



#20160-20161 INSTRUCTIONS

Power Steering Bracket Installation

Chevy Small Block Long Water Pump

1. If your power steering pump came equipped with a mounting stud at the rear of the pump use a $1\frac{1}{16}$ " wrench to remove the mounting stud from the pump unit (fig. 1).

2. Mount the lower support brackets that came with your kit to the water pump using the $\frac{3}{8}$ -16 x $3\frac{3}{4}$ " socket head bolt. Place three (3) $\frac{3}{8}$ x $\frac{3}{4}$ " diameter spacer washers between the water pump and the rear support bracket and start threads (fig. 2) (do not tighten at this time). Due to production variances in OEM and aftermarket water pumps the number of spacer washers required may change (read on).

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

3. Secure pump to lower support brackets using two (2) $\frac{3}{8}$ -16 x $\frac{3}{4}$ " hex head head bolts at the front bracket (fig. 3) and one (1) $\frac{3}{8}$ -16 x $\frac{3}{4}$ " hex head head bolt at the rear placing a $\frac{3}{8}$ " x $\frac{3}{4}$ " diameter washer between the bracket and the pump. (fig. 4) Snug down bolts at pump and at water pump (fig. 5).

4. Mount upper bracket to water pump using two (2) $\frac{3}{8}$ -16 x $4\frac{1}{4}$ " socket head bolts and two (2) $\frac{9}{16}$ " o.d. x $\frac{3}{8}$ " i.d. x 1.775" long spacer tubes. Snug down bolts at this time (fig. 6).

