

ASSEMBLY INSTRUCTIONS FOR HYDRAULIC STEERING PUMPS

NEVER START THE PUMP DRY - Bleed the hydraulic fluid from the system, including the steering fluid. - Do not strike the shaft or the pulley with a hammer. Use the special assembly and disassembly tools. - Avoid handling the pump by the inlet pipes or hoses. - Do not remove the protective covers until the steering system is fitted on the vehicle to ensure that no foreign matter (scrap, dirt, etc.) enters the pump. - Do not start the vehicle with the power steering hose disconnected.

I DISASSEMBLY OF THE STEERING PUMP

- Remove the belt.
- Remove the pulley according to the model:
 - Snap-on pulley on the shaft: DO NOT remove
 - Pulley fixed with screws: loosen the screws and remove the pulley.
- Place a tray under the pump to collect the oil.
- Remove the pressure hose from the power steering.

II FITTING THE STEERING PUMP

- Attach the pump to the support with the screws.
- Fit the return hose to the power steering pump reservoir and fasten it.
- Fit the power steering pressure hose and fasten. - When required, fit the power steering pressure switch in the pressure line.
- When equipped with a pulley block, fit the pulley.
- Apply the proper tension to the belt. Make sure that the belt is the same size as the original belt. Avoid fitting belts of different lengths to avoid excessive tension on the pump shaft.

III - ADDING AND BLEEDING OIL

- With the front wheels of the car raised and manually turned completely to the left and without starting the engine, add oil suitable for each type of power steering between the MAX. and MIN. mark on the oil filler cap.
- With an assistant, turn the wheels to full right and then the left lock. Repeat this 20 or 40 times, depending on whether the return lines are short or long. Keep adding oil, taking care to keep the level between the MAX and MIN marks.

- Once the steering has been bled, run the engine at idling speed check the oil level. - After a couple of minutes, put the plug in, lower the wheels and turn the steering wheel in both directions to check whether:

- The servo-assistance works without problems.

- No noises - Oil level remains correct and there are no leaks in the system.

- The oil remains in the correct condition.

- NOTE: The oil level must be between the MAX and MIN marks when it is hot.