



Sedan Range

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**SERVICE**

# TECHNICAL BULLETIN

## PAS Pump – Drive Dog Tool – Replacement Procedure

MODEL 1995 MY  
Sedan Range  
VIN  
720001-ON

### ISSUE:

A new set of required power assisted steering (PAS) tools have been introduced for the AJ16 engines. These tools permit the transfer of the drive dog from the shaft of the old PAS pump, to the shaft of a replacement pump. The tool set is as follows:

TOOL NUMBER	DESCRIPTION
JD 206	PAS Pump Drive Dog Removal Tool Set

The set consists of the following:

- Puller legs
- Spacer
- Tool center bolt

### ACTION:

#### PAS PUMP DRIVE DOG REPLACEMENT PROCEDURE

With the PAS and adapter assembly already removed from the vehicle:

1. Position the pump with the drive dog facing up.
2. Position the two puller legs JD 206/1 on the drive dog. Engage the tips of the puller legs into the notches in the lower face of the drive dog.
3. Rotate the drive dog and shaft as needed to find a position where there is maximum clearance between the drive dog and adapter casting to allow complete engagement of the puller legs behind the drive dog.

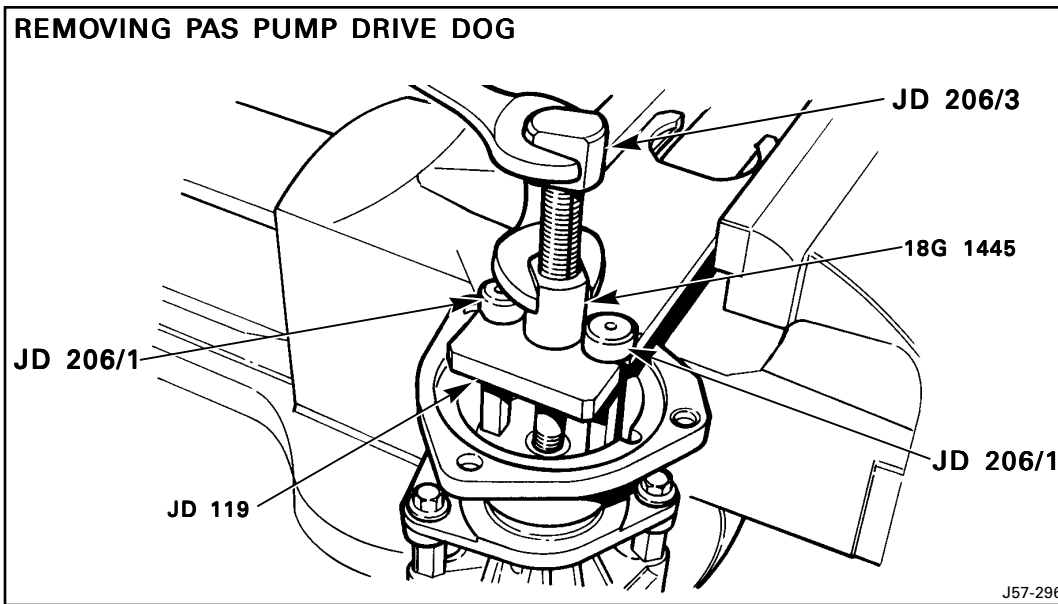


ILLUSTRATION 1

4. Install the nut of tool 18G 1445 into the plate of tool JD 119. Lubricate the lower side of the plate where the nut will press, and the locating hole for the nut.
5. Lubricate the threads of the center bolt or new special tool JD 206/3. Start the upper threads of the center bolt two or three turns into the nut of plate JD 119. Install the assembly on the drive dog and puller legs and engage the puller legs into the slots on plate JD 119.
6. **BY HAND ONLY**, engage the lower thread of the center bolt JD 206/3 into the threaded service hole in the end of the PAS pump shaft. Screw the bolt completely into the pump shaft, then loosen by 1/2 turn. Rotate the nut (from 18G 1445) as needed to take up the play below the puller legs. As the nut is tightened, make sure that the lower tips of the puller legs are properly engaged in the notches of the drive dog and that the upper ends are properly located in the plate.
7. Position the end of the plate JD 119 in a vise as shown in Illustration 1.
8. Hold the center bolt using a wrench, and turn the nut counterclockwise to pull the drive dog from the pump shaft.
9. Disassemble the tools.
10. Remove the adapter from the old PAS pump and install it on the new PAS pump.

