

# Power Steering Rack Leak from Right Side: Overhaul Procedure

Service Category Steering

Section Steering Gear/Linkage

Market USA

Lexus Supports  
ASE Certification 

## Applicability

YEAR(S)	MODEL(S)	ADDITIONAL INFORMATION
2004 – 2009	RX330, RX350	WMI(s): 2T2

### SUPERSESSON NOTICE

The information contained in this bulletin supersedes SB No. L-SB-0107-12.

- The entire bulletin has been updated to include Power Steering Rack Gasket overhaul.

Service Bulletin No. L-SB-0107-12 is Obsolete and any printed versions should be discarded. Be sure to review the entire content of this bulletin before proceeding.

## Introduction

A new repair procedure and overhaul kit have been developed for repairing the power steering rack to improve the overall serviceability and reduce ownership cost. This repair procedure only applies to vehicles where the steering rack leak is originating from the right (passenger) side **and** is the OEM steering rack assembly.

### NOTE

- This bulletin only applies to North American Produced (NAP) vehicles (VINs starting with 2T2).
- This bulletin does NOT apply to aftermarket or rebuilt steering rack assemblies.
- The procedure in this bulletin is only one of several repair options which include, but are not limited to, complete steering rack overhaul and steering gear replacement. Please use your best judgment to recommend the most effective repair method for the customer.

## Parts Information

PART NUMBER	PART NAME	QTY
04003-3810E	Power Steering Rack Gasket Kit	1
95381-03220	Cotter Pin	2
90080-43036	Exhaust Pipe Gasket	1
90917-06046	Exhaust Pipe Gasket No. 2	1

## Power Steering Rack Leak from Right Side: Overhaul Procedure

### Warranty Information

OP CODE	DESCRIPTION	TIME	OFP	T1	T2
ST1400	R & R Steering Gear Assembly and Overhaul Right (Passenger) Side Power Steering Rack	2.9	44250-0E010 44250-0E011	65	13

#### APPLICABLE WARRANTY

- This repair is covered under the Lexus Basic Warranty. This warranty is in effect for 48 months or 50,000 miles, whichever occurs first, from the vehicle's in-service date.
- Warranty application is limited to occurrence of the specified condition described in this bulletin.

### Required Tools & Equipment

REQUIRED TOOLS & MATERIAL	QUANTITY
Hand Vacuum Pump w/ Gauge	1
Soft Jaw Attachment (Bench Vise)	1
Union Nut Wrench, 17 mm (or equivalent)	1
Union Nut Wrench, 12 mm (or equivalent)	1
Power Steering Oil (Dexron II, III, or equivalent)	As Needed
Silicone Grease	As Needed

SPECIAL SERVICE TOOLS (SST)	PART NUMBER	QTY
Ball Joint Puller*	<a href="#">09628-62011-01</a>	1
Rack & Pinion Holding Tool*	<a href="#">09612-00012-01</a>	1
Variable Open Wrench*	<a href="#">09922-10010-01</a>	2
Steering Rack Adjustment Kit (Steering Worm Bearing Adjusting Socket)	<a href="#">09612-10030-02</a> ( <a href="#">09616-00010-02</a> )	1
Steering Housing Overhaul Tool Set (Puller)	<a href="#">09613-22011</a>	1
Steering Rack Oil Seal Test Tool	<a href="#">09631-12071</a>	1
Vacuum Pressure Tester Seal	<a href="#">09633-00010-01</a>	2
Rear Axle Shaft Bearing Remover (or equivalent)	09527-21011	1
Drive Shaft Boot Clamping Tool (or equivalent)	<a href="#">09521-24010-02</a>	1
Replacer Set #1* (Replacer 40)	<a href="#">09950-60010-02</a> ( <a href="#">09951-00400-01</a> )	1
Handle Set* (Handle Assembly 100 – 4.25")	<a href="#">09950-70010-02</a> ( <a href="#">09951-07100-01</a> )	1

## Power Steering Rack Leak from Right Side: Overhaul Procedure

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### Required Tools & Equipment (Continued)

\* Essential SST.

**NOTE**

Additional SSTs may be ordered by calling 1-800-933-8335.

