

**STEERING—POWER RACK AND PINION—REVISED  
TORQUE REQUIREMENT FOR INSTALLING NEW  
DESIGN TIE RODS**

**Article No.  
96-1-1**

**FORD:** 1982-1995 MUSTANG, THUNDERBIRD  
1986-1995 TAURUS

**LINCOLN:** 1984-1992 MARK VII  
1988-1995 CONTINENTAL  
1993-1995 MARK VIII

**MERCURY:** 1982-1995 COUGAR  
1986-1995 SABLE

**ISSUE**

There is a revised torque specification and procedure for removing and installing new design inner tie rods for rack and pinion steered vehicles.

**ACTION**

Remove, install and torque the new design inner tie rods by referring to the following Service Procedure.

**NOTE**

**THE NEW DESIGN INNER TIE RODS DO NOT HAVE RIVETS OR COILED PINS TO RETAIN THEM. PREVIOUS PRODUCTION TIE RODS, WITH RIVETS OR COIL PINS, MUST USE PRIOR TORQUE SPECIFICATION.**

**SERVICE PROCEDURE**

**DISASSEMBLY**

1. Remove power rack and pinion steering gear. Refer to the appropriate model/year Service Manual, Section 11-02, for procedure.
2. Install two (2) long bolts and washers through the steering gear insulators (-3K576-) and attach to Bench Mounted Holding Fixture T57L-500-B.
3. Loosen the jam nuts on the outer ends of the front wheel spindle tie rods (-3280-) adjacent to the tie rod ends (-3A130-) and remove the tie rod ends and jam nuts.

4. Remove the four (4) inner/outer steering gear boot/bellow clamps (-3C650-) retaining the bellows to the steering gear housing (-3548-) and the front wheel spindle tie rods. Discard the inner/outer steering gear boot clamps if damaged or excessively corroded.
5. Remove the bellows along with the power steering gear rack tube (-3K762-).

**CAUTION**

**USE CARE NOT TO DAMAGE THE BOOT/BELLOWS, AS INTERNAL DAMAGE TO FRONT WHEEL INNER TIE ROD MAY RESULT.**

6. Remove power steering short rack (-3L547-) from the holding fixture and lay on the bench before proceeding. This prevents steering gear teeth damage from steering gear input shaft twisting when removing the front wheel spindle tie rods.
7. Position steering gear input shaft so that several steering gear input shaft teeth are exposed. Hold steering gear rack with an adjustable wrench on the end teeth only, while loosening front wheel spindle tie rods **with a 34mm hex nut wrench.**

**NOTE**

**SOME POWER STEERING SHORT RACK ASSEMBLIES MAY CONTAIN ONE (1) OR TWO (2) STEERING GEAR TRAVEL RESTRICTORS ON EACH SIDE OF THE STEERING GEAR RACK. THE RESTRICTORS ARE SPLIT NYLON WASHERS AND, IF REQUIRED, CAN EASILY BE REMOVED FROM THE STEERING GEAR RACK. RESTRICTORS MAY BE REUSED UNLESS HEAVILY WORN.**

## Article No. 96-1-1 Cont'd.

### ASSEMBLY

1. Turn power rack and pinion against or near left stop and hold steering gear rack with adjustable wrench. Tighten each inner tie rod assembly separately, **using a 34mm hex nut wrench, to 90-110 N•m (66-81 lb-ft).**

### NOTE

**THE NEW DESIGN SERVICE TIE ROD ENDS DO NOT HAVE RIVETS OR COILED PINS TO RETAIN THEM.**

2. Install tie rod bellows and power steering gear rack tube. Install clamps retaining the tie rod bellows to the steering gear housing and tighten to 2.3-3.4 N•m (20-30 lb-in). Position tie rod bellows, power steering gear rack tube and clamps as shown.

3. Install new clamps retaining tie rod bellows to tie rod ends.
4. Install the jam nuts on the front wheel spindle tie rods.
5. Apply Silicone Brake Caliper Grease and Dielectric Compound D7AZ-19A331-A, or equivalent meeting Ford specification ESA-M1C172-A, to tie rod end threads.
6. Install tie rod ends on the front wheel spindle tie rod.
7. Install power rack and pinion steering gear. Refer to the appropriate model/year Service Manual, Section 11-02, for procedure.

### SERVICE TIE ROD USAGE

Year	Model	Current Service Part Number	New Service Part Number
1986-95	Taurus/Sable	F2DC-3280-AA	F6SZ-3280-BA
1982-88	Mustang	E8SC-3280-AA	F6SZ-3280-CA
1989-93	Mustang	E8SC-3280-AA	F6SZ-3280-CA
1994-95	Mustang	F2DC-3280-AA	F6SZ-3280-BA
1982-86	Capri	E8SC-3280-AA	F6SZ-3280-CA
1982-88	Thunderbird/Cougar	E8SC-3280-AA	F6SZ-3280-CA
1989-95	Thunderbird/Cougar	E9SC-3280-CA	F6SZ-3280-BA
1988-95	Continental	F2DC-3280-AA	F6SZ-3280-BA
1984-92	Mark VII	E8SC-3280-AA	F6SZ-3280-CA
1993-95	Mark VIII	E9SC-3280-CA	F6SZ-3280-BA
1986-95	Aerostar	F2DC-3280-AA	F6SZ-3280-BA
1995	Windstar	F58C-3280-AA or F58C-3280-BA	F78Z-3280-AA

PART NUMBER	PART NAME
F6SZ-3280-BA	Tie Rod - Inner
F6SZ-3280-CA	Tie Rod - Inner
F78Z-3280-AA	Tie Rod - Inner

**OTHER APPLICABLE ARTICLES: NONE**  
**WARRANTY STATUS: INFORMATION ONLY**  
**OASIS CODES: 303000**