

TRW Automotive  
Steering & Suspension Systems

## Service Bulletin #TAS-110

### Illustration for Service Seal Kit TAS650010

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.

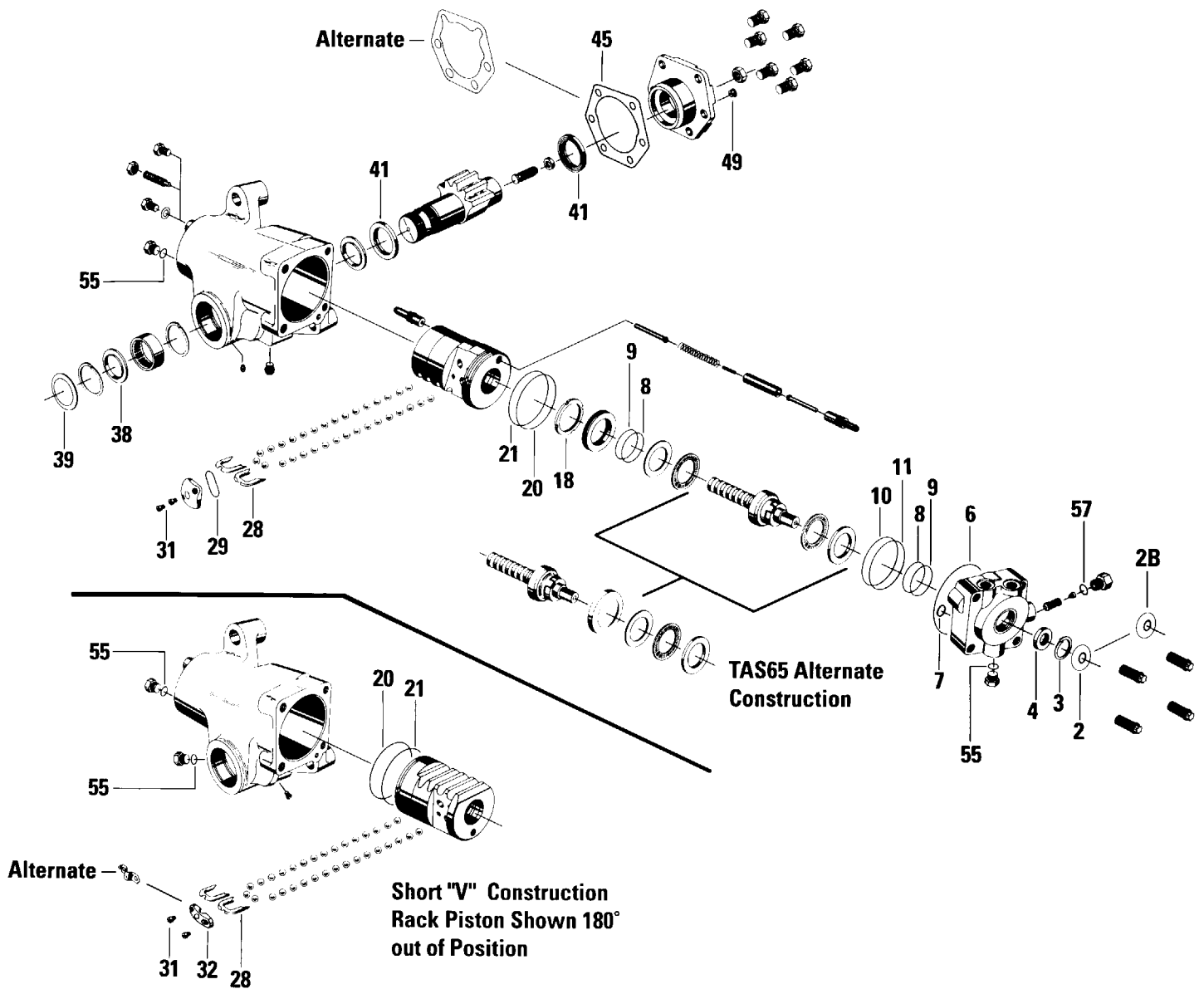
Use the Ball Return Guide Strap (32) as a direct replacement for the alternate "clip". Use the Torx screws included in the kit to secure the new strap. Discard the old clip and bolts.

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

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

\* Item 2 (Dirt & Water Seal with .687" I.D.) is for TAS units with 13/16" input serrations (P/N 478044)

\* Item 2B (Dirt & Water seal with .852" I.D.) is for TAS units with 1" input serrations (P/N 478050)



Item	Description	Part Number	Item	Description	Part Number
2	Dirt & Water Seal (13/16" serr)*	478044	21	O-ring (Back up; Rack Piston)	032615
2B	Dirt & Water Seal (1" serr)*	478050	28	Ball Return Guides (2-Right)	400156
3	Retaining Ring	401637		Ball Return Guides (2-Left)	400157
4	Seal (Input Shaft)	478076	29	Seal (Cap)	478042
6	Seal Ring (Valve Housing)	032616	31	Torx Screws (2-Cap/Strap)	020228
7	Seal Ring (Valve Housing)	032823	32	Ball Return Guide Strap	400167
8	Seal Ring (2)	029123	38	Dirt Seal	478041
9	O-ring (2)	032200158	39	Dirt & Water Seal (Trunnion)	478045
10	Seal Ring	029116	41	Seal (2-Output)	478040
11	O-ring (Valve Housing)	032200152	45	Gasket (Side Cover)	HFB649000
18	Adjuster locknut	027007	49	Vent Plug (Side Cover)	036201
20	Teflon Seal Ring (Rack Piston)	032590	55	O-ring (2-Aux. Port Plug)	032229
			57	O-ring (Relief Valve)	032200153

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