

TRW Automotive
Steering & Suspension Systems

Service Bulletin #TAS-109

Illustration for Service Seal Kits TAS400003, TAS550003 and TAS650009

Revised September, 1995

This TRW Commercial Steering Division service bulletin has been written to help you repair commercial vehicles more efficiently. This bulletin 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.

⚠ WARNING If the TAS65 gear you are servicing has a ball bearing and ball race in the valve housing, remove them and call TRW for disposition. Do not rebuild the gear.

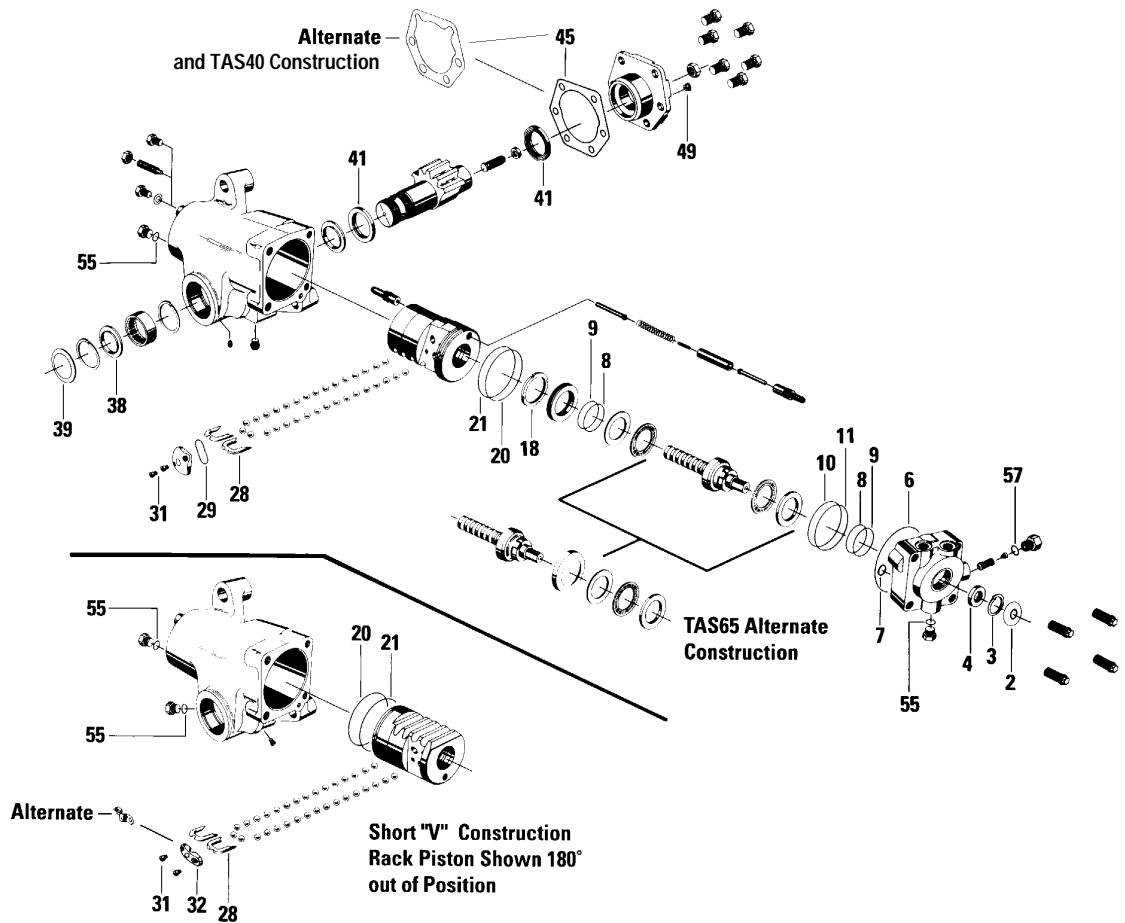
⚠ WARNING All steering mechanisms are safety critical items. As such, it is imperative that the instructions in the vehicle manufacturer's or TRW's latest published service manual are followed to the letter. Failure to observe the proper procedures, cautions and warnings may result in loss of steering.

Service seal kits include service parts for more than one type of construction. Select the service kit parts required for the unit being serviced by comparing them with those being replaced.

Service seal kits include grease pack 406015 and all item numbers shown on this bulletin.

Use the Ball Return Guide Strap (32) as a direct replacement for the alternate "clip". Use the Torx screws included in the kit to secure the new strap. Discard the old clip and bolts.

The new side cover gasket (45) is a direct replacement for the older "alternate" design, even though it may look slightly different.



Item	Description	Part Number (by kit)		
		TAS400003	TAS550003	TAS650009
2	Dirt & Water Seal	478044	478044	478044
3	Retaining Ring	401637	401637	401637
4	Seal (Input Shaft)	478076	478076	478076
6	Seal Ring (Valve Housing)	032829	032829	032616
7	Seal Ring (Valve Housing)	032823	032823	032823
8	Seal Ring (2)	029123	029123	029123
9	O-ring (2)	032200158	032200158	032200158
10	Seal Ring	029116	029116	029116
11	O-ring (Valve Housing)	032200152	032200152	032200152
18	Adjuster locknut	027007	027007	027007
20	Teflon Seal Ring (Rack Piston)	032828	032830	032590
21	O-ring (Back up; Rack Piston)	032827	032831	032615
28	Ball Return Guides (2-Right)	400158	400160	400156
	Ball Return Guides (2-Left)	400159	400165	400157
29	Seal (Cap)	478042	478042	478042
31	Torx Screws (2-Cap)	020228	020228	020228
32	Ball Return Guide Strap	400167	400167	400167
38	Dirt Seal	478052	478041	478041
39	Dirt & Water Seal (Trunnion)	478053	478045	478045
41	Seal (2-Output)	478051	478040	478040
45	Gasket (Side Cover)	HFB529000	HFB649000	HFB649000
49	Vent Plug (Side Cover)	036201	036201	036201
55	O-ring (2-Aux. Port Plug)	032229	032229	032229
57	O-ring (Relief Valve)	032200153	032200153	032200153

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