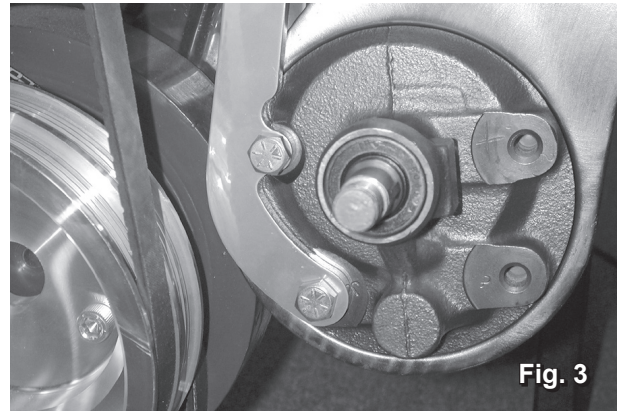


Fig. 3

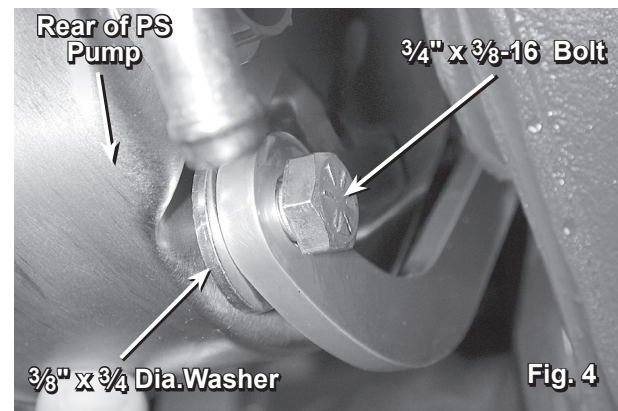


Fig. 4

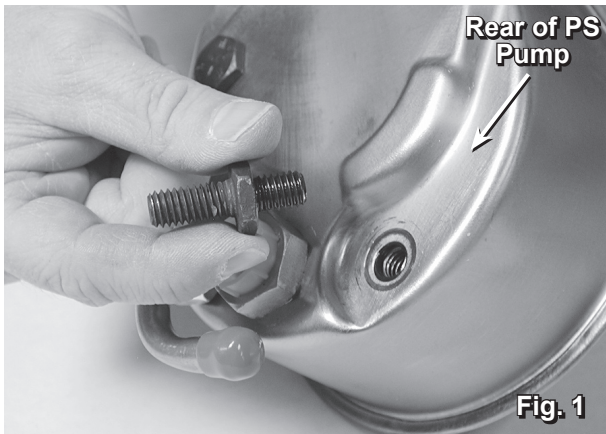


Fig. 1

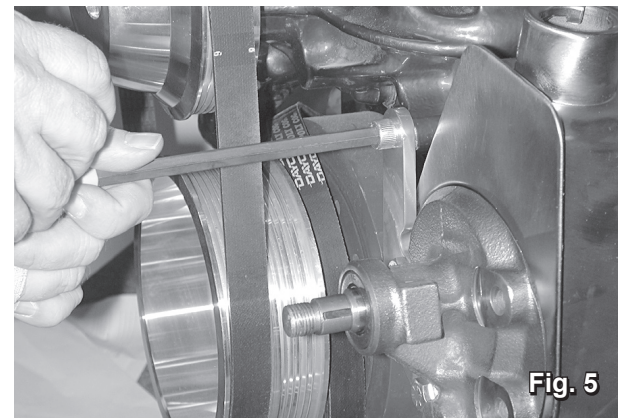


Fig. 5

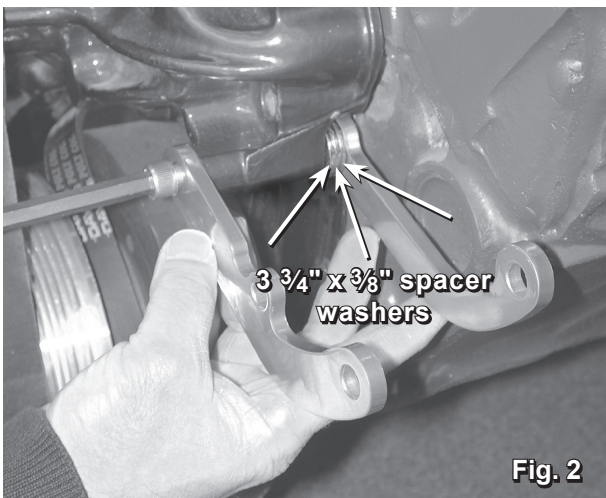


Fig. 2

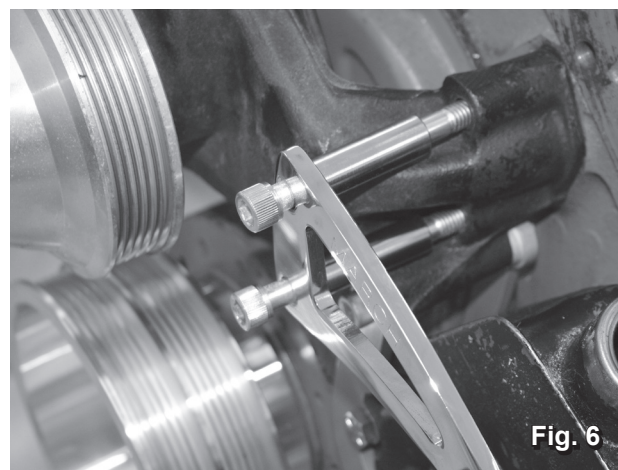
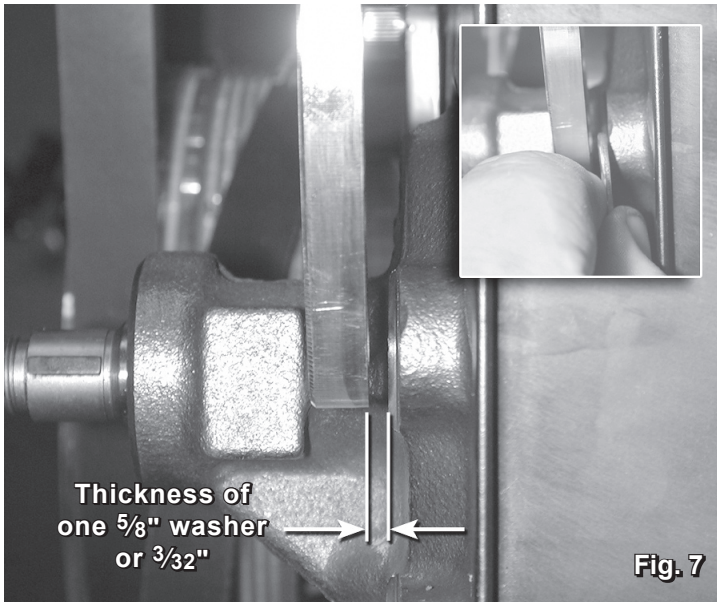
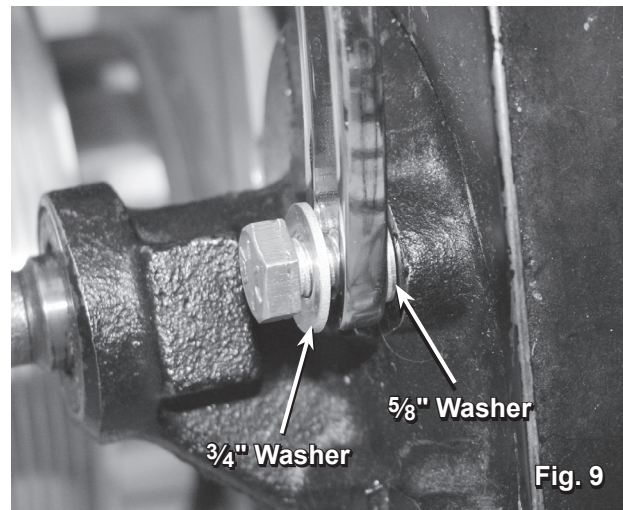
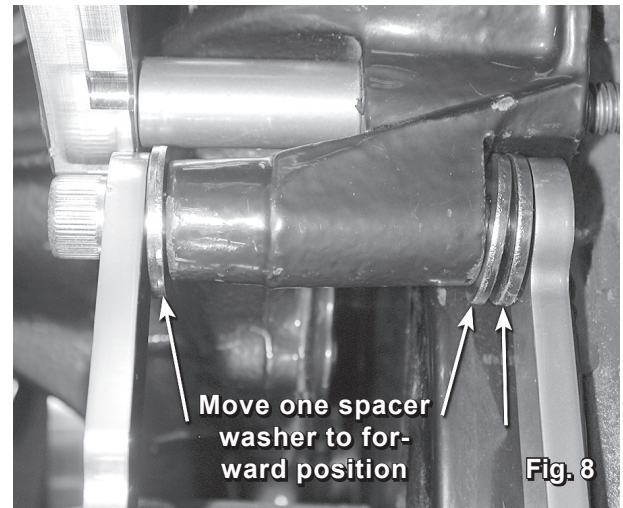


Fig. 6

5. Referring to (fig. 7) check distance between upper mount bracket and power steering pump. This distance should be approximately the thickness of one (1) $\frac{3}{8}$ " x $\frac{3}{4}$ " spacer washer ($\frac{3}{32}$ "). If this distance is too great it may be necessary to move the pump forward. This is accomplished by moving one or more spacers from the lower bracket to water pump mount forward from the rear bracket position to the front bracket (fig. 8). Moving one spacer will move the pump forward approximately $\frac{3}{32}$ ".



6. Once proper pump to upper bracket spacing has been achieved secure the pump to the upper mounting bracket using one (1) $\frac{3}{8}$ -16 x $\frac{3}{4}$ hex head head bolt with a $\frac{3}{4}$ " washer in front of the upper bracket and a $\frac{5}{8}$ " washer between the power steering pump and the upper bracket (fig. 9). All other mounting bolts may be tighten at this time.



NOTE: We supply extra washers due to variances in power steering and water pumps

7. Mount power steering pulley to pump shaft. 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 the adjustment bolt with a $\frac{9}{16}$ " opened wrench (fig. 10).