### Service Bulletin Overview

1. Confirm origin of oil leak.
2. Remove the power steering rack.
3. Thoroughly clean and inspect the power steering rack.
4. Remove the right side steering rack bushing assembly and install new O-ring and seal.
5. Vacuum air test the power steering rack to confirm repair.
6. Re-install the power steering rack to the vehicle.
7. Confirm by test driving and checking for leaks.



## Power Steering Rack Leak from Right Side: Overhaul Procedure

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### Repair Procedure

#### Confirmation of Steering Rack Oil Leak Source

Place the vehicle on the lift to confirm that only the right side steering rack boot is leaking.

Is leak from right side of rack only?

- **YES** — Proceed with this bulletin.
- **NO** — Steering rack is leaking from the left side, both sides, or another location. **STOP.** This bulletin does NOT apply. Order the complete Power Steering Rack Gasket Kit and rebuild the steering rack assembly using the procedure outlined in the applicable Repair Manual.

#### **NOTE**

This bulletin applies only to OEM power steering racks. Do NOT use these parts or procedures to repair non-OEM or rebuilt power steering racks.

#### Power Steering Rack Removal

Remove the power steering rack assembly.

Refer to the Technical Information System (TIS), applicable model and model year Repair Manual:

- [2004 / 2005](#) RX 330:  
*Steering – Power Assist Systems – “Power Steering Link Assy: Overhaul”*
- [2006](#) RX 330:  
*Steering – Power Assist Systems – “Power Steering: Power Steering Link: Removal”*
- [2007 / 2008 / 2009](#) RX 350:  
*Steering – Power Assist Systems – “Power Steering: Power Steering Link: Removal”*

#### Power Steering Rack Cleaning & Inspection

- If the steering rack housing is damaged, repair the damaged or worn parts as necessary.
- If replacement parts are NOT available or cannot restore the housing integrity/operability, do **NOT** proceed with this bulletin.
- Replace steering rack housing if damaged.

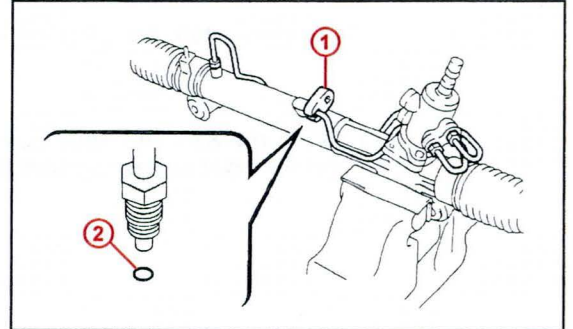
## Power Steering Rack Leak from Right Side: Overhaul Procedure

### Repair Procedure (Continued)

#### Right Side Steering Rack Bushing Removal

1. Prepare the steering rack by steering the rack to the left-hand lock (clockwise).
2. Remove the steering left turn pressure tube.
  - A. Remove the tube clamp from the turn pressure tubes.
  - B. Using a 12 mm Union Nut Wrench (or equivalent), disconnect the left turn pressure tube.
  - C. Remove the 2 O-rings from the left turn pressure tube and discard.

Figure 1.



<b>1</b>	Union Nut Wrench, 12 mm (or equivalent)
<b>2</b>	O-ring

3. Remove the steering right turn pressure tube.
  - A. Disconnect the right turn pressure tube using the procedure above.
  - B. Remove the 2 O-rings from the right turn pressure tube and discard.

**HINT**

Wrap the steering rack in cloth or shop rags to capture any excess power steering oil that will leak during the repair.

Figure 2.



## Power Steering Rack Leak from Right Side: Overhaul Procedure

### Repair Procedure

#### Right Side Steering Rack Bushing Removal (Continued)

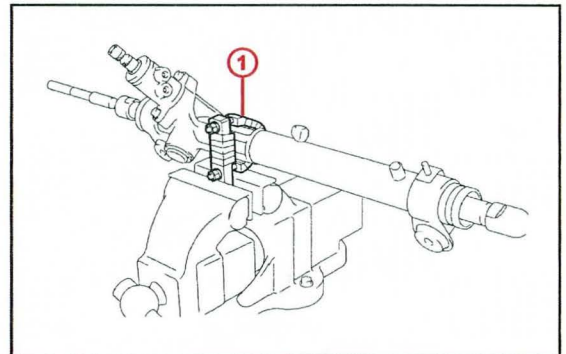
- Using the Rack & Pinion Holding Tool, secure the steering link assembly to prevent damaging the steering link assembly.

