

# GROUP 23

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This group is structurally similar to that of the vehicle **6TV623** and consequently the disassembly and reassembly procedures remain the same.

# SERVICE DATA AND SPECIFICATIONS

## GENERAL SPECIFICATIONS

### FLUIDS AND LUBRICANTS

Description	Type	Recommended product	Quantity
Needle roller bushing housings (on steering column support)	GREASE	SPCA: Spagroph ISECO: Ergon Rubber Grease n. 3 REINACH Sferul B2 AR Part. no. 3671-69816	
Steering column support lower bearing	GREASE	AGIP: Grease 33 FD IP: Autogrease FD SHELL Retinax AX ESSO Norva 275 Part. no. 3671-69833	90 g (3.17 oz.)
Mating surfaces of steering wheel adjustment guides on column Steering column and sliding sleeve spline	GREASE	ISECO: Molykote Paste G Part. no. 3671-69840	
ZF steering rack	OIL	Calypsol Part no. 3671-69838	
Power steering fluid	OIL	AGIP: ATF DEXRON II 11297 IP: DEXRON FLUID II 11297 SHELL: DEXRON II 10709-D 20137 Part. no. 3631-69527	1.76 lb (0.8 kg)

## CHECKS AND ADJUSTMENTS

### POWER STEERING

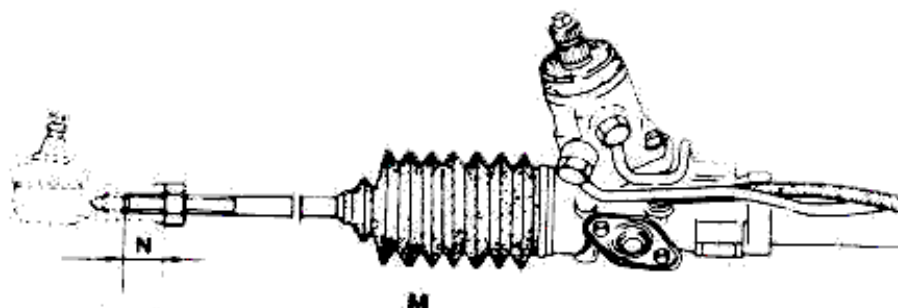
#### Steering installation dimension

LHD M = 399.5 mm (15.73 in)

RHD M = 394 mm (15.51 in)

#### Tie rod ball joint installation dimension

N = 26 mm (1.02 in)



### HYDRAULIC POWER STEERING SYSTEM FILLING

1. Before starting engine, fill the tank with recommended oil to the limit.
2. On the pump, loosen the feeding pipe fitting (this pipe leads the oil from the reservoir to the pump) until a little oil flows out and all air is bled.
3. Lock the fitting to the specified torque.
4. Start the engine and feed the tank until level settles.
5. With the engine running, carry out a few full steering locks to right and left, then top up the oil in the tank to the "Max" mark.
6. Reassemble the tank plug.

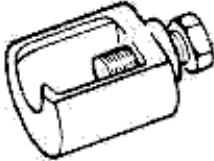

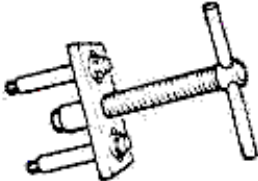
# STEERING

## TIGHTENING TORQUES

Description	Measurement unit	N·m (ft·lb; kg·m)
Capscrews, steering unit to crossmember		26 to 29 (19.2 to 21.4; 2.7 to 3)
Locknut, ball joint on tie rod		54 to 88 (39.8 to 64.9; 5.5 to 9)
Nut, tie rod ball joint		44 to 54 (32.5 to 39.8; 4.5 to 5.5)
Bolt, intermediate shaft/pinion shaft U-joint (Tighten further to permit cotter pin insertion)		15 (11.1; 1.5)
Bolt, steering column to lower support on body		4.9 to 7.35 (3.6 to 5.4; 0.5 to 0.75)
Nut, steering column to upper support on body (steering wheel lever locked)		21 to 26 (15.5 to 19.2; 2.1 to 2.6)
Nut, steering column intermediate shaft sliding sleeve (nut must be tightened to obtain specified sliding load on spline)		34 to 44 (7.6 to 9.9; 3.5 to 4.6) (1)
Nut, steering wheel on steering column		16.7 to 20.6 (12.3 to 15.2; 1.7 to 2.1)
Tie rod on rack		63 to 77 (46.5 to 56.8; 6.4 to 7.8)
Oil delivery pipe on power steering pump fitting		28 to 31 (20.7 to 22.9; 2.9 to 3.2)
Oil return pipe adapter on power steering pump fitting		45 to 50 (33.2 to 36.9; 4.6 to 5.1)
Oil delivery pipe adapter on control valve fitting		22 to 24 (16.2 to 17.7; 2.2 to 2.4)
Oil return pipe adapter on control valve fitting		38 to 43 (28 to 31.7; 3.9 to 4.4)
Oil pipe fittings on steering unit		20 (14.8; 2)

(1): N (lb; kg)

**SPECIAL SERVICE TOOLS**

Part No.	Description	Page ref.
A.3.0156	Puller steering lever ball joint 	-
A.3.0346	Installer, column, and steering unit bushings 	-
A.3.0451	Puller, steering wheel 	-