

## Service Procedure #TAS-120

### Illustration for Service Seal Kit TAS000002

Revised March 2009

This kit will service both TAS55 and TAS65 steering gears.

*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**

**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.**

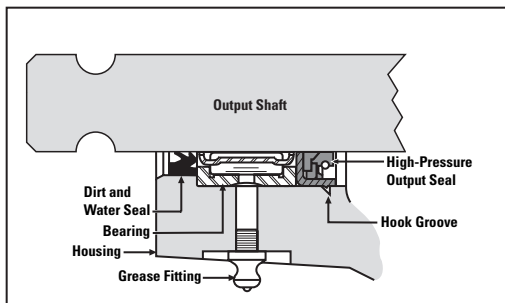
Service seal kits include service parts for more than one type of construction. Select the service kit parts required for the unit being serviced by comparing them with those being replaced.

#### **⚠ 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.**

Service seal kits include a grease pack (406038) and all item numbers shown on the exploded view in this service procedure.

### Section View of Various Output Shaft Seal Installations

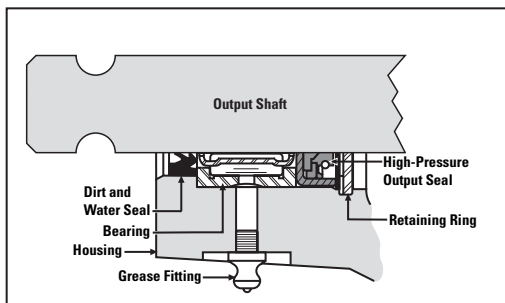


**Step Bore w/ Hook Groove**

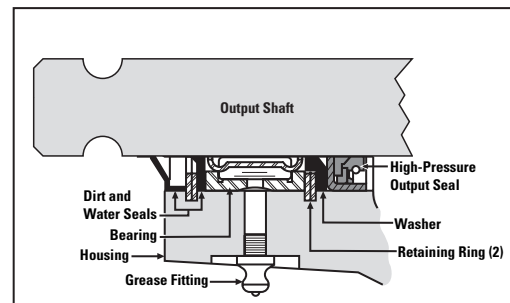
These cross sections of the output shaft seal area show the differences between the various design revisions of the steering gear assembly. The current production procedure is to machine a hook groove in the housing to keep the output shaft seal in place. (See exploded views.)