**NOTE:** Make sure that the drain hole in the adapter is approximately in line with the outlet port of the pump.

Install the two set screws that retain the adapter to the pump. Torque the set screws to 12.5 - 17 lb ft (17 - 23 Nm).

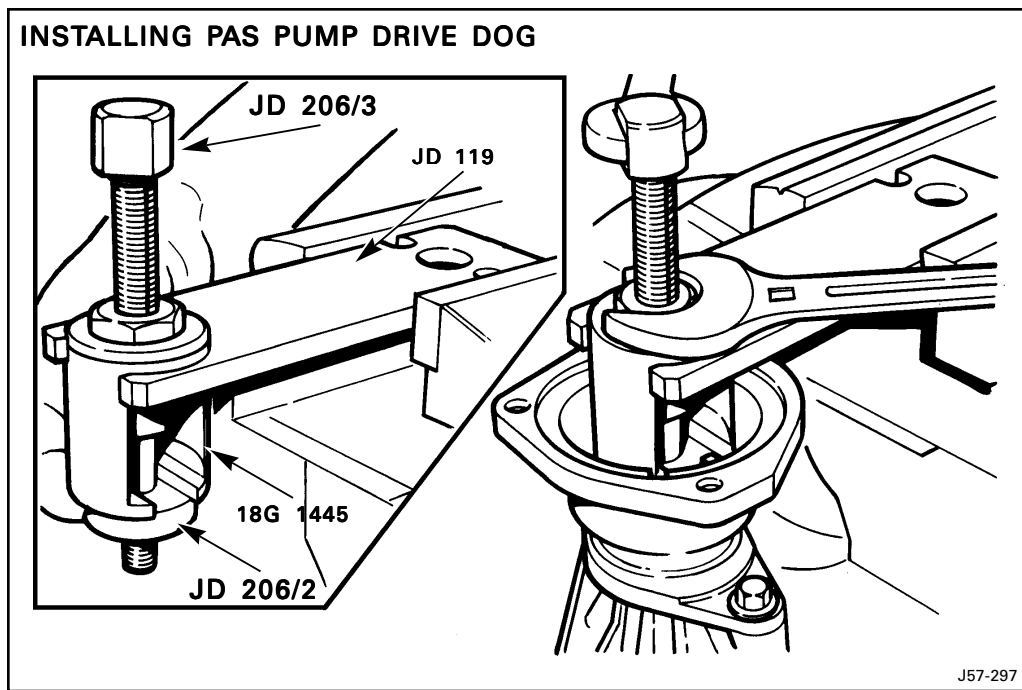


ILLUSTRATION 2

11. Lubricate the center bolt JD 206/3. Install the nut of existing tool 18G 1445 on the bolt with its flange away from the head of the center bolt. Screw the nut well on to the upper thread of the center bolt.
12. Start the drive dog on the pump shaft.
13. Place the new distance piece tool JD 206/2 with its stepped face on the drive dog along with the mandrel of existing tool 18G 1445.
14. Insert the assembled center bolt and nut through the mandrel, spacer and the drive dog. Tighten the center bolt completely into the pump shaft by hand only. Loosen the bolt by 1/2 turn.
15. Tighten the nut on the upper thread of the center bolt by hand to take up all free play.
16. Clamp the plate of JD 119 into a vise and mount the pump and tool assembly on to the plate of JD 119.
17. Use a wrench to hold the center bolt and tighten the nut to press the drive dog on to the pump shaft.  
When resistance is felt, the drive dog has been pressed on to the pump shaft the correct distance.
18. Hold the center bolt and loosen the nut.
19. Unscrew the center bolt by hand from the pump shaft.
20. Disassemble the tools.