

## Steering Column: Service and Repair Assembly

1. To assemble bearing housing, proceed as follows:
  - a. Using a suitable socket, press bearings into bearing housing.
  - b. Install lock shoe springs, lock shoes and shoe pin into bearing housing.
  - c. Install shoe release lever, spring and pin.
  - d. Install sector drive shaft and snap ring into housing.
  - e. Install lock bolt and engage bolt with sector cam.
  - f. Install rack and spring. Block tooth on rack should engage block tooth on sector.
  - g. Install tilt release lever.
  - h. Install lock bolt spring and retaining bolt. Torque bolt to 35 inch lbs.
2. On C, G and K models, install shift lever spring into housing.
3. On Caballero and El Camino models, install shift lever spring into shift bowl.
4. Install bearing support lock plate and wave washer.
5. On C, G and K models, carefully install shift tube into lower end of steering column jacket. Install wobble plate end of tool J-23073 into upper end of shift tube. Install adapter over end of tube, seating it against the lock plate. Place nut onto threaded portion of tool and pull shift tube into housing. Remove tool.
6. On Caballero and El Camino models, install bearing support thrust washer and retaining ring. Carefully install shift tube into lower portion of steering column jacket. Align shift tube key with shift bowl keyway. Using tool J-23073, pull shift tube into the shift bowl. Install thrust washer and retaining ring. Install actuator rod through support hole between shift bowl and steering column jacket.
7. Install bearing support. Align bearing support ``V" with ``V" on steering column jacket. Install attaching bolts through support and into lock plate. Torque attaching bolts to 60 inch lbs.
8. Align lower bearing adapter or bushing with notches in steering column jacket. Install lower bearing, bearing reinforcement and retaining clips. Ensure clips align with reinforcement slots on steering column jacket and adapter assembly.
9. Install centering spheres and anti-lash spring onto upper shaft. Install lower steering shaft assembly.
10. On C, G and K models, install steering shaft assembly into shift tube. Install ignition switch actuator rod through shift lever housing.
11. On Caballero and El Camino models, position shift bowl into Park (counterclockwise to stop). Install ignition switch actuator rod between shift bowl and steering column jacket.
12. Assemble bearing housing over steering shaft and engage rack over actuator rod end.
13. On Caballero and El Camino models, position access hole of bearing housing over dimmer switch actuator rod end.
14. While holding the locking shoes in the disengaged position, install bearing housing over steering shaft until pivot pin holes align with holes in support assembly.
15. Install pivot pins.
16. Place bearing housing in the full up (tilt) position. Install tilt lever spring guide, spring and spring retainer.
17. On C, G and K models, proceed as follows:
  - a. Install upper bearing inner race and race seat.
  - b. Install tilt lever opening shield.
  - c. Remove tilt release lever, then install turn signal housing. Torque housing attaching screws to 45 inch lbs.
  - d. Install tilt release lever, shift lever and lever retaining pin.
  - e. Install lock cylinder, turn signal switch and ignition switch assembly.
  - f. Install intermediate shaft onto upper shaft assembly. Tighten clamp bolt nut. **While tightening the clamp bolt nut, the clamp bolt must be drawn through the shaft assembly under cut.**
  - g. Install neutral safety or back-up light switch. Connect electrical connectors onto neutral safety or back-up light switch.
  - h. Install dash panel to steering column attaching bolts. Torque bolts to 30 ft. lbs.
18. On Caballero and El Camino models, proceed as follows:
  - a. Install tilt lever opening shield into cover.
  - b. Remove tilt release lever.
  - c. Install housing cover. Torque housing cover screws to 45 inch lbs.
  - d. Install buzzer switch onto spring clip retainer. Push switch and clip assembly into cover hole until switch ``snaps" into lock cylinder bore.
  - e. Install turn signal switch wires and electrical connector through column cover, bearing housing and shift bowl assembly.
  - f. Install actuator ball arm into pivot slot.
  - g. Install hazard warning knob, bearing inner race, race seat, bearing preload spring, canceling cam and lock plate.
  - h. Using a suitable tool, depress lock plate and install snap ring. Ensure snap ring completely seats into groove.
  - i. Install tilt release lever and turn signal switch lever.
  - j. Install upper shift lever and lever retaining pin.
  - k. Install lock cylinder, shaft lock cover and ignition switch. Connect electrical connector onto ignition switch.
  - l. Install dash panel to steering column attaching bolts. Torque attaching bolts to 30 ft. lbs.