

5. Where the balls are stopped by the end of the worm, hold down those balls that are already in the ball nut with a clean rod or punch and turn the worm shaft backwards while continuing to fill the circuit.

N O T E

It may be necessary to work the worm backwards and forwards holding the balls down, first in one hole, then in the other, to close up the spaces between the balls and fill the circuit completely.

6. Put half of the ball guide, groove up, on the bench and put half the balls in it. There should be enough balls remaining in the pan to fill the other circuit. Put the other half of ball guide, groove down, over the first half. Hold the halves together and close the ends with clean grease to keep the balls from coming out while installing the guide.
7. Push the guide into the guide holes of the ball nut. This completes one circuit of balls. If the guide does not push all the way down easily, hit it softly into place with a rubber hammer.
8. Fill the second circuit in the same manner as described for the first ball circuit.
9. Assemble the ball guide clamp to the nut. Be sure to use lockwashers under the clamp screws, then tighten the screws securely.

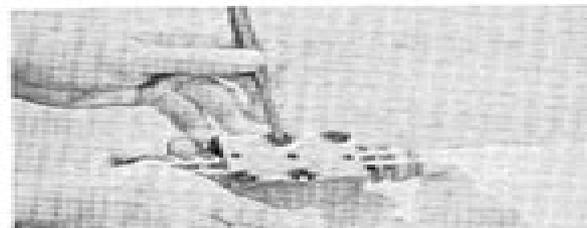


Fig. 13932



Fig. 11875

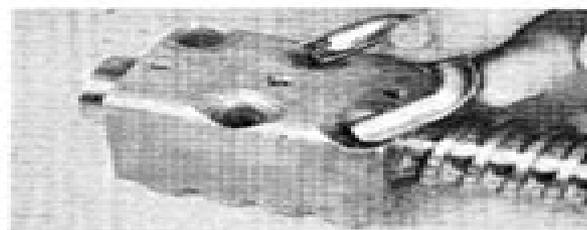


Fig. 13933

I M P O R T A N T

DO NOT ROTATE THE BALL NUT TO THE END OF THE WORM THREADS. THIS CAN DAMAGE THE ENDS OF THE BALL GUIDES. ANY FRICTION IN THE MOTION OF THE BALL NUT INDICATES SOME DAMAGE TO THE ENDS OF THE BALL GUIDES THAT WAS NOT SEEN BEFORE.

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