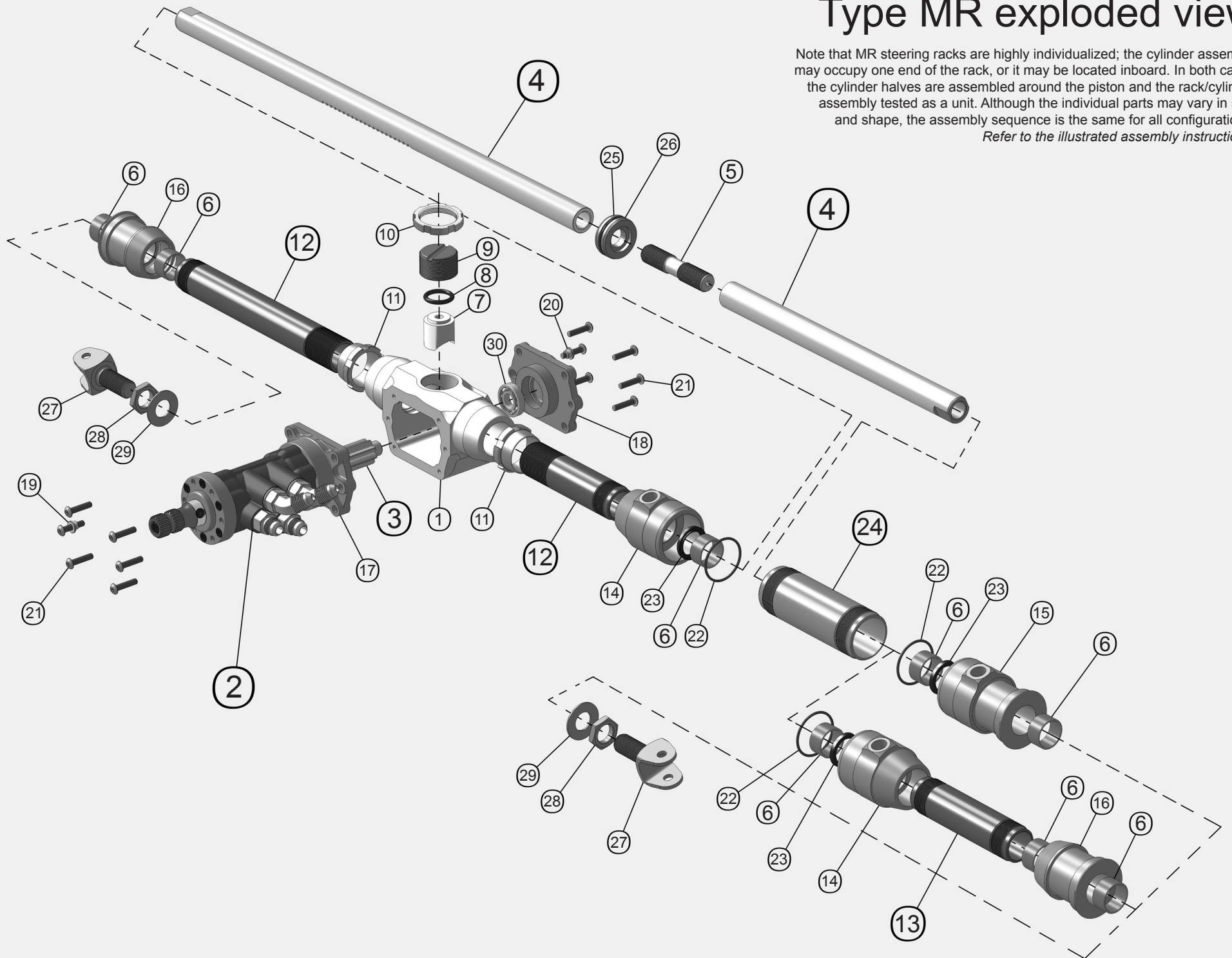


Type MR exploded view

Note that MR steering racks are highly individualized; the cylinder assembly may occupy one end of the rack, or it may be located inboard. In both cases the cylinder halves are assembled around the piston and the rack/cylinder assembly tested as a unit. Although the individual parts may vary in size and shape, the assembly sequence is the same for all configurations.
Refer to the illustrated assembly instructions.



Type MR parts list

(NOTE: Variations of some of the basic part numbers shown below can run into the hundreds. Parts marked * are custom made; to duplicate these we need the original rack serial number or the model number from the CAD file.)

Dwg no.	Part no.	Description	Dwg no.	Part no.	Description
1	MR100	Housing	16	MR152	Tube end
	MR100B	Housing, offset*			
2,3	MR800	Servo/pinion assembly* (refer to servo exploded view)	17	MR153	Servo mounting flange
	MR900	<i>Any valve profile is available in any MR servo. However, the pinion (number of teeth) matches the rackshaft. To change the gear ratio requires both parts.</i>	18	MR154	Pinion bearing flange
4	CF200A & B	Rackshaft* <i>The length, the location of the piston, the number and location of the rack teeth and the ratio are specific to the serial number or the model number from the CAD file.</i>	19	MR155	Long eccentric bushing
5	MR250	Rack stud	20	MR156	Short eccentric bushing
6	MR101A	Rack bushing, 7/8 x 1OD x .5L (5 or 6 depending on the model)	21	-	Button head cap screw, #10-24 x 3/4 Torx IP25 drive (12)
7	MR102	Snubber	22	MR158	O-ring for MR151 and 151B
8	MR103	Snubber O-ring		MR158X	O-ring for MR151X and 151BX
9	MR104	Snubber adjusting screw	23	MR159	Loaded lip seal
10	MR105	Snubber lock nut	24	MR160	Cylinder tube for 1.38 piston*
11	MR111	Housing tube lock nut (1 or 2 depending on the model)		MR160X	Cylinder tube for 1.50 piston*
12	MR140	Inner housing tube* (1 or 2 depending on the model) <i>The length of these tubes is specific to the serial number or the model number from the CAD file.</i>			<i>The length of the tube is specific to the rack serial number or the model number from the CAD file.</i>
13	MR141	Outer housing tube* <i>The length of this tube, if used, is specific to the serial number or the model number from the CAD file</i>	25	MR171	Piston, 1.38 diameter
14	MR151	Cylinder adapter for 1.63 piston		MR171X	Piston, 1.50 diameter
	MR151X	Cylinder adapter for 1.75 piston	26	MR172	O-ring for 1.38 piston
15	MR151B	Cylinder end for 1.63 piston		MR172X	O-ring for 1.50 piston
	MR151BX	Cylinder end for 1.75 piston	27	MR412	Clevis for 1/4 high-misalignment spherical rod end
				MR413	Clevis for 5/6 high-misalignment spherical rod end or 8mm rod end with side shims
			28	MR415	5/8-18 thin jam nut
			29	-	5/8 SAE flat washer
			30	MR340	Pinion radial ball bearing