SST: 09612-00012-01, Rack & Pinion Holding Tool

**NOTICE**

Wrap the SST with tape before use, in order to prevent damaging the steering link assembly.

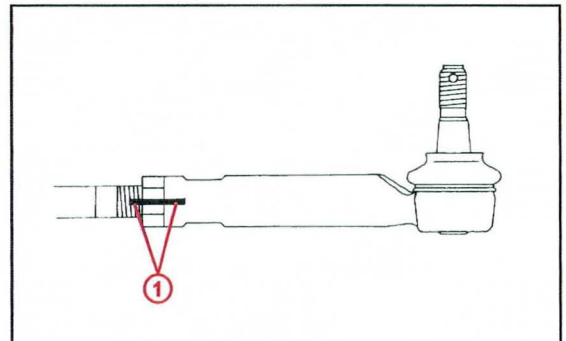
Figure 3.



1 Rack & Pinion Holding Tool

- Put matchmarks on the tie rod assembly and the rack end.

Figure 4.



1 Matchmarks

- Loosen the lock nut and remove the tie rod assembly RH and the lock nut.
- Remove the tie rod assembly RH.
- Remove the 2 RH steering rack boot clips.
- Using pliers, remove the steering rack boot No. 2 clamp.
- Remove the steering rack boot No. 1 clamp.
- Remove the steering rack boot No. 2.
- Remove the steering rack boot No. 1.



## Power Steering Rack Leak from Right Side: Overhaul Procedure

### Repair Procedure

#### Right Side Steering Rack Bushing Removal (Continued)

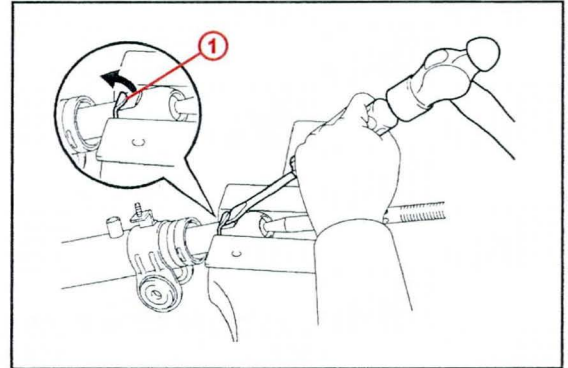
13. Remove the steering rack end sub-assembly.

- A. Using soft jaws, clamp the steering rack end as shown in Figure 5.

**NOTICE**

This step is necessary to avoid transmitting impact to the steering rack gear and steering pinion gear which may cause damage.

Figure 5.



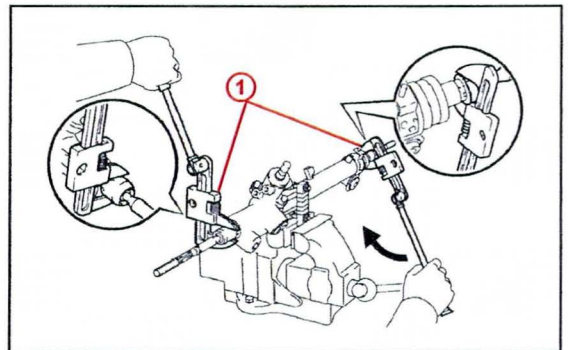
1 Claw Washer

- B. Using a screwdriver and a hammer, unstake the claw washer.

- C. Using the Variable Open Wrench, remove the right-hand rack end and the claw washer.

SST: 09922-10010-01, Variable Open Wrench

Figure 6.



1 Variable Open Wrench

## Power Steering Rack Leak from Right Side: Overhaul Procedure

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### Repair Procedure

#### Right Side Steering Rack Bushing Removal (Continued)

14. Inspect the left-hand and right-hand tie rod ends for excessive wear and play. Push and pull the tie rod to confirm condition. Replace as necessary.

Figure 7.



