

# Steering Gears & Linkage

## TOYOTA (EXC. LAND CRUISER) RECIRCULATING BALL

Celica  
Corona  
Corolla  
Hi-Lux Pickup

**NOTE** — Corona Mark II uses only power steering gear. See Toyota Corona Mark II Power Steering under STEERING GEARS & LINKAGE in this section.

### DESCRIPTION

#### STEERING GEAR

Steering gear is of recirculating ball type with a variable gear ratio. Several loose ball bearings circulate in two divided sections within grooves of worm and nut. Turning motion of worm moves ball nut axially on shaft, thereby turning the sector shaft and pitman arm.

#### STEERING LINKAGE

Linkage consists of idler arm, center relay rod, two adjustable tie rods, and two steering knuckles. The connection between each component is through ball joints. The linkage assembly is joined to the steering gear at the pitman arm.

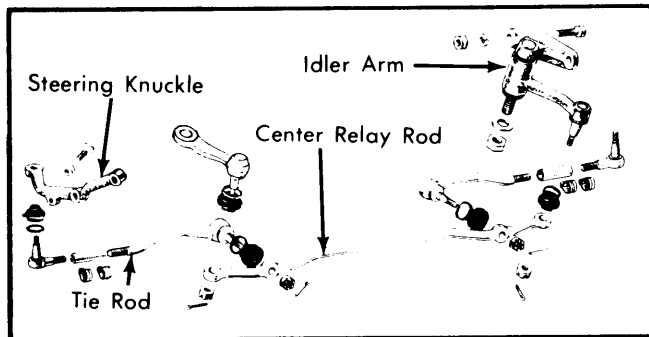


Fig. 1 Toyota Steering Linkage with Bushings and Retainers (Typical Illustration)

### ADJUSTMENT

See Overhaul procedures in this article.

### REMOVAL & INSTALLATION

#### STEERING GEAR

**Removal (Exc. Corona)** — Remove bolt attaching coupling yoke-to-worm shaft. Using a suitable puller (09610-20011, Celica & Corolla or 09628-62010, Hi-Lux), detach pitman arm from sector shaft. Unbolt gear housing from frame and remove from vehicle.

**Removal (Corona)** — Remove air cleaner for access, then remove coupling pinch bolt and two rubber disc through bolts (as viewed from pinch bolt side, the two bolts which have nuts directly against the rubber disc). Using a suitable puller (09611-20014), disconnect pitman arm from center relay rod. Unbolt gear from frame and remove from vehicle.

**Installation (All Models)** — Reverse removal procedure, aligning worm shaft cut portion with flexible coupling yoke.

#### STEERING LINKAGE

**Removal** — Using a suitable puller (09628-62010, Hi-Lux, or 09610-20011, Celica, Corolla & Corona), disconnect pitman arm from sector shaft. Remove idler arm support from frame. Detach tie rod ends from steering knuckles, using a suitable puller (09611-20014, Hi-Lux, Corolla & Corona, or 09611-20013, Celica). Remove steering linkage assembly from vehicle.

**Installation** — Connect tie ends to steering knuckles and torque retaining nuts to specification. Install pitman to sector shaft (ensure correct positioning of aligning marks as illustrated). Tighten nut to specified torque. Place idler arm support on frame and tighten retaining bolts to specification. Adjust toe-in.

### OVERHAUL

#### STEERING GEAR

**Disassembly** — On Corona, use a suitable puller (09610-20011) to remove pitman arm from sector shaft. On all models, loosen sector shaft adjusting screw lock nut. Remove bolts attaching end coverplate, then remove plate and sector shaft. Drain oil from housing. Unscrew worm bearing adjusting screw lock nut, using a suitable wrench (09617-22020). Remove worm bearing adjusting screw, using a suitable tool (09616-30011, Hi-Lux, Corolla & Corona, or 09616-22010, Celica). Extract worm assembly with bearing. **NOTE** — Do not disassemble ball nut from worm. If recirculating ball assembly has defective components, replace assembly.

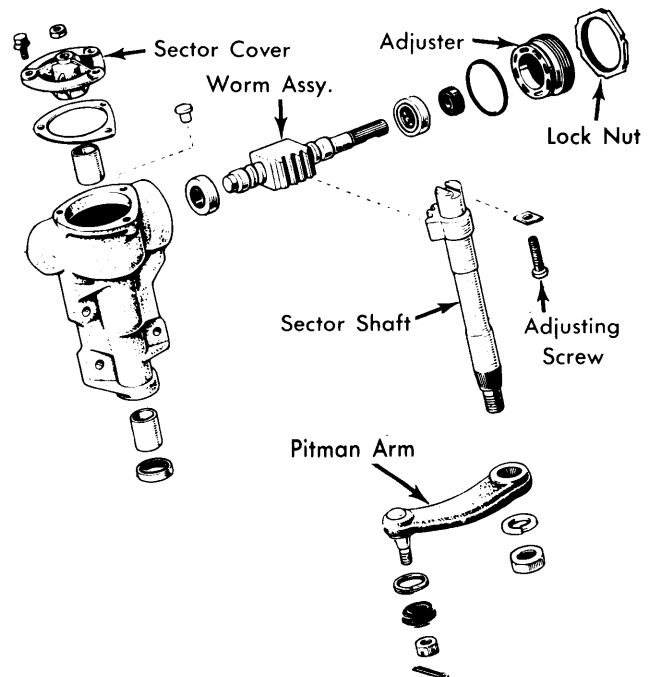


Fig. 2 Exploded View of Recirculating Ball Type Steering (Corona Shown, Others Similar)

