



STEERING GEAR BOX INSTALL GUIDE

INSTALLATION

These instructions are provided as supplementary information to the factory service manual instructions for power steering gear box replacement.

When installing this steering gear, it is **critical** that it is centered prior to and throughout the installation. If the gear is not centered before driving the vehicle, premature failure, loose steering, and/or other steering-related issues could occur. Follow these instructions to properly center the steering gear.

1. Remove the steering gear from the package and place it on a firm surface.
2. Remove the plugs from the pressure and return ports. (Caution: Power Steering Fluid will be in the steering gear after test procedures, take appropriate steps to contain it.)
3. Rotate the input shaft counterclockwise using a sufficient tool until it will not turn anymore. (**DO NOT** use excessive force.)
4. Rotate the input shaft clockwise and count the total turns until it stops. (On average, this will be about 3 to 4 turns.)
5. Take the total number of turns you have and divide that number by 2.
6. Turn the input shaft the determined number of turns back counterclockwise. (For example, if you have 3 and 1/4 total turns, your amount would be 1 and 5/8 turns.)
7. You have now centered the steering gear. Take a marker or whiteout and place a mark on the end of the pitman shaft and another mark on the housing of the gear that will be visible when the pitman arm is installed. These are now your alignment marks, and they will be used going forward to make sure the gear stays centered during installation.
8. Prior to installing the new gear, verify that the vehicle is parked on a flat surface, the steering wheel is centered, and the wheels are pointed straight.
9. Install the steering gear and align the vehicle.

Note: During the installation of the pitman arm, steering shaft, and connection to the center link, minimal movement of the pitman shaft should occur. It is best practice to disconnect the outer tie rod ends to allow free movement of the center link and easy installation to the pitman arm. Post-installation, check your alignment marks, and if they are out of alignment, remove the pitman arm, adjust the gear, and reinstall the pitman arm.



PITMAN ARM TORQUE SPECS

DO NOT use anti-seize on the sector shaft. Ensure the pitman arm seats correctly. There should be splines exposed on the top of the pitman arm as the shaft is tapered. If your pitman arm goes all the way up and no splines are showing it is worn and should be replaced. Install the pitman arm by hand and thread the nut on by hand, then torque using a torque wrench. **DO NOT** use an impact gun.

XD745 - 225ft/lbs	XD750 - 225ft/lbs	XD755 - 350ft/lbs
XD746 - 184ft/lbs	XD751 - 350ft/lbs	XD756 - 184ft/lbs
XD747 - 190-230ft/lbs	XD752 - 275ft/lbs	XD757 - 200ft/lbs
XD748 - 184ft/lbs	XD753 - 175ft/lbs	
XD749 - 184ft/lbs	XD754 - 185ft/lbs	



WARRANTY

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Products manufactured by XDP carry a 2-Year Unlimited Mileage warranty against defects in materials and craftsmanship. The Warranty is Limited to two (2) years from the date of sale and limited solely to the parts contained within the product's kit.

FOR MOST DIESEL APPLICATIONS

POWERSTROKE

- XD745** - 1997-2004 Ford F-Series Trucks/E-Series Vans
- XD747** - 1994-1997 Ford F-250/350
- XD751** - 2008-2010 Ford F-250/350
- XD755** - 2005-2008 Ford F-250/350
- XD757** - 1997-2004 Ford F-Series Trucks/E-Series Vans

DURAMAX

- XD746** - 2001-2007 GM 2500/3500
- XD748** - 2011-2021 GM 2500/3500
- XD749** - 2001-2007 GM 2500/3500
- XD756** - 2007.5-2010 GM 2500HD/3500

CUMMINS

- XD750** - 2003-2008 Dodge Ram 2500/3500
- XD752** - 2009-2025 Dodge Ram 2500/3500
- XD753** - 1981-1993 Dodge D/W 250/350
- XD754** - 1994-2002 Dodge Ram 2500/3500

FOR MORE INFORMATION VISIT XDP.COM OR CALL US AT 1-888-343-7354