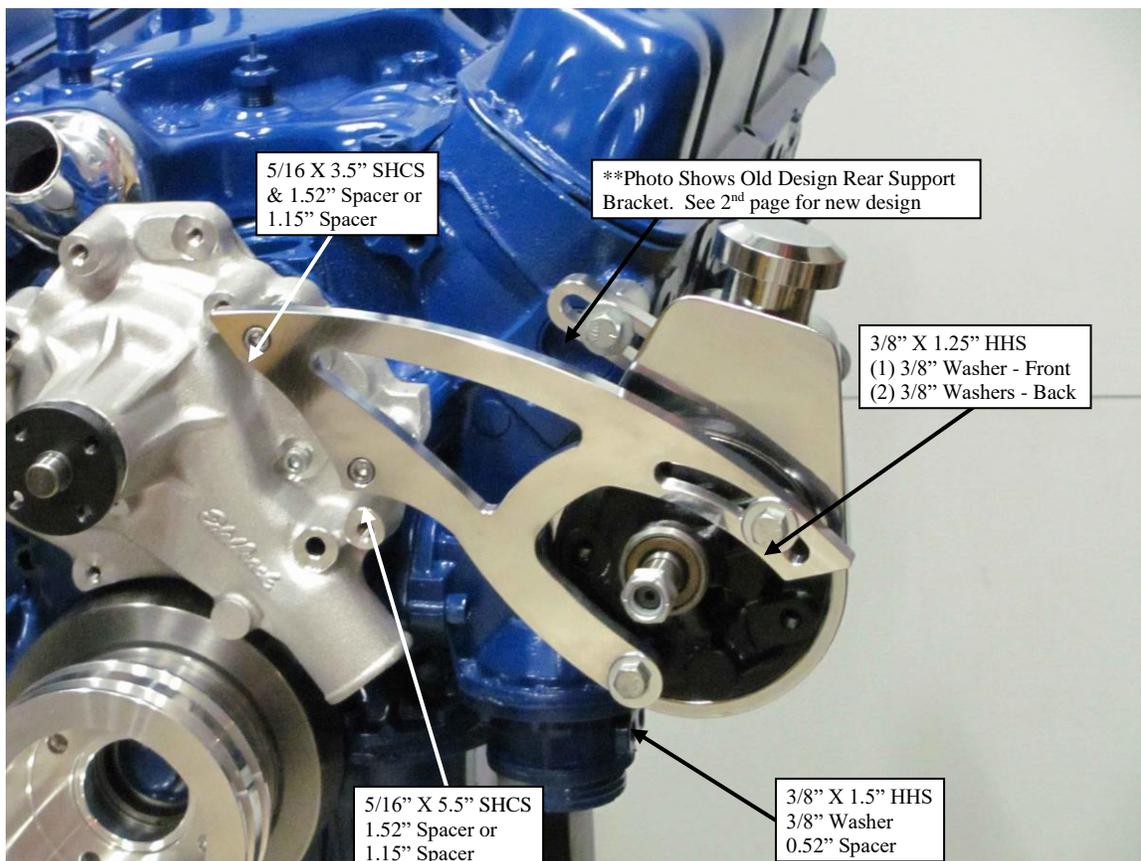


302-PSBRKT-S Instructions (Saginaw PS Pump) Rev I

Ford 289-302-351W Power Steering Bracket – Mechanical Water Pump			
Item	Description	Qty	Comments
1	5/16-18 X 3.50" SHCS	1	Main Bracket to Water Pump (Top Bolt)
2	5/16-18 X 5.50" SHCS	1	Main Bracket to Water Pump (Bottom Bolt)
3	3/8-18 X 1.50" SHCS	1	Rear Support Bracket to Power Steering Pump
4	3/8-16 X 1.25" HHS	1	Bracket to Power Steering Pump (Top)
5	3/8-16 X 1.50" HHS	1	Bracket to Power Steering Pump (Bottom)
6	7/16-14 X 2.00" SHCS	1	Rear Support Bracket to Cylinder Head
7	3/8" USS Washer	5	Washer for mounting pump to Bracket (2) Washer between bolt and Rear Support Bracket (1)
8	7/16" SAE Washer	2	Washer between bolt and Rear Support Bracket (1)
9	0.75" X 1.0" Dia Aluminum Spacer	1	Spacer between Rear Support Bracket and PS Pump
10	1.00" X 1.0" Dia Aluminum Spacer	1	Spacer between Rear Support Bracket and Cylinder Head
11	0.52" X .625" Dia Spacer	1	Spacer between Main Bracket and Steering Pump
12	1.15 " X .625" Dia Spacer	2	Spacer Between Bracket & Water Pump (Newer Pumps)
13	1.52 " X .625" Dia Spacer	2	Spacer Between Main Bracket & Water Pump (Older Pumps)
14	302 Rear Support Bracket (302777-2)	1	Bracket that Bolts to Back of PS Pump
15	Main Bracket (P/N 302977-E)	1	Bracket that Bolts to Front of PS Pump
	Total Parts	22	S-4601, 10x8x2 Box
	Note: SHCS = Socket Head Cap Screw HHS = Hex Head Screw		



Step 1: Remove old power steering bracket.

