

vanes. See inset X—Fig. 9. Position lobe of rotor in valley of stator as shown at (V—Fig. 10). Center opposite lobe on crown of stator, then using two feeler gages, measure clearance (C) between rotor lobes and stator. If clearance is more than 0.006 inch, renew stator-rotor assembly. Using a micrometer, measure thickness of stator and rotor. If stator is 0.002 inch or more thicker than rotor, renew the assembly. Stator, rotor, vanes and vane springs are available only as an assembly.

Before reassembling, wash all parts in clean solvent and air dry. All parts, unless otherwise indicated, are installed dry. Install recirculating ball (26—Fig. 9) and plug (28) with new "O" ring (27) in valve body and tighten plug to a torque of 10-14 ft.-lbs. Clamp fitting (installed in valve body port) in a vise so that top end of valve body is facing upward. Install thrust washer (14), thrust bearing (15), second thrust washer (14) and snap ring (13) on input shaft (17). If actuator ball retaining ring (34) was removed, install new retaining ring. Place actuator ball (23) in its seat inside valve spool (22). Insert input shaft into valve spool, engaging the helix and actuator ball with a counter-clockwise motion. Use the mid-section of torsion bar (21) as a gage between end of valve spool and thrust washer, then place the assembly in a vertical position with end of input shaft resting on a bench. Insert drive ring (19) into valve spool until drive ring is engaged on input shaft spline. Remove torsion bar gage. Install spacer (20) on torsion bar and insert the assembly into valve spool. Align crossholes in torsion bar and input shaft and install pin (18). Pin must be pressed into shaft until end of pin is about 1/32-inch below flush. Place spacer (16) over spool and install spool assembly into valve body. Position original shims (12) on thrust washer (14). Lubricate new seal ring (10), place seal ring in upper cover (9) and install upper cover assembly. Align the match marks on cover flange and valve body and install cap screws finger tight. Tighten a worm drive type hose clamp around cover flange and valve body to align the outer diameters, then tighten cap screws to a torque of 18-22 ft.-lbs.

NOTE: If either input shaft (17) or upper cover (9) or both have been renewed, the following procedure for shimming must be used. With upper cover installed (with original shims) as outlined above, invert unit in vise so that input shaft is pointing downward. Grasp input shaft, pull downward and prevent it from rotating. Engage drive link (30) splines in valve spool and ro-

tate drive link until end of spool is flush with end of valve body. Remove drive link and check alignment of drive link slot to torsion bar pin. Install drive link until its slot engages torsion bar pin. Check relationship of spool end to body end. If end of spool is within 0.0025 inch of being flush with end of body, no additional shimming is required. If not within 0.0025 inch of being flush, remove cover and add or remove shims (12) as necessary. Reinstall cover and recheck spool to valve body position.

With drive link installed, place spacer plate (29) on valve body with plain side up. Install stator-rotor set over drive link splines and align cap screw holes. Make certain vanes and vane springs are properly installed. Install manifold (32) with circular slotted side up and align cap screw holes with stator, spacer and valve body. Install commutator ring (33) with slotted side up, then install commutator (34) over drive link and making certain that link end is engaged in the smallest elongated hole in commutator. Install seal (36) and retainer (35). Apply a few drops of hydraulic fluid on commutator. Use a small amount of grease to stick washer (37) in position over pin on end cover (38). Install end cover making sure that pin engages center hole in commutator. Align holes and install cap screws (39). Alternately and progressively tighten cap screws while rotat-

ing input shaft. Final tightening should be 18-22 ft.-lbs. torque.

Relocate the unit in vise so input shaft is up. Lubricate new seal (8) and carefully work seal over shaft and into bore with lip toward inside. Install new Teflon washer (7), brass washer (6) and stepped washer (5) with flat side up. Install snap ring (4) with rounded edge inward. Place new felt seal (3) and water and dirt seal (2) over input shaft.

Remove unit from vise and remove fitting from port. Turn unit on its side with hose ports upward. Pour clean hydraulic fluid into inlet port, rotate input shaft until fluid appears at outlet port, then plug all ports.

Models 484-584

16. REMOVE AND REINSTALL. To remove steering control valve, remove access panel from top of hood, lower side panels from instrument panel, battery and battery tray. Remove steering wheel cap and nut. Using a suitable puller, remove steering wheel. Identify and disconnect the four hydraulic lines from steering valve. Immediately plug or cap all openings to prevent dirt or other foreign material from entering system. Working through opening in instrument panel along side of steering column, remove steering valve mounting bolts and remove the assembly.

Reinstall by reversing the removal procedure, then bleed air from system as outlined in paragraph 5.

17. OVERHAUL. Clean exterior of unit and scribe match marks on end plate, rotor plate, distributor plate and valve housing as shown in Fig. 11. Unbolt and remove steering column and shaft (3) from steering valve. Clamp valve housing in a soft jaw vise in inverted position and remove end plate cap screws (25 and 26—Fig. 12).

NOTE: One cap screw (25) has a roll pin in the end to restrain the check ball (10).

Remove end plate (34), wear washer (17), rotor plate (21) and rotor (22). Remove distributor plate (19) and drive shaft (16), then remove check ball retaining threaded bushing (9) from valve housing and remove check ball (10). Push valve spool assembly from valve housing. Remove axial washer (5), needle (thrust) bearing (6), bearing race (7) and retaining ring (8) from end of spool. Remove cross pin (11) from spool, then slide spool (12) from valve sleeve (15). Remove inner and outer plate springs (13 and 14) from spool. Remove sealing ring (4), "O" ring (3) and oil seal (1) from housing (2).

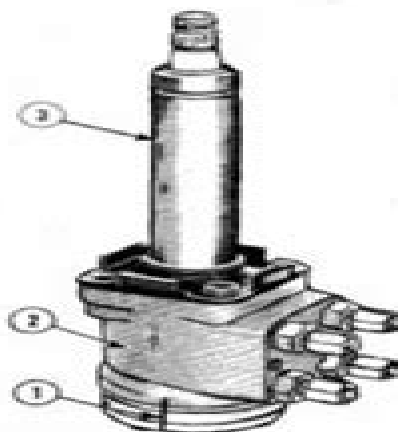


Fig. 11—View of steering valve (hand pump) removed from Model 484 or 584.

1. Match marks
2. Valve housing
3. Steering column & shaft assy.

584 Ih Repair Manual

Kathleen Armour



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