#### **NOTE**

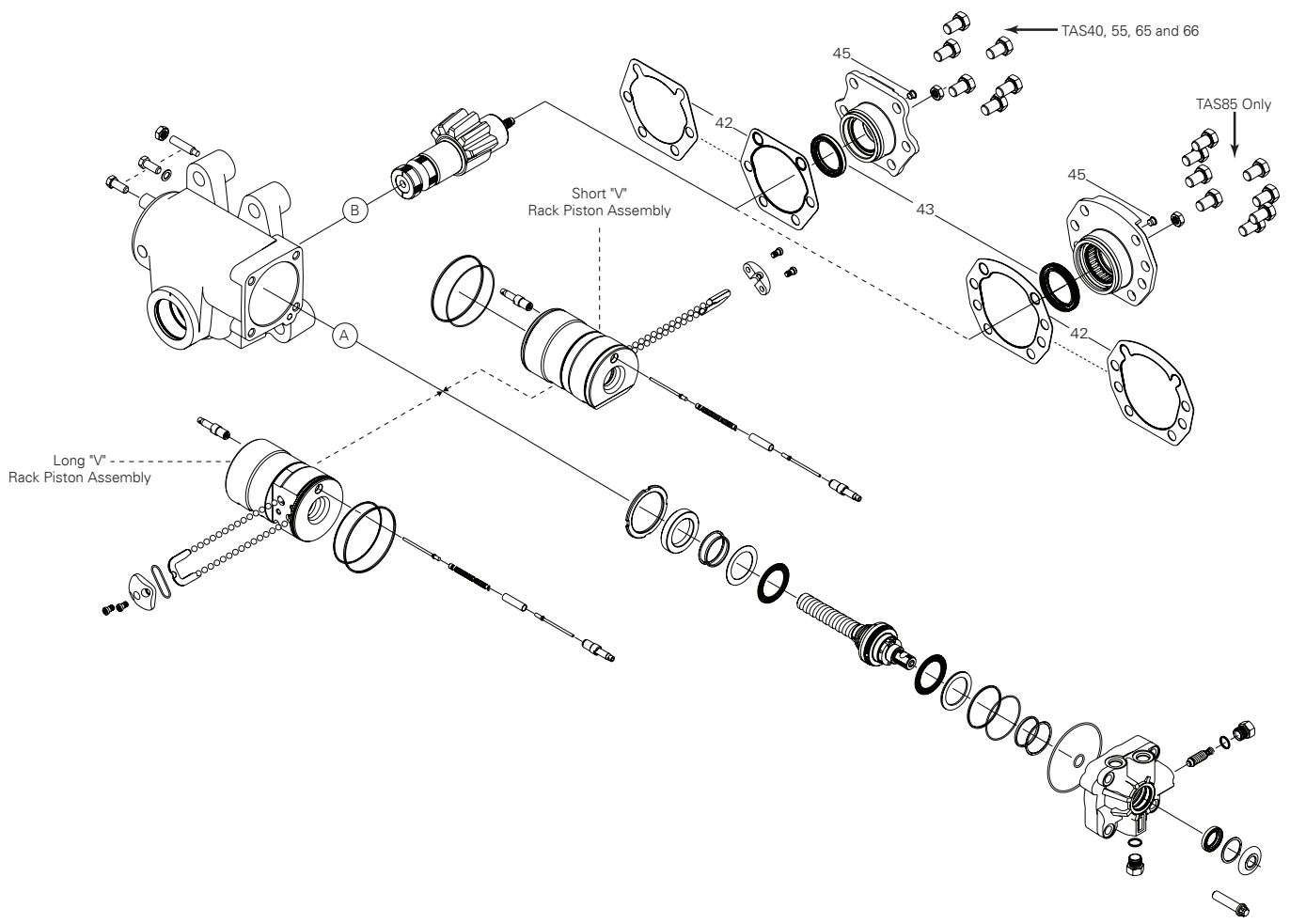
**Grease the trunion bearing with a hand grease gun only. Automatic grease guns may blow out the output shaft seal.**



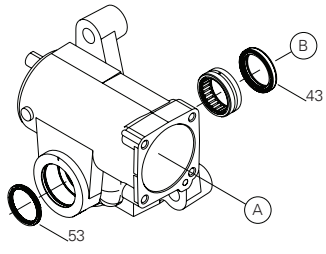
**Step Bore w/ Retaining Ring**



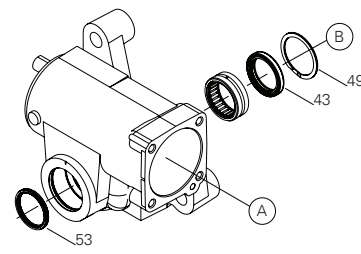
**Standard**



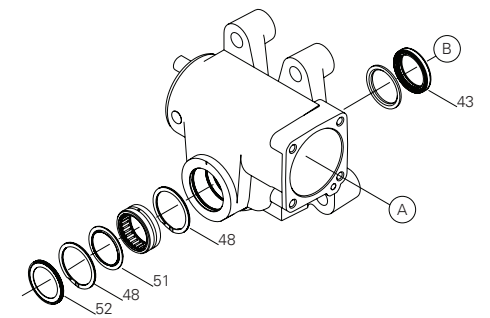
Step Bore w/ Hook Groove



Step Bore w/ Retaining Ring



Standard



Item	Description	Part Number
42	Gasket, Side Cover .....	HFB649000
43	Seal, Output .....	478040
45	Vent Plug, Side Cover .....	036201
48	Ring, Retaining .....	401650
49	Ring, Retaining.....	401724

Item	Description	Part Number
51	Seal, Dirt .....	478041
52	Seal, Dirt & Water (Standard).....	478045
53	Seal, Dirt & Water (Step Bore).....	478095

**TRW Commercial Steering Systems**  
P.O. Box 60  
Lafayette, IN 47902  
Phone: 765.423.5377  
Fax: 765.429.1868

