CA & CT Series Rotating Group Replacement Instructions. Service Kit #403915-J 3, 403915-J 5 and 403917-J 5.

Released June, 1996
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Tilt Only (CT) Procedure

1. Remove the column from the vehicle. Remove the upper shroud (2) by removing four mounting screws (1), and twisting the shroud off over the input shaft.

2. Place the column in a vice, clamping on the mounting bracket flange.

3. Remove four bolts (6) from the base unit and bearing cap.

4. Remove the bearing cap (7).

5. Tilt away from the mounting bracket and remove the rotating group (9) by lifting the bearings out of their grooves, and pulling on the input shaft. Discard.

6. Insert the new rotating group (9) in the jacket tube.

7. Make sure the ground terminal (8) is in place in the housing. Seat the bearings in the tilt housing grooves. Make sure the bearing gaskets are straight and seated properly.

8. Install the bearing cap (7) with the pilot up, so it matches with the pilot lip on the housing. Install four bolts (6), placing the ground wire over one bolt. Torque to 75-80 lbf•in.

9. Reinstall the upper shroud (2), and torque the mounting screws (1) to 25-30 lbf•in. Reinstall the column in the vehicle. Torque mounting bolts to manufacturer’s specifications.

<table>
<thead>
<tr>
<th>No.</th>
<th>Description</th>
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<tbody>
<tr>
<td>1</td>
<td>Mounting screws (4)</td>
</tr>
<tr>
<td>2</td>
<td>Upper shroud</td>
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<tr>
<td>3</td>
<td>Upper shroud</td>
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<tr>
<td>4</td>
<td>Upper shroud</td>
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<tr>
<td>5</td>
<td>Upper shroud</td>
</tr>
<tr>
<td>6</td>
<td>Bolts (4)</td>
</tr>
<tr>
<td>7</td>
<td>Bearing cap</td>
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<tr>
<td>8</td>
<td>Ground terminal</td>
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<tr>
<td>9</td>
<td>Rotating group</td>
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</tbody>
</table>
Tilt Telescope (CA) Procedure

1. Remove the column from the vehicle. Remove the upper shroud (2) by removing four mounting screws (1), and twisting the shroud off over the input shaft.

2. Place the column in a vice, clamping on the mounting bracket flange.

3. Telescope the column up fully to partially unload the telescope spring.

4. Remove four bolts (6) from the base unit and bearing cap.

5. Remove the bearing cap (7).

6. Tilt away from the bracket and remove the upper rotating tube (10) by lifting the bearings out of their grooves, and pulling on the input shaft. Discard.

7. Remove the retaining ring (9) holding the lower rotating tube.

8. Remove the lower rotating tube (11) from the base unit and discard.

9. Make sure the dust cover (R3) is still in place on the lower bearing, and the telescope spring (R2) is still in place in the jacket tube.

10. Note the position of the alignment arrows on the rotating tubes. Alignment arrows must line up for the tubes to fit together and function properly. Mark if necessary to align parts during installation, but not on the formed surfaces.

11. Install the lower retaining ring (9). Make sure it is seated properly in its groove.

12. Align arrows or marks on upper and lower rotating tubes and install the upper rotating tube (10) assembly onto the lower rotating tube.

13. Make sure the ground terminal (8) is in place in the housing. Seat the bearings in the tilt housing grooves. Make sure the bearing gaskets are straight and seated properly.

14. Replace the bearing cap (7) with the pilot up, so it matches with the pilot lip on the housing. Install four bolts (6), placing the ground wire over one bolt. Torque to 75-80 lbf•in.

15. Reinstall the upper shroud (2), torque mounting screws (1) to 25-30 lbf•in. Reinstall the column in the vehicle. Torque mounting bolts to manufacturer’s specifications.

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No. | Description
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1 | Mounting screws (4)
2 | Upper shroud
3 | Bolts (4)
4 | Bearing cap
5 | Ground terminal
6 | Retaining Ring
7 | Upper rotating tube
8 | Lower rotating tube
9 | Mounting brackets
10 | Telescope spring
11 | Dust cover

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