Step 2: Attach Main Power Steering Bracket to Water Pump using 5/16" X 5.5" SHCS and 5/16" X 3.5" SHCS. Older water pumps where the boss height is 0.90" use 1.52" spacers. Newer pumps with 1.25" boss height use 1.15" Spacers.

Note: If 5.5" bolt bottoms out before tightening you may need to remove the water pump and clean the blind hole in engine block. If cleaning does not work, you may need to shorten the bolt by up to 1/4".

IMPORTANT: Do not tighten any bolts until the end.

Step 3: Attach power steering pump to main bracket using:

Top Bolt:

3/8" X 1.5" HHS

3/8" Washer under Bolt

3/8" Washers (2) between bracket and pump

Bottom Bolt:

3/8 X 1.25" HHS

3/8" Washer under Bolt

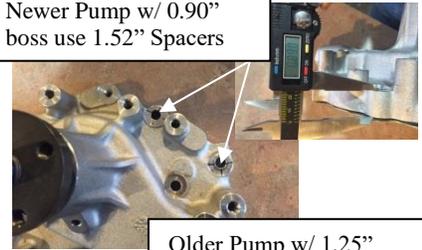
0.52" Steel Spacer between bracket and pump.

Step 4: Attach rear support bracket to cylinder head using 7/16" X 2.00" HHS with 1.0" Aluminum Spacer between bracket and cylinder Head. Note: If using CVF Racing A/C bracket then delete the 1.0" Spacer and replace with 7/16 Washer and A/C Bracket.

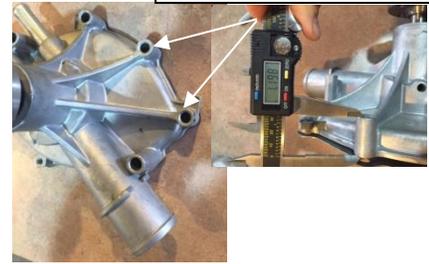
Step 5: Attach rear support bracket to power steering pump using 3/8" X 1.5" SHCS, and 0.75" Aluminum Spacer between bracket and pump. (You will need to remove a threaded plug of stud from the back of most Saginaw Style Pumps)

Step 6: Tighten all bolts except the ones that will need to move during belt tensioning. Install belt, set proper belt tension and tighten all remaining bolts.

Newer Pump w/ 0.90" boss use 1.52" Spacers



Older Pump w/ 1.25" Boss use 1.15" Spacers



7/16" X 2.00" HHS & 1.0" Aluminum Spacer Or AC Bracket & 7/16" Washer



3/8" X 1.5" SHCS & 0.75" Spacer

