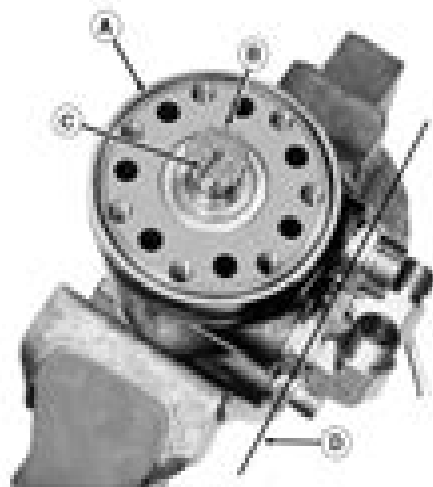


- A Balls
- B Centering Spring

Install a ball (A) on each side of centering keys.

Install spring ends to each ball and continue inserting spring toward the bottom center position (B).

Install bearing races, needle thrust bearing, front retainer with new seals, and retaining ring.



Steering Valve Timing

LEGEND:

- A O-Ring Seal
- B Drive
- C Timing Mark
- D Port Face Reference Line

Clamp the housing in a vise as illustrated.

Install O-ring seal (A) in housing.

NOTE:

Timing mark (C) is parallel with slot in the end of drive.

Install drive (B) making sure drive correctly engages with centering pin inside the spool-sleeve assembly. Make sure timing mark (C) on drive is parallel to port face (D) of housing.

NOTE:



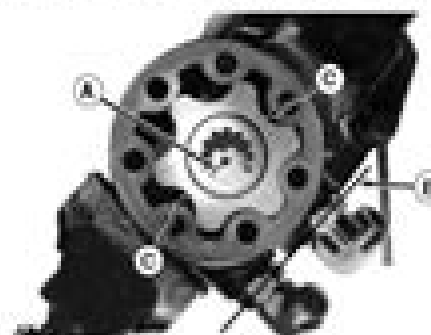
Wear Plate Installation

LEGEND:

- A Wear Plate

The wear plate oil feed holes are larger on one side than the other.

Install wear plate (A) making sure the smaller diameter holes are toward the valve housing.



Steering Valve Timing

LEGEND:

- A Timing Mark
- B Reference Line
- C Star Valleys

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