15. Thoroughly clean the steering rack assembly.

**NOTICE**

Be sure to clean the inside of the rack assembly to prevent foreign material from damaging the rack surface (for example, when boot has torn and allowed debris to collect around the inside of the rack).

Figure 8.





## Power Steering Rack Leak from Right Side: Overhaul Procedure

### Repair Procedure

#### Right Side Steering Rack Bushing Removal (Continued)

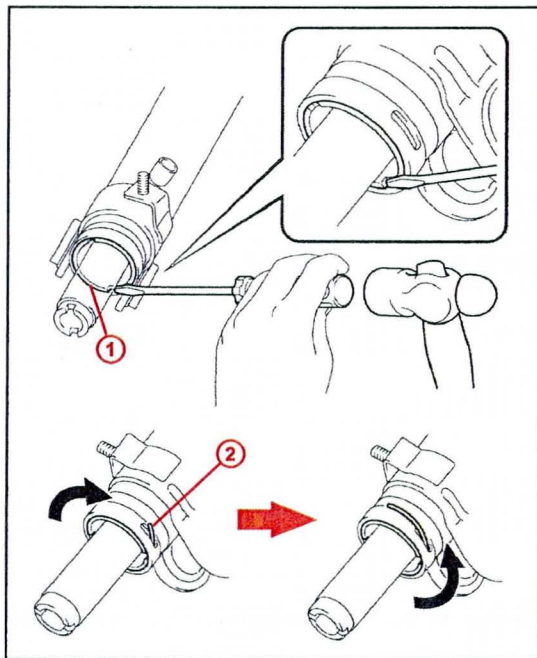
16. Remove the cylinder end stopper.

- A. Using a screwdriver and a hammer, turn the cylinder end stopper clockwise until the wire end is visible through the service hole.
- B. Using a screwdriver and a hammer, turn the cylinder end stopper counterclockwise, and remove the wire and the cylinder end stopper.

**HINT**

Use the hooked wire end or a 90 degree angle hooked pick to pull the end stopper out.

Figure 9.



1	Cylinder End Stopper
2	Wire

Figure 10.



## Power Steering Rack Leak from Right Side: Overhaul Procedure

### Repair Procedure

#### Right Side Steering Rack Bushing Removal (Continued)

17. Remove the power steering rack bushing.

Plug the port while simultaneously turning the input shaft counterclockwise.

**HINT**

The internal air pressure will cause the rack bushing to get pushed out.

**NOTICE**

Do NOT turn the input shaft clockwise. May cause damage to the center seal on the rack bar if it goes beyond its normal travel.

Figure 11.



18. Remove the power steering rack bushing seal and O-ring.

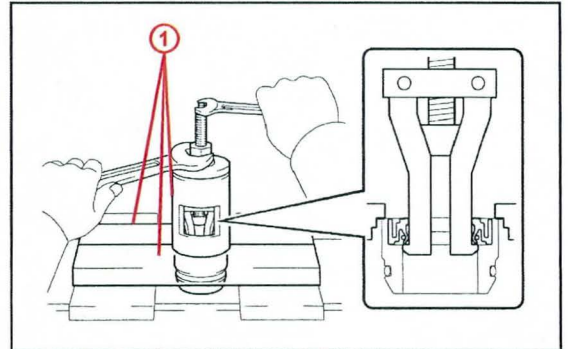
- A. Using the SSTs listed below, remove the rack bushing oil seal from the rack bushing.

SST: 09527-21011, Rear Axle Shaft Bearing Remover (or equivalent)

SST: 09612-24014, Steering Housing Overhaul Tool Set (09613-22011, Puller)

- B. Using a screwdriver or pick, remove the O-ring from the rack bushing.

Figure 12.



- 1 Rear Axle Shaft Bearing Remover (or equivalent), Puller

19. Thoroughly clean the accumulated debris from the steering rack bushing and the steering rack housing before reassembly.