## TOYOTA (EXC. LAND CRUISER) RECIRCULATING BALL (Cont.)

**Inspection** — Check all components for wear or damage and replace as necessary. Check sector shaft-to-bushing clearance: it must not exceed .0020" (.05 mm). If clearance is exceeded, replace bushing or shaft.

**Assembly & Adjustment** — 1) Lubricate all bearings and sliding portions of gear assembly. Install worm into gear housing, then install adjusting screw and lock nut. Check worm bearing preload: Wind a cord around worm shaft and attach a pull-scale to end of cord. Pull required to turn worm shaft should be within given specifications. Turn adjusting screw as required to bring preload within limits.

### Initial Worm Bearing Preload

Celica .....	8.2-10.3 lbs. (3.5-5 kg)
Corona & Corolla .....	8.8-13.2 lbs. (4-6 kg)
Hi-Lux .....	6.6-13.2 lbs. (3-6 kg)

2) Install adjusting screw and thrust washer onto sector shaft and measure thrust clearance (between head of adjusting screw and bottom of "T" slot). Maximum satisfactory clearance is as specified. If clearance limit is exceeded, replace thrust washer with one of suitable size, to bring clearance into limits.

### Adjusting Screw-to-Shaft Clearance

Exc. Hi-Lux .....	.002" (.05 mm)
Hi-Lux .....	.004" (.1 mm)

3) Install sector shaft to end cover and install assembly (with gasket) into gear housing. **NOTE** — Ensure ball nut is at center travel before inserting sector shaft. Loosen adjusting screw completely, prior to shaft insertion. After sector shaft cover is

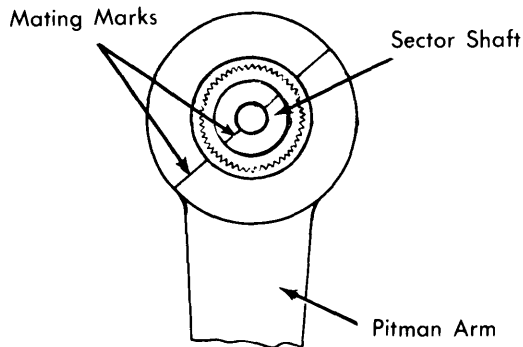


Fig. 3 Aligning Pitman Arm to Sector Shaft

bolted into place, repeat worm bearing preload test as previously described, using sector shaft adjusting screw to obtain specified preload:

### Final Worm Bearing Preload

Exc. Hi-Lux .....	17.6-24.2 lbs. (8-11 kg)
Hi-Lux .....	15.4-24.2 lbs. (7-11 kg)

4) Install pitman arm (aligning mating marks); attach a dial gauge to measure pitman arm backlash. Backlash, as measured at pitman arm outer end, should not exceed 5° from either side of center. After checking, tighten adjusting screw lock nut securely.

### TIGHTENING SPECIFICATIONS

Application	Ft. Lbs. (mkg)
<b>Steering Gear-to-Frame</b>	
Corona .....	36-50 (5.0-6.9)
All Others .....	25-36 (3.5-5.0)
<b>Pitman Arm-to-Sector Shaft</b>	
Celica & Corolla .....	72-101 (9.9-14.0)
Corona .....	80-101 (11.0-14.0)
Hi-Lux .....	79-90 (10.9-12.4)
<b>Worm Adjusting Screw Lock Nut</b>	
All Models Exc. Corolla .....	58-72 (8.0-9.9)
Corolla .....	72-87 (9.9-12.0)
<b>Sector Shaft End Cover</b>	
All Models .....	11-16 (1.5-2.2)
<b>Sector Adjusting Screw Lock Nut</b>	
Celica .....	18-24 (2.5-3.3)
Corona & Corolla .....	14-22 (1.9-3.1)
Hi-Lux .....	14-22 (1.9-3.0)
<b>Coupling Yoke-to-Worm Shaft</b>	
Corona .....	⓪
All Others .....	14-22 (1.9-3.0)
<b>Relay Rod-to-Idler Arm</b>	
Hi-Lux .....	54-80 (7.5-11.1)
All Others .....	36-51 (5.0-7.0)
<b>Tie Rod-to-Steering Knuckle</b>	
Hi-Lux .....	36-65 (5.0-9.0)
All Others .....	36-51 (5.0-7.0)

⓪ — No specific torque given; tighten until preload is obtained as indicated under Overhaul in this article.