

20. Install distributor plate. See Figure 56. Be sure to properly align plate holes with holes in middle plate.



**Figure 56**

21. Install shaft into bore of housing. See Figure 57. Position slot in shaft to engage cross pin.



**Figure 57**

22. Position rotor so that cross pin is between two teeth as shown by position of screwdriver. See Figure 58.



**Figure 58**

23. Lubricate two O-rings with 20 Weight mineral oil and install them in grooves of cylinder gear. Slide cylinder gear into position on housing. See Figure 59.



Figure 59

4983A

24. Use a bolt to align holes in cylinder gear with bolt holes in housing. See Figure 60.



Figure 60

4984A

25. Install spacer bushing. See Figure 61. Remove bolt that was installed in previous step (If equipped.).

**NOTE:** *Refer to parts manual for our unit to determine if these parts are installed.*



Figure 61

4985A

26. Use a screwdriver to install the spacers (If equipped.). See Figure 62.

**NOTE:** *Refer to parts manual for our unit to determine if these parts are installed.*



Figure 62

27. Install end cover. See Figure 63.



Figure 63

28. Install a washer and roll pin into hole shown in Figure 64.



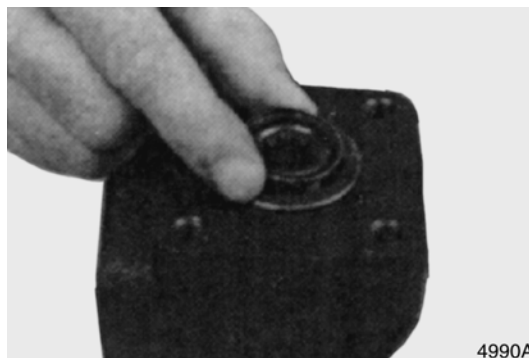
Figure 64

29. Install six remaining bolts and tighten them. See Figure 65. Cross tighten bolts and roll pin to 48.1 N•m (35 ft lbs).



Figure 65

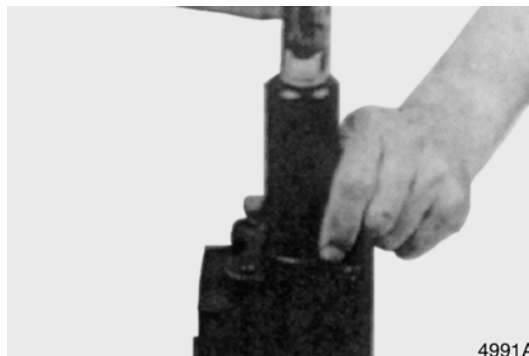
30. Turn steering unit over and work from opposite side. Set dust seal in position on housing. See Figure 66.



**Figure 66**

4990A

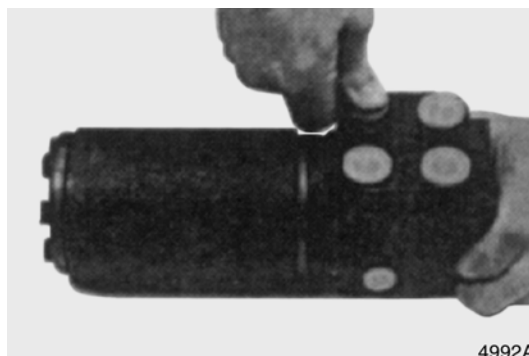
31. Use a seal driver and a plastic hammer to install dust seal. See Figure 67.



**Figure 67**

4991A

32. Install plastic plugs to prevent dirt from entering steering unit. See Figure 68.



**Figure 68**

4992A

33. Figure 69, shows port identification for steering unit.

L = Left pressure port.

R = Right pressure port

T = Tank port

P = Pressure from pump.

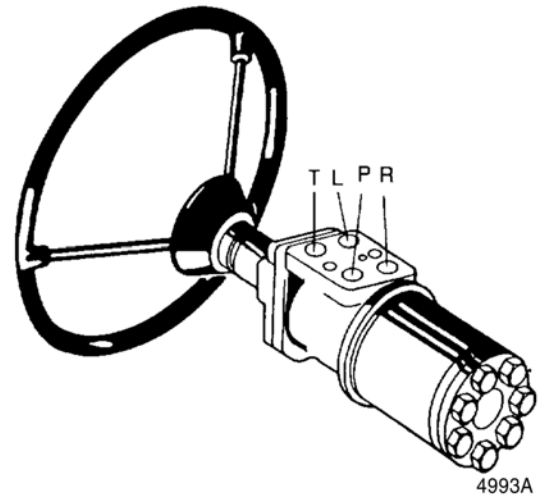


Figure 69

## INSTALLATION

The following table shows torque specifications for hydraulic fittings used to install steering unit.

Type of Screw Fitting	Maximum Tightening Torque kg•m (ft lb)		
	1/4 RG 1/4 BSP.F R 1/4 G 1/4	1/2 RG 1/2 BSP.F R 1/2 G 1/2	7/16-20UNF
Cutting Edge	4 (29)	10 (72)	
Copper Washer	2 (15)	3 (22)	
Aluminum Washer	3 (22)	8 (58)	
O-ring			2 (15)