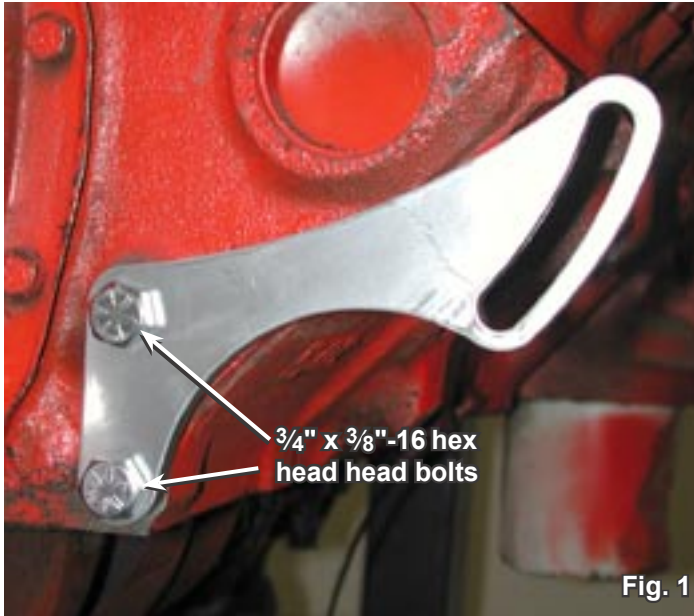




#20165 #20166 Power Steering Bracket Installation Chevy Small Block Metric Long Water Pump

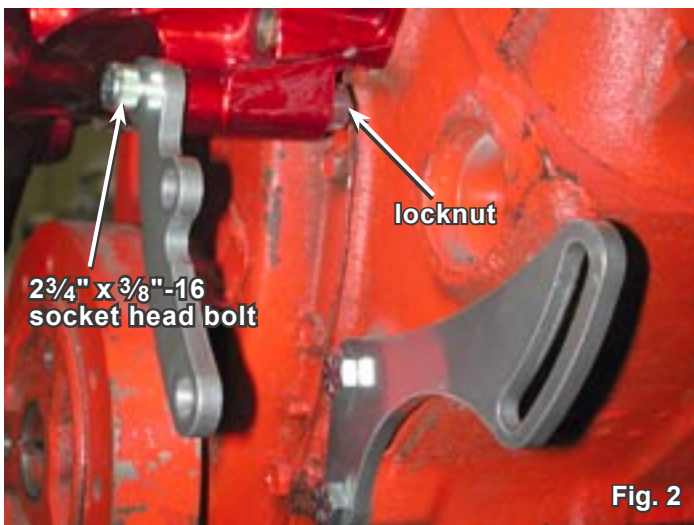
Revised 7-1-06

1. Mount rear power steering pump bracket to front of engine block using two (2) $\frac{3}{4}$ " x $\frac{3}{8}$ "-16 hex head bolts (do not tighten at this time) (fig. 1).

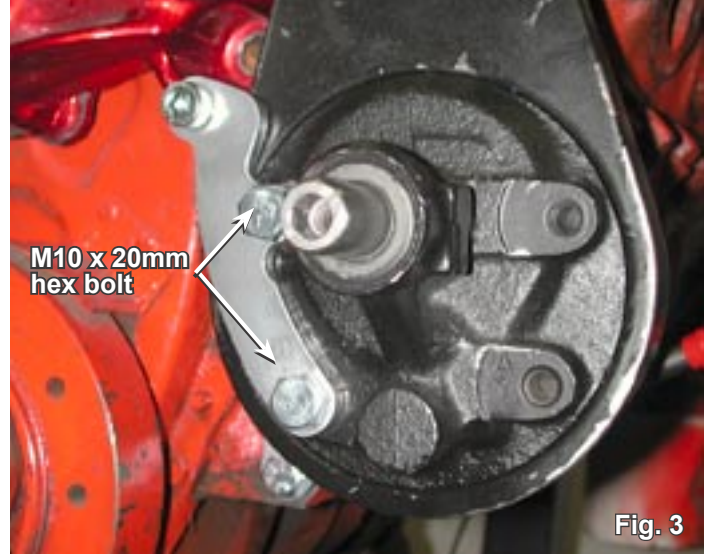


2. Mount the forward lower power steering support bracket that came with your kit to the water pump using the $2\frac{3}{4}$ " x $\frac{3}{8}$ "-16 socket head bolt and $\frac{3}{8}$ " locknut (locknut to back-side of water pump) (do not tighten at this time) (fig. 2).