## Power Steering Rack Leak from Right Side: Overhaul Procedure

### Repair Procedure

#### Right Side Steering Rack Bushing Removal (Continued)

20. Install the power steering rack bushing seal.

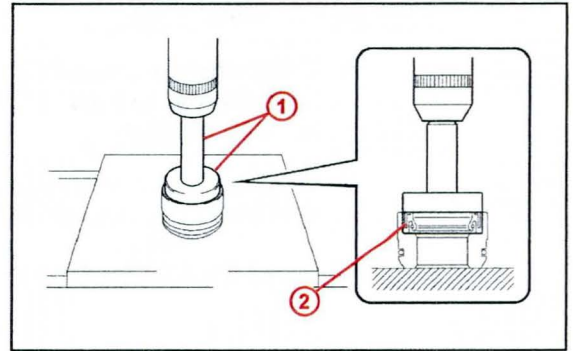
- A. Coat a new rack bushing oil seal lip and outside diameter with power steering oil.
- B. Using the SSTs listed below and a press, install the rack bushing oil seal to the rack bushing.

**SST: 09950-60010-02, Replacer Set #1 (09951-00400-01, Replacer 40)**

**SST: 09950-70010-02, Handle Set (09951-07100-01, Handle Assembly 100 - 4.25")**

- C. Coat a new O-ring with power steering oil and install it to the rack bushing.

Figure 13.



<b>1</b>	Replacer 40, Handle Assembly 100 - 4.25"
<b>2</b>	Oil Seal

21. Inspect and clean the inside of the rack housing.

Look down inside the rack housing to confirm it is clean before reinstalling the rack bushing.

Figure 14.





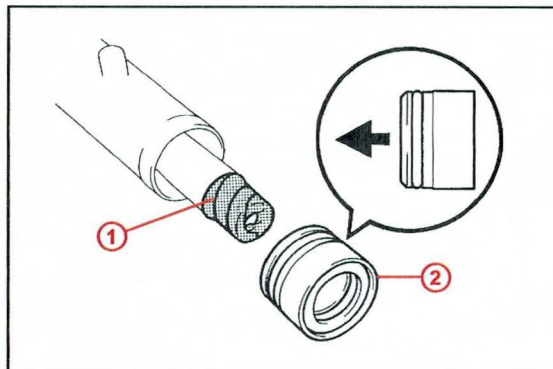
## Power Steering Rack Leak from Right Side: Overhaul Procedure

### Repair Procedure

#### Right Side Steering Rack Bushing Removal (Continued)

22. Install the power steering rack bushing to the rack housing.
  - A. Wrap vinyl tape around the end of the steering rack in order to prevent damaging the rack bushing oil seal.
  - B. Coat the rack bushing oil seal lip, vinyl tape, and the O-ring with power steering oil.
  - C. Install the rack bushing to the rack housing.

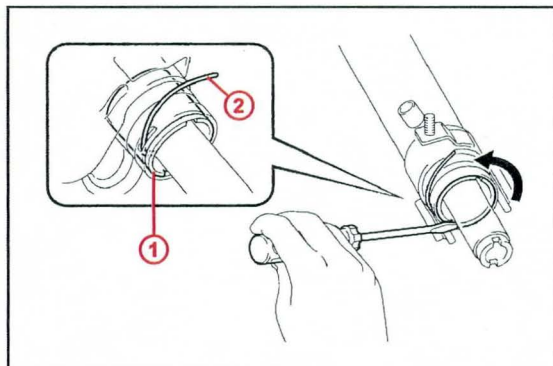
Figure 15.



1	Vinyl Tape
2	Rack Bushing

23. Install the cylinder end stopper.
  - A. Align the installation hole for the wire of the cylinder end stopper with the slot of the rack housing.
  - B. Install a new wire into the cylinder end stopper.
  - C. Using a screwdriver, turn the cylinder end stopper counterclockwise by  $450^{\circ} \pm 50^{\circ}$ .

Figure 16.



