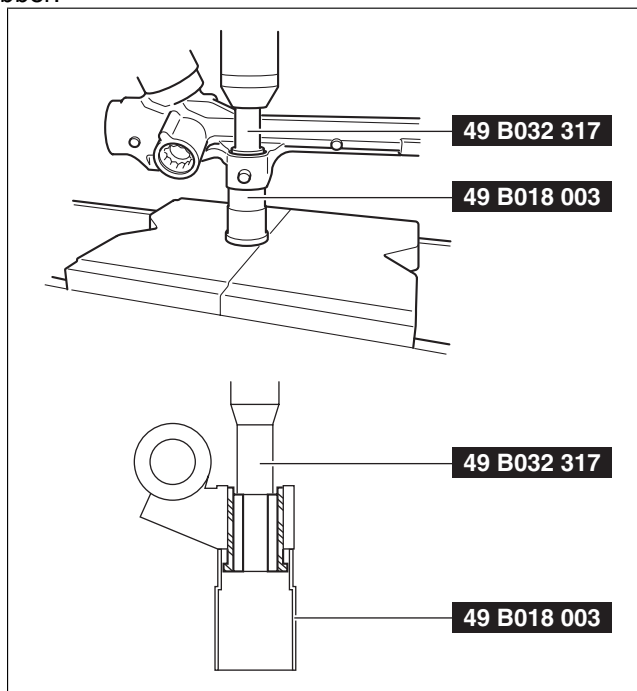
7	Locknut
8	Tie-rod end (See Tie-rod End Assembly Note.)
9	O-ring
10	Dust cover

Mounting Rubber Assembly Note

1. Apply soapy water to the rubber part of the mounting rubber.
2. Press fit the ear portion of the mounting rubber (lower side) using the SSTs until it projects from the gear housing as shown in the figure.

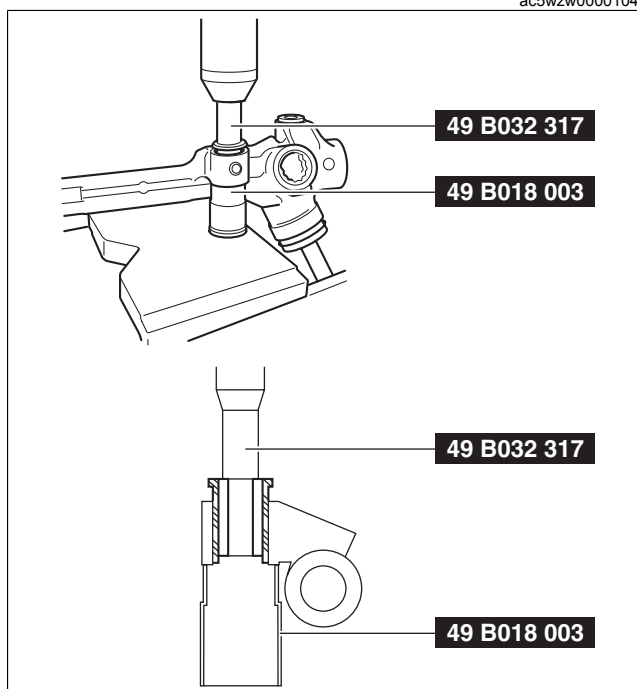
Note

- Press fit the ear portion of the mounting rubber (upper side) until it partially enters the gear housing.



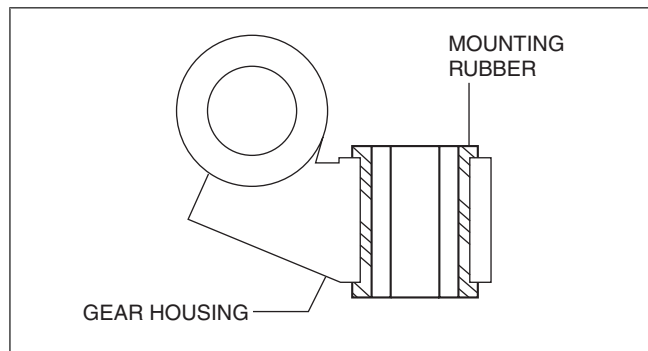
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3. Reverse the gear housing, then press fit the mounting rubber using the SSTs and the press until the mounting rubber ear portion (upper side) contacts the gear housing.



