

TRW Automotive
Commercial Steering Systems

Service Bulletin #TAS-119

Illustration for Service Seal Kits TAS400004, TAS550004 and TAS650012

January 2010

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.

⚠ 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.

⚠ CAUTION

When installing seals, be sure to use the correct seal installation tool. Damage to the seal or improper installation will result if proper tool is not used during installation.

⚠ 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 a grease pack (406038) and all item numbers shown on the exploded view in this service bulletin.

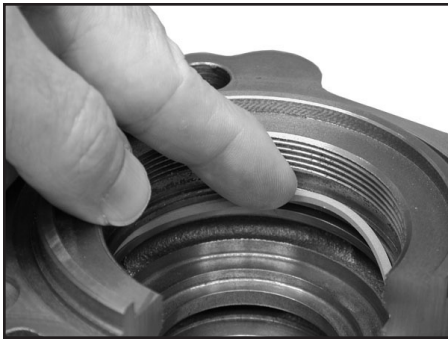
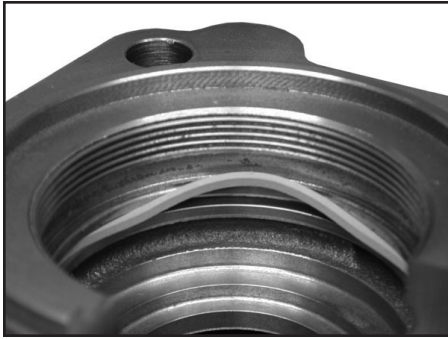
Use the Ball Return Guide Strap (30) as a direct replacement for the alternate "clip". Use the Torx screws included in the kit to secure the new strap. Discard the old clip and bolts.

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

The dirt and water seal (Item 2) with .687" I.D. is for TAS units with 13/16" input serrations (P/N 478044). The dirt and water seal with .852" I.D. is for TAS units with 1" input serrations (P/N 478050).

Be sure to use the installation method for the green valve housing seal ring (Item 15) outlined on the next page. Failure to install this part correctly will require an entire new kit.

Valve Housing Seal Ring Installation



1. Insert seal ring into groove as shown, being careful not to "butterfly" the seal towards the inner diameter of the housing bore.

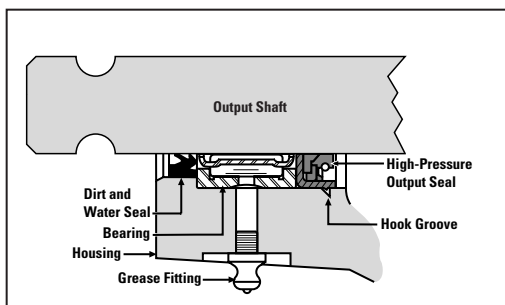
⚠ CAUTION

Be sure not to "butterfly" this seal ring during installation. This will deform the part and cause it to be damaged during the installation process.

2. Gently pull the seal in towards the inner diameter of the housing bore while working the seal down to seat it into the valve housing groove.

3. The seal ring, when installed correctly, will be seated fully into the housing groove with only a slight protrusion into the valve housing inner diameter.

Section View of Various Output Shaft Seal Installations

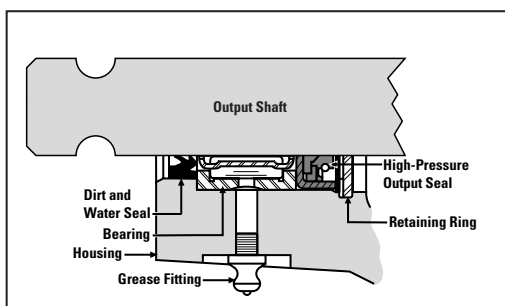


Step Bore w/ Hook Groove

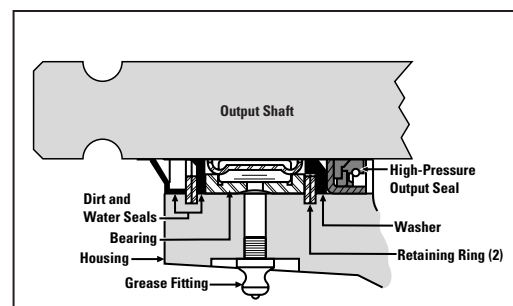
These cross sections of the output shaft seal area show the differences between the various design revisions of the steering gear assembly. The current production procedure is to machine a hook groove in the housing to keep the output shaft seal in place. (See exploded views.)

