This TRW Commercial Steering Systems' service procedure has been written to help you repair commercial vehicles more efficiently. This procedure should not replace your manuals; you should use them together. These materials are intended for use by properly trained, professional mechanics, NOT "Do-it-yourselfers". You should not try to diagnose or repair steering problems unless you have been trained, and have the right equipment, tools and know-how to perform the work correctly and safely.

Service Procedure # COL-162

Field Replacement of CT616FL Steering Column Assemblies

Sept. 06

Tool List
- T25 Torx Drive
- T27 Torx Drive
- Ratchet
- 1 1/4" Socket
- 5/32" Hex (allen) Wrench
- Steering Wheel Puller
- Torque Wrench

NOTE Take appropriate safety measures before beginning this procedure.

1. Remove existing steering column assembly from vehicle.
2. Using a 1.25" socket & wheel puller, remove the steering wheel. See Figure 1.
3. Using a T25 Torx driver, remove the (3) upper shroud screws shown in Figure 2. The upper shroud that faces the driver will come off at this time; be sure to catch the large lock washers and re-use them in #9 below.
4. Using a T27 Torx driver, remove the (1) remaining upper shroud screw shown in Figure 3.
5. Still using a T27 Torx driver, remove the (4) lower shroud screws. See Figure 2.
6. Using a 5/32" Allen driver/wrench, remove the (2) screws shown, and remove the turn signal switch. See Figure 4.
7. Marking it with red paint to prevent re-use, set the old steering column assembly aside.
8. Re-use the turn signal switch, and install it on the new steering column assembly, re-using the (2) Allen screws from #6 above. Pull outward on the switch, while tightening the screws to 30-35 in-lbs. See Figure 4.
9. Install the upper shrouds onto the new column assembly, re-using the (3) screws from #3 above. Be sure to fit the large lock washers (from #3 above) over the (2) lower posts, on the inside of the upper shroud that faces the driver. Tighten the (1) upper screw to 25-30 in-lbs, and the (2) lower screws to only 15-20 in-lbs. See Figure 2.

10. Re-install the remaining upper shroud screw, tightening to 40-45 in-lbs. See Figure 3.

11. Install the lower shroud onto the new column assembly, re-using the same (4) screws from #5 above. Tighten all (4) screws to 40-45 in-lbs. See Figure 2

12. Install new steering column assembly in vehicle.