NOTE: On some later model water pumps it may be necessary to drill the lower mounting hole thorough with a .406 drill.



3. Secure power steering pump to forward lower support brackets using two (2) M10 x 20mm hex head bolts (fig. 3) (these can be tighten).



4. Secure power steering pump to rear lower support brackets using (1) $\frac{3}{4}$ " x $\frac{3}{8}$ "-16 hex head bolt placing a $\frac{3}{8}$ " x 1" washer or .150 thick $\frac{3}{8}$ " spacer between the rear bracket and the pump and a $\frac{3}{4}$ " washer between the bracket and the bolt. (fig. 4) This is dependant on variations with the power steering pump and engine block and can only be determined during installation by checking the squaring of your P/S pump to crank pulley.

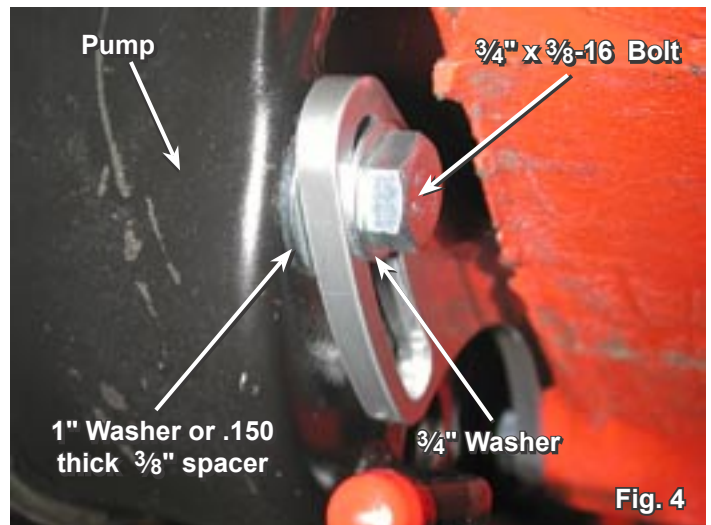




Fig. 5

5. Mount upper support bracket to water pump using two (2) 3 $\frac{3}{4}$ " x $\frac{3}{8}$ "-16 socket head bolts and two (2) spacer tubes. Tighten down bolts at this time (fig. 5).

6. Referring to (fig. 6) check distance between upper mount bracket and power steering pump. This distance should be approximately the thickness of one (1) $\frac{3}{8}$ " x 1" spacer washer ($\frac{3}{32}$ "). If this distance is too great it may be necessary to move the pump forward. This is accomplished by placing one or more spacer washers between the forward lower bracket and the water pump mount (fig. 7). Moving one spacer will move the pump forward approximately $\frac{3}{32}$ ".

