

# Sheppard® M-Series-Style Integral Power Steering Gear

## Setting Procedure for Manual Plungers

Follow this simple manual plunger(s) setting procedure immediately after installing your steering gear to ensure maximum turning capability and reduced pressure in full right and left turns.

- Follow your shop's safety guidelines. Chock the vehicle and wear personal protective gear.
- Follow the vehicle manufacturer's installation and service information.
- Ensure the axle stops and all steering linkage are set according to the vehicle manufacturer's specifications and that the pitman arm is correctly aligned on the output shaft. To achieve proper alignment, torque the pitman arm retainer to 225 ft-lbs for the M80 Series model gear; to 350 ft-lbs for the M100 model; and to 550 ft-lbs for the M110 model steering gear.
- With the wheels chocked, the vehicle loaded and engine idling, locate the plunger and determine which plunger is used to adjust right and left turns based on the direction of the pitman arm travel.
- Turn the steering wheel to a full left turn and check the clearance. If the clearance is not 1/8", adjust the manual plunger. Begin the adjustment by returning the steer tires to a straight position. Using a screwdriver, adjust the plunger in or out depending on which direction of turn you are adjusting. Never adjust the plunger with pressure on the steering wheel as seal damage will occur.
- To set the opposite manual plunger, follow the same procedure while turning the steering wheel in the other direction. You have now positioned the manual plungers to trip and reduce pressure correctly.

For additional information or questions about this procedure, please contact your local account manager or technical support team.



These instructions are provided to help you repair commercial vehicles more efficiently. This document should not replace your Service manuals; you should use them together. These materials are intended for use by properly trained, professional mechanics, adhering to the safety instructions directed by the vehicle and component manufacturer. You should not try to diagnose or repair steering problems unless you have been trained, and have the right equipment, tools and know-how to perform the work correctly and safely.