1	Cylinder End Stopper
2	Wire

## Power Steering Rack Leak from Right Side: Overhaul Procedure

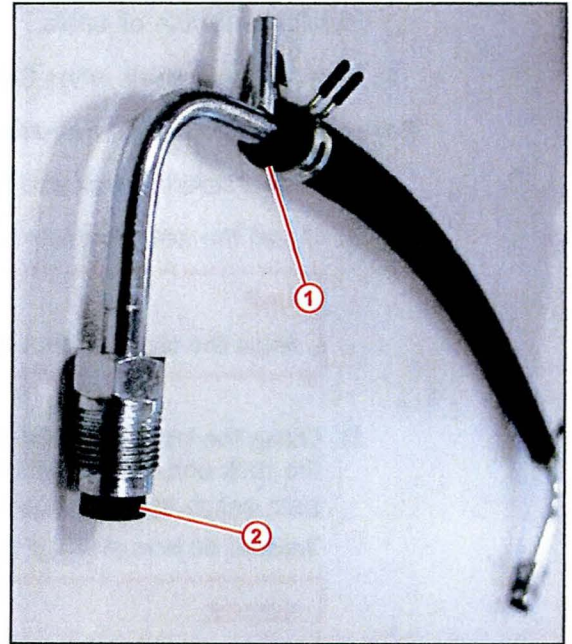
### Repair Procedure (Continued)

#### Vacuum Air Test of Power Steering Rack System

1. Remove the old O-ring and install 2 Vacuum Pressure Tester Seals to ensure proper sealing during testing.

SST: 09633-00010-01, Vacuum Pressure Tester Seal

Figure 17. Vacuum Pressure Tester Seal

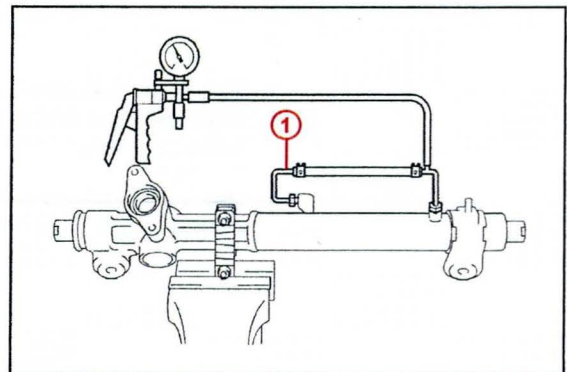


1	Vacuum Pressure Tester
2	Tester Seal

2. Install the SSTs to the rack housing.  
SST: 09631-12071, Steering Rack Oil Seal Test Tool  
SST: 09633-00010-01, Tester Seal (2)

**NOTE**  
Be sure not to over-torque the SST as it can crush the opening of the seal shut and cause inaccurate reading.

Figure 18.



1	Steering Rack Oil Seal Test Tool, Tester Seal
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3. Apply a vacuum of 53 kPa for about 30 seconds.  
Vacuum Pressure: 53 kPa (400 mmHg, 15.75 in.Hg)

## Power Steering Rack Leak from Right Side: Overhaul Procedure

### Repair Procedure

#### Vacuum Air Test of Power Steering Rack System (Continued)

4. Check that there is no change in the vacuum. If there is a change in the vacuum, check the installation of the oil seals.
5. Remove the 2 seals when SST is removed from the steering rack housing.

#### Power Steering Rack End Sub-assembly Installation

1. Install the steering rack end sub-assembly.
  - A. Install the new claw washers, and temporarily install the rack end sub-assembly.

**HINT**

Align the claws of the claw washer with the steering rack grooves.

- B. Using the Variable Open Wrench SST, install the rack end sub-assembly.

SST: 09922-10010, Variable Open Wrench

Torque: 50 N\*m (505 kgf\*cm, 37 ft\*lbf)