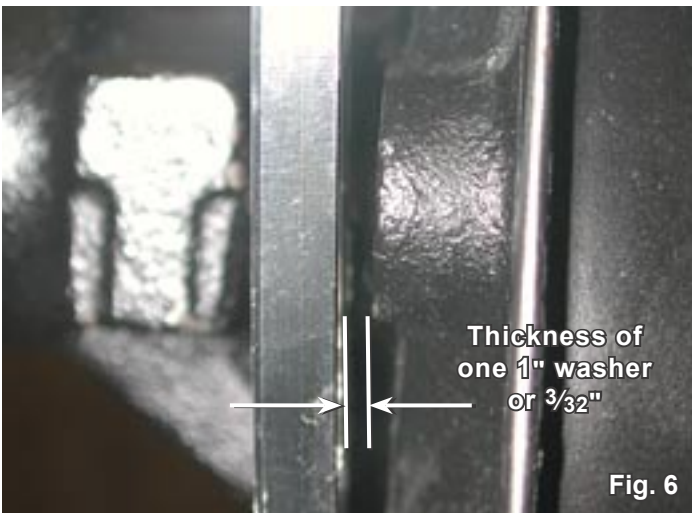


Fig. 6

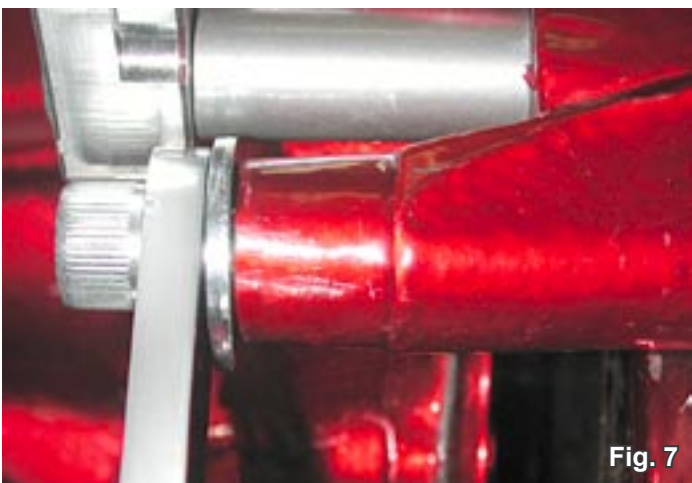


Fig. 7

7. Once proper pump to upper bracket spacing has been achieved secure the pump to the upper mounting bracket using one (1) M10 x 20mm hex head bolt through adjustment slot in upper support bracket placing one $\frac{3}{4}$ " washer between bolt and bracket and one 1" washer between the bracket and the pump. (do not tighten at this time) (fig. 8).

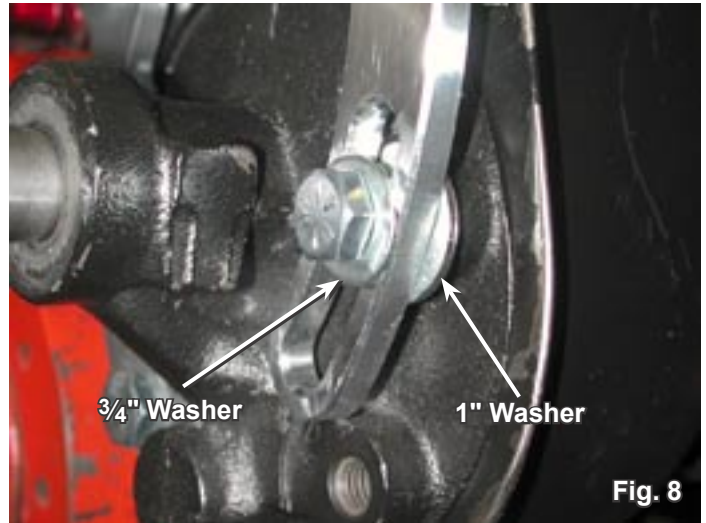


Fig. 8

8. Mount power steering pulley to pump shaft and secure with proper nut. Check power steering to crank pulley alignment. Install belt and adjust belt tension by pulling up on power steering pump. Belt tension is correct when there is no more than $\frac{1}{4}$ " play in the belt at mid point between the power steering pulley and the crank pulley. Lock the belt tension by tightening BOTH front and rear adjustment bolts with a $\frac{9}{16}$ " opened wrench (fig. 9).

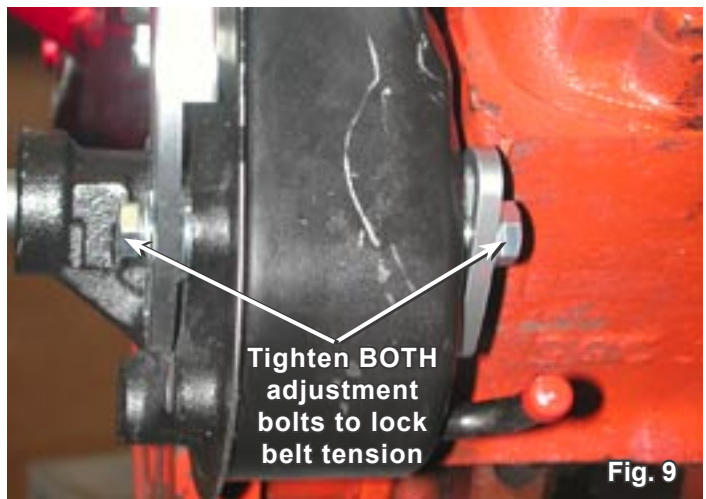


Fig. 9

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