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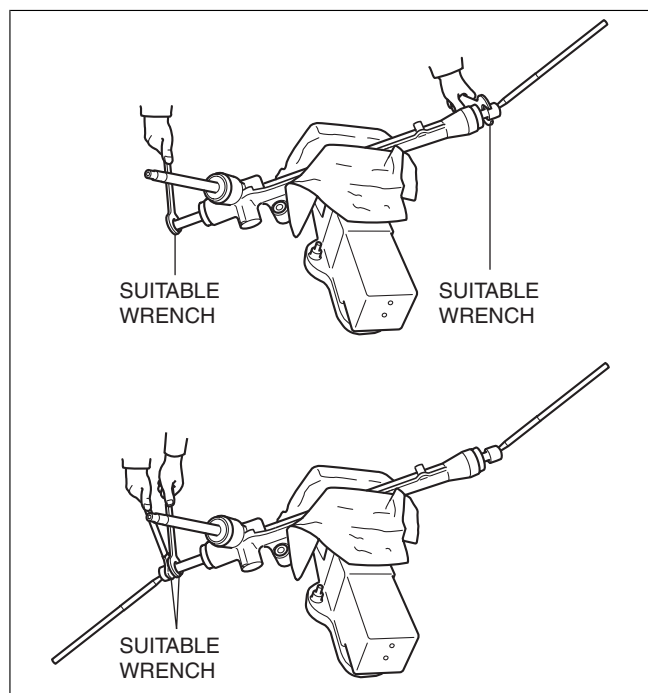
4. Verify that both mounting rubber ears are correctly assembled with no gaps between them and the gear housing as shown in the figure.
 - If there are gaps, readjust their positions using the **SSTs** and the press.



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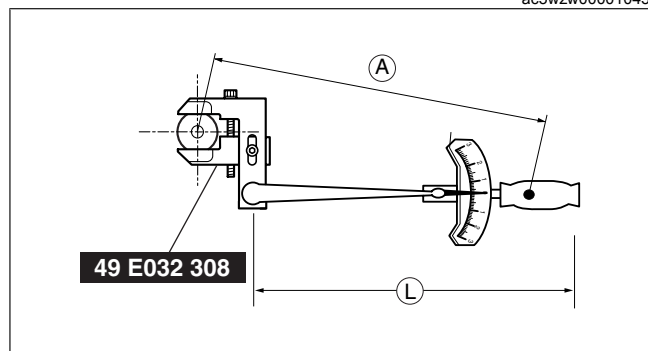
Tie Rod Assembly Note

1. Lock the steering rack end (pinion gear side) against rotation with a wrench and install the tie rod using the suitable wrench.



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2. Combine the the **SST** with the torque wrench, then measure A and L as shown in the figure.
 - A: Length from the center of the tie rod to the grip.
 - L: Length of the torque wrench.

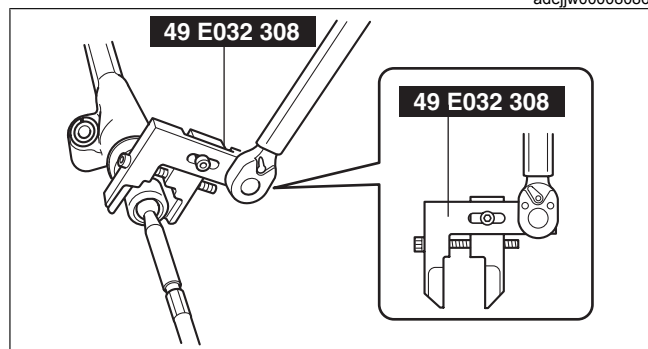


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3. Recalculate the torque by using torque formulas, then tighten the tie rod using the **SST**.