NOTE

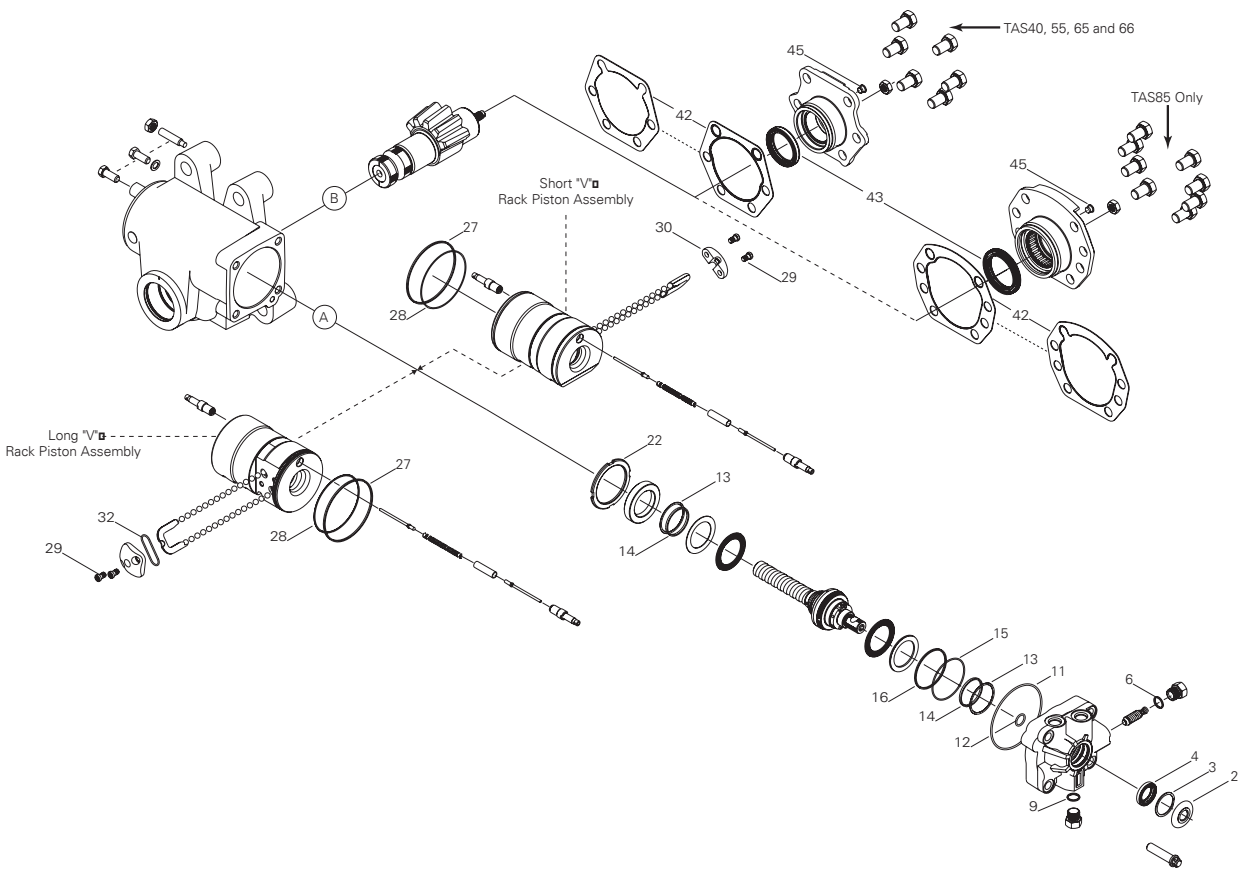
Grease the trunnion bearing with a hand grease gun only. Automatic grease guns may blow out the output shaft seal.



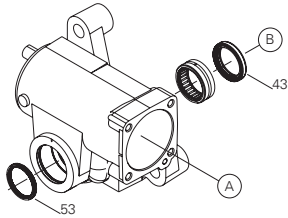
Step Bore w/ Retaining Ring



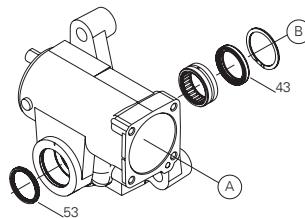
Standard



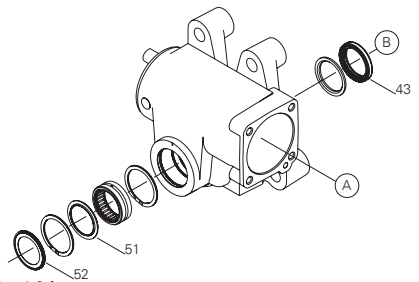
Step Bore w/ Hook Groove



Step Bore w/ Retaining Ring



Standard



Item Description

Part Number (by kit)

	TAS400004	TAS550004	TAS650012
2 Seal, Input Shaft Dirt & Water 13/16" Serr. 1" Serr.	478044	478044	478044
3 Ring, Retaining	401637	401637	401637
4 Seal, Input Shaft	478076	478076	478076
6 O-Ring, Relief Valve	032200153	032200153	032200153
9 O-Ring, Auxiliary Port Plug	032229	032229	032229
11 Seal Ring, Valve Housing	032873	032873	032875
12 Seal Ring, Valve Housing	032874	032874	032874
13 Seal Ring	029123	029123	029123
14 O-Ring	032200158	032200158	032200158
15 Seal Ring	029135	029135	029135
16 O-Ring, Valve Housing	032862	032862	032862
22 Locknut, Adjuster	027007	027007	027007
27 Teflon Seal Ring, Rack Piston	032828	032830	032590
28 O-ring (Back up), Rack Piston	032827	032831	032615
29 Screws, Torx	020228	020228	020228
30 Strap, Ball Return Guide	400167	400167	400167
32 Seal, Cap	478042	478042	478042
42 Gasket, Side Cover	HFB529000	HFB649000	HFB649000
43 Seal, Output	478119	478040	478040
45 Vent Plug, Side Cover	036201	036201	036201
51 Seal, Dirt	478052	478041	478041
52 Seal, Trunnion Dirt & Water	478053	478045	478045
53 Seal, Trunnion Dirt & Water	478098	478095	478095

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