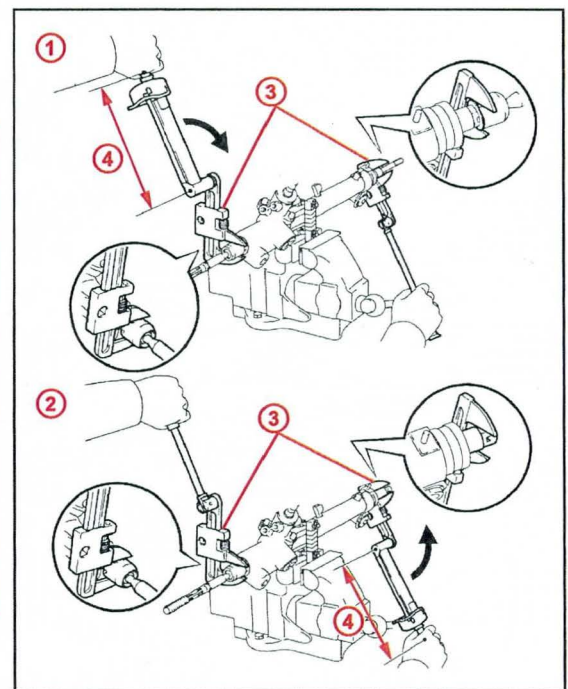
**NOTICE**

Use the Variable Open Wrench following the direction shown in the illustration. Failure to follow this procedure will result in the tie rod not being tightened to the proper torque.

**HINT**

- Using the Variable Open Wrench, hold the rack and install the rack end sub-assembly.
- Use a torque wrench with a fulcrum length of 345 mm (13.58 in.).

Figure 19.



1	LH
2	RH
3	Variable Open Wrench
4	Fulcrum Length



## Power Steering Rack Leak from Right Side: Overhaul Procedure

### Repair Procedure

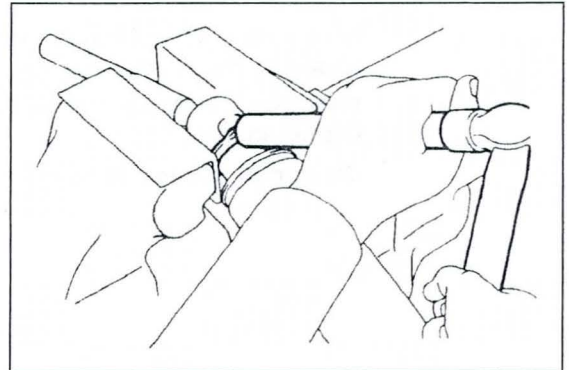
#### Power Steering Rack End Sub-assembly Installation (Continued)

2. Use a brass bar and a hammer to stake the claw washer.

**NOTICE**

Clamp the tie rod as shown to help avoid any impact to the steering rack.

Figure 20.

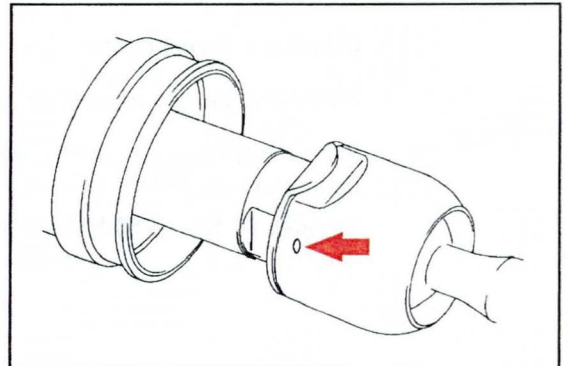


3. Inspect the power steering rack end. Ensure that the holes of the rack ends are NOT clogged with grease.

**HINT**

If the hole is clogged, the pressure inside the boot will change after it is assembled and steering wheel is turned.

Figure 21.



4. Install the steering rack boot.
  - A. Apply a small coat of silicone grease to the inside clamping surface of the small end of the boot as shown.
  - B. Install the steering rack boot.
  - C. Install the steering rack boot clip using pliers.

Figure 22.



## Power Steering Rack Leak from Right Side: Overhaul Procedure

### Repair Procedure

#### Power Steering Rack End Sub-assembly Installation (Continued)

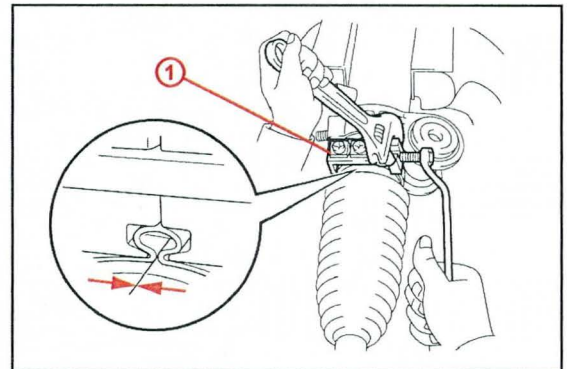
5. Install the steering rack boot clamp.

