Steering Box Rebuild Kit

**Note: At this time this part is not available**

The following items are included in this kit:

<table>
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<th>1 - Worm Shaft Seal</th>
<th>1 - Set Adjustor Shims</th>
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<td>1 - Sector Shaft Seal</td>
<td>2 - Worm Shaft Felt Seal</td>
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<td>1 - Top Cover Gasket</td>
<td>2 - Sector Shaft Bearings</td>
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<td>1 - Top Cover Assembly with Bolts</td>
<td>2 - Worm Shaft Bearings</td>
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<tr>
<td>1 - Worm Shaft Bearing Retainer</td>
<td>2 - Worm Shaft Races</td>
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<td>1 - Sector Shaft Adjustor</td>
<td>54 - Worm Shaft Balls</td>
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Be sure your work area is free of dirt for the reassembly of the steering box. Remove the steering box from your car. Place a pan under the box to catch the oil. Refer to figure A for parts layout.

**DISASSEMBLY**

1. Remove the number 22 bolt and turn the number 18 adjustor counterclockwise.

2. Remove the number 21 bolt and pull the side cover with the sector shaft from the housing. Worm shaft must be centered to remove. See figure B.

3. Remove locknut number 1 and adjustor number 2. Slide the worm shaft with ball nut out of the housing. See figure C.

4. Turn the number 18 adjustor clockwise until it is free of the top cover. Slide the adjustor and shims out of the slot in the end of the sector shaft.

5. Remove screw number 23, clamp 24, and turn the number 5 nut assembly upside down over a pan. Turn the worm shaft back and forth until all the balls have dropped out of the nut.

6. Take drive seal number 13 and race number 8 out of the housing. Take bushing number 11 and number 16 along with seal number 10 out of the housing.

7. Remove bearing number 4, race number 3, and the retainer form adjustor number 2

Be sure to clean all the parts that you will be using again.
REASSEMBLY

1. Press the new number 11 and 16 bushings in to the housing using the old bushing for the driver. Install the new number 11 seal.

2. Press number 8 bearing race into the housing from the inside and the number 13 seal from the outside.

3. Install new race number 3, bearing number 4, and the retainer in the number 2 adjustor.

4. Slide number 5 worm nut over the worm shaft with the holes facing upward, and the widest portion of the teeth to the left from the steering wheel position.

5. Count 27 of the number 26 balls and drop them into one of the guide holes while turning the worm shaft slowly away from that hole. Continue until the ball circuit is full from the bottom of one guide hole to the bottom of the other guide hole. See figure D. It may be necessary to turn the worm back and forth holding the balls down in one hole first and then do the same in the other to fill the circuit.

6. Fill half of the ball guide with the leftover balls from initial 27 and fill the other half with Vaseline to hold the balls in place. See figure E. Fill the second ball circuit in the same manner.

7. With both circuits complete, reinstall clamp number 24 and screw number 23.

8. Slide the new adjustor number 18 with shim number 19 on to the end of the sector shaft. Check the end clearance. See figure G. The end clearance should not be greater than .002 inches. Four shims are included in the kit for the adjustment of the clearance.

9. Screw adjustor number 18 counterclockwise through cover number 20 until it stops.

10. Slide the worm shaft and the nut assembly into the housing with the new bearing number 7 on the shaft.

11. Install the number 2 adjustor assembly in the lower end of the housing. Adjust it until all the end play has been removed. Tighten locknut number 1.

12. Install the new gasket on the top cover. Install the sector shaft with the cover into the housing making sure that the teeth on the nut and sector shaft are centered with each other. Install the number 21 bolts.
ADJUSTMENT

1. Install the steering wheel and turn it from lock to lock. The pull required to turn the wheel should be between 3/8 and 5/8 pounds. If necessary you may tighten or loosen adjustor number 2 to get the proper pull.

2. With the steering box centered, turn adjustor number 18 clockwise to remove all lash between the ball nut teeth and the sector teeth. Fill the housing with all-purpose or 80-90 weight universal gear lubricant.

3. Slide the new felt down the worm shaft to the box. Install the box.

FIGURE A

1. Worm Bearing Adjustor Lock Nut
2. Worm Bearing Adjustor
3. Lower Worm Bearing
4. Lower Ball Bearing
5. Ball Nut
6. Worm Shaft
7. Upper Ball Bearing
8. Upper Worm Bearing Cup
9. Packing Retainer
10. Seal
11. Lower Sector Shaft Bushing
12. Housing
13. Seal
14. Filler Plug
15. Gasket
16. Upper Sector Shaft Bushing
17. Sector and Shaft
18. Lash Adjustor
19. Lash Adjustor Shim
20. Housing Side cover and Bushing Assembly
21. Side Cover Bolts
22. Lash Adjustor Lock Nut
23. Ball Guide Clamp Screw
24. Ball Guide Clamp
25. Ball Guides
26. Balls