

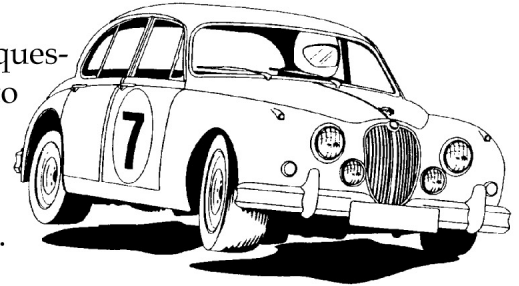
XKs UNLIMITED

MK 2 Rack & Pinion Conversion Kit Part#14-4001

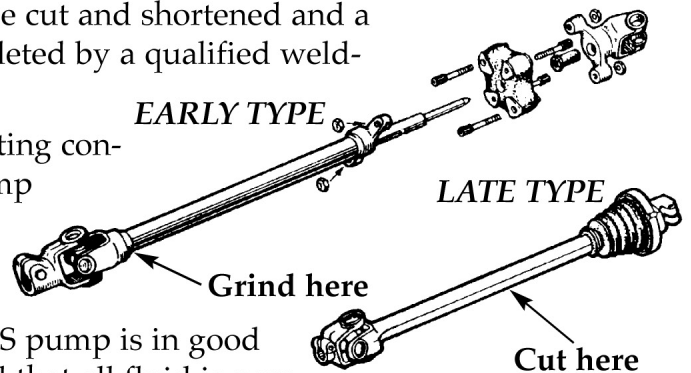
Includes the following parts:

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| (1) Rebuilt and modified XJ power steering rack | (1) Rack mount set |
| (1) Rack mounting bracket | (2) Power steering hoses |
| (1) Set of Graded bolts | |

This is a relatively easy conversion, but if at any time you have questions on the installation please feel free to call us. We want you to be completely satisfied with the results!



- 1) Raise front end of car and rest on safety stands.
- 2) Remove original steering box, hoses, drag links and idler arm. These parts will not be reused.
- 3) Remove lower steering column and save for later
- 4) Attach steering rack mounting bracket to rear side of front subframe with Grade 8 bolts provided. Original mounting holes vary and some "fitting" of bracket may be necessary.
- 5) Fit rack mounts to rebuilt rack and offer up to rack mounting bracket. On some cars the rack tower may interfere with the inner side of the frame rail flange. If this is the case, either bend the flange or grind it away. When proper clearance has been achieved, mount rack to bracket with mounting bushings and new bolts provided.
- 6) Attach tie-rod ends to steering arms on RH & LH uprights. Do not tighten until toe is set (step 11).
- 7) There are two types of lower steering columns. The early style uses a U-joint and is tubular; the later uses a roller CV joint and is a solid rod. Both types need to be shortened $1/2''$ to $1''$ depending on your car. On the early style, grind away the weld around the lower coupler allowing the coupler to slide up the shaft. When the proper length has been determined reweld and reinstall. On the later style, the rod will have to be cut and shortened and a sleeve/weld executed. This step should be completed by a qualified welding/fabrication shop.
- 8) The power steering pump must be in good operating condition for the system to work properly. If the pump is in poor condition you will need to rebuild the pump (#14-4018 Kit available) or send it to XKs Unlimited for rebuilding. **IMPORTANT!** Before attaching power steering hoses make sure the P/S pump is in good condition and that the fluid reservoir is clean and that all fluid is new and clean. It is strongly recommended that power steering filter (#02-MHF-117) be replaced. Install hoses.



NOTE: If you run the system with dirty fluid you can immediately ruin the new rack. This action will void any warranty!

- 9) After the Steering Kit is installed, fill system with fresh Type-F transmission oil. Start engine and work steering wheel back-and-forth for 30 seconds to expel any trapped air. Recheck oil level.
- 10) Set toe-in to $1/8''$ and tighten the tie rod jam nuts. Slightly more castor than stock will improve the steering feel.