Using the SST, tighten the rack boot clamp as shown in the illustration.

**SST: 09521-24010-02, Drive Shaft Boot Clamping Tool**

**Clearance: 3.0 mm (0.18 in.) or less**

**Figure 23.**



<b>1</b>	<b>Drive Shaft Boot Clamping Tool</b>
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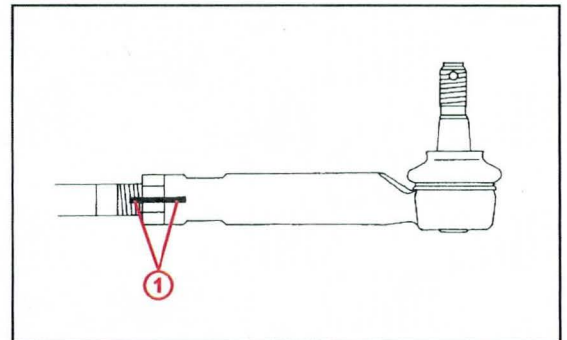
6. Install the steering rack boot clip using pliers.

7. Install the tie rod assembly.

Screw the lock nut and tie rod assembly on the rack end until the matchmarks are aligned.

**Torque: 74 N\*m (750 kgf\*cm, 54 ft\*lbf)**

**Figure 24.**



<b>1</b>	<b>Matchmarks</b>
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8. Repeat steps 1 – 7 for the opposite side.

## Power Steering Rack Leak from Right Side: Overhaul Procedure

### Repair Procedure

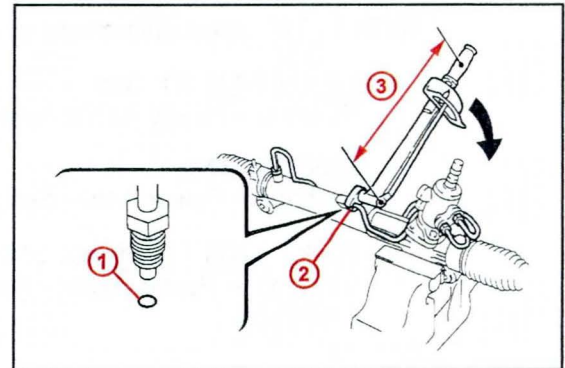
#### Power Steering Rack End Sub-assembly Installation (Continued)

9. Install the steering left turn pressure tube.
  - A. Coat 2 NEW O-rings with power steering oil and install them to the left turn pressure tube.
  - B. Using a 12 mm union nut wrench (or equivalent), install the left turn pressure tube to the steering link assembly.  
Torque: 12 N\*m (122 kgf\*cm, 9 ft\*lbf)

**HINT**

Use a torque wrench with a fulcrum length of 250 mm (9.84 in.).

Figure 25.



1	O-ring
2	Union Nut Wrench, 12 mm (or equivalent)
3	Fulcrum Length

10. Install the steering right turn pressure tube.
  - A. Coat 2 NEW O-rings with power steering oil and install them to the right turn pressure tube.
  - B. Using a 12 mm union nut wrench (or equivalent), install the right turn pressure tube to the steering link assembly.  
Torque: 12 N\*m (122 kgf\*cm, 9 ft\*lbf)

**HINT**

Use a torque wrench with a fulcrum length of 250 mm (9.84 in.).



## Power Steering Rack Leak from Right Side: Overhaul Procedure

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### Repair Procedure (Continued)

#### Power Steering Rack Installation

Reinstall the power steering rack.

Refer to TIS, applicable model and model year Repair Manual:

- [2004](#) / [2005](#) RX 330:  
*Steering – Power Assist Systems – “Power Steering Link Assy: Overhaul”*
- [2006](#) RX 330:  
*Steering – Power Assist Systems – “Power Steering: Power Steering Link: Installation”*
- [2007](#) / [2008](#) / [2009](#) RX 350:  
*Steering – Power Assist Systems – “Power Steering: Power Steering Link: Installation”*

#### Repair Confirmation

1. Confirm there is NO power steering leak by turning the steering wheel left and right with the engine running.
2. Test drive the vehicle and verify that the steering wheel is centered and NO other alignment or vehicle handling concerns are observed.