Sheppard® M-Series-Style Integral Power Steering Gear
Setting Procedure for Automatic Plungers

Follow this simple automatic 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 unloaded and engine idling, turn the steering wheel in one direction until contact is made with the axle stop. Do not apply more than 40 lb rim pull (178 N) on a 20 in. (508 mm) diameter steering wheel during this procedure.

- Remove the wheel chocks and allow the vehicle to roll forward, or jack up the vehicle at the front axle, if you require excess rim pull effort.

- To set the opposite automatic plunger, follow the same procedure while turning the steering wheel in the other direction. You have now positioned the automatic 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.

> ### ⚠ CAUTION
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> 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.