Caution

- When installing a torque wrench to the **SST** (49 E032 308), install it perpendicular to the **SST** as shown in the figure. If installed incorrectly, the **SST** could separate from the tie rod, which could cause damage to the tie rod.



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Tightening Torque

70—95 N·m {7.2—9.6 kgf·m, 52—70 ft·lbf}

Torque formula

Torque unit	Formula
N·m	$N \cdot m \times [L/A]$
kgf·m	$kgf \cdot m \times [L/A]$

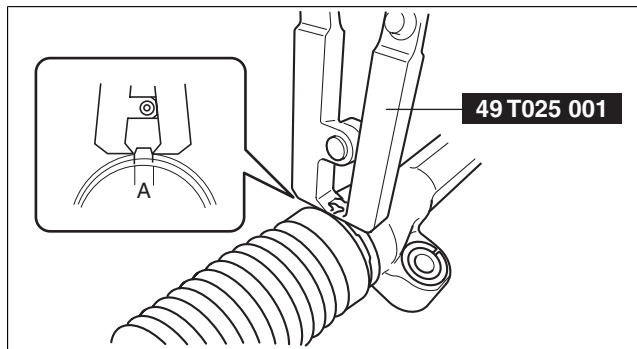
Torque unit	Formula
ft·lbf	$ft \cdot lbf \times [L/A]$

Boot Band Assembly Note

1. Assemble the boot band to the boot.
2. Crimp the boot band using the **SST**.
3. Verify that the crimping clearance A is within the specification.
 - If crimping clearance A exceeds the specification, reduce **SST** clearance, and crimp the boot band again.
 - If crimping clearance A is less than the specification, increase **SST** clearance, and crimp a new boot band.

Standard clearance A

2.5—3.0 mm {0.10—0.11 in}

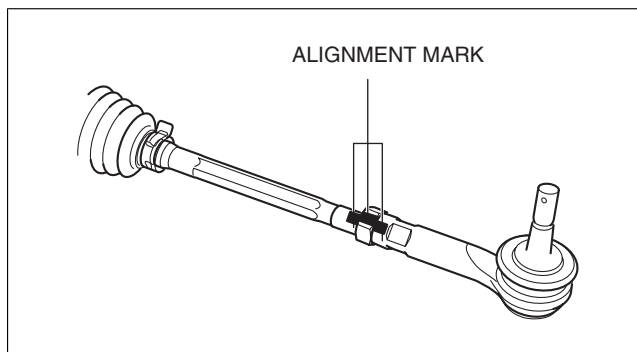


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4. Rotate the by hand and verify that it is securely installed to the boot band.

Tie-rod End Assembly Note

1. Align the alignment marks made before removal and assemble the tie-rod end to the tie rod.
 - If there are no alignment marks, go to the next step.

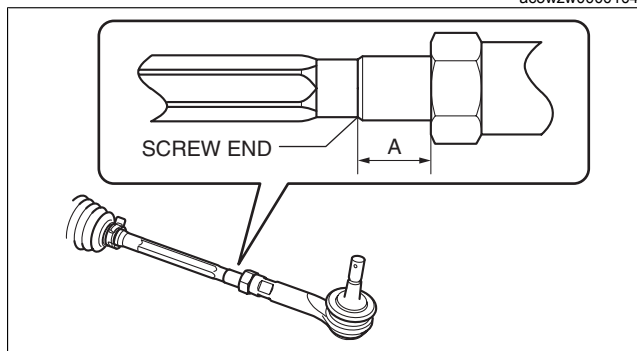


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2. Adjust dimension A shown in the figure to the standard, then assemble the tie-rod end.

Standard Dimension A

- 10.1—23.1 mm {0.398—0.909 in}



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