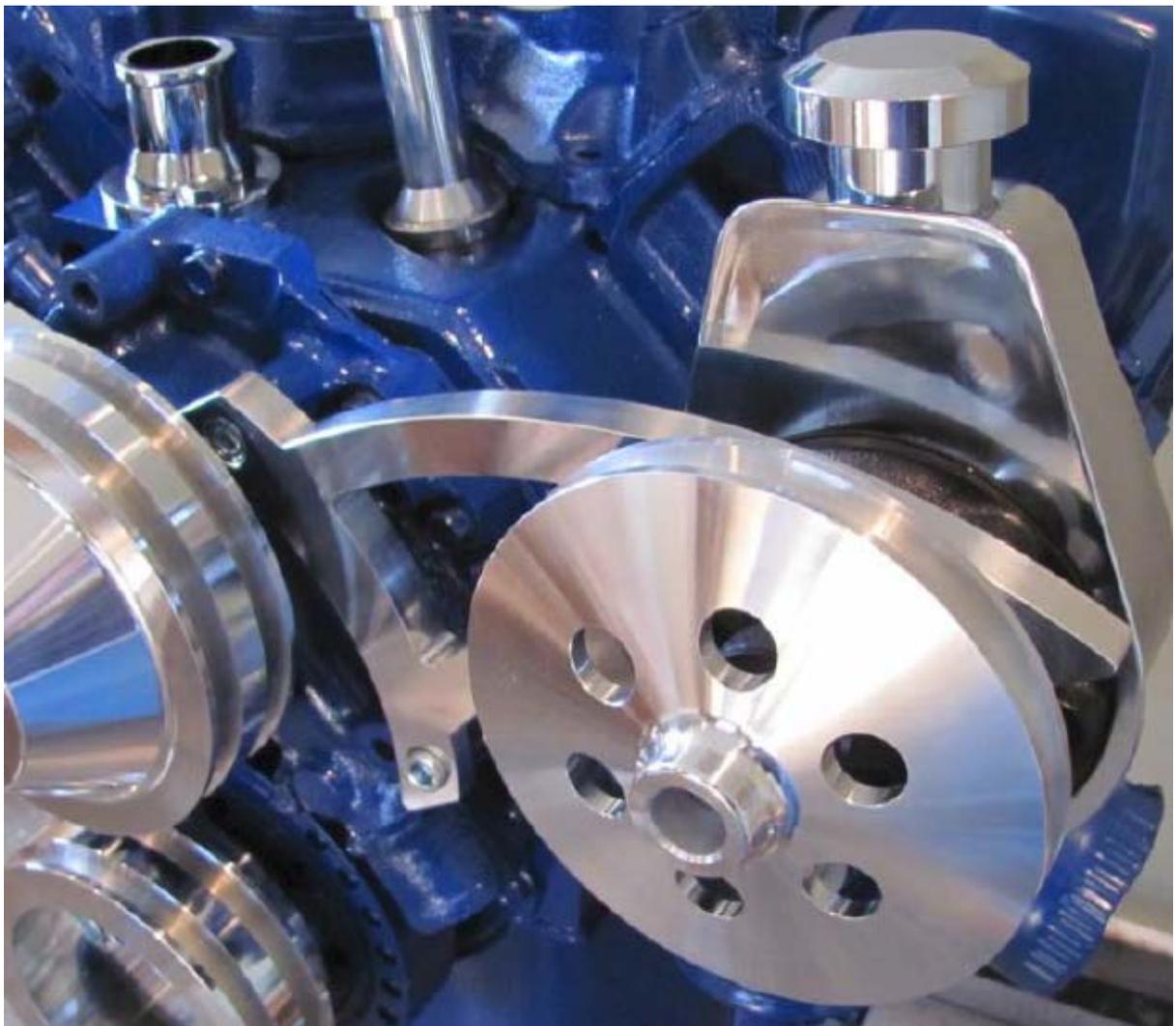


400-PSBRKT-S Instructions (Saginaw PS Pump) Rev B

351M & 400 Power Steering Bracket Parts List			
Item	Description	Qty	Comments
1	SHCS 3/8-16 X 3/4"	2	Bracket to Water Pump Bolts
2	HHS 3/8-16 X 1.25"	1	Pump to Main Bracket (Top)
3	HHS 3/8-16 X 1.5"	1	Pump to Main Bracket (Bottom)
4	HHS 3/8-16 X 2.00"	1	Rear Support Bracket to Pump
5	SHCS 7/16-14 X 1.0"	1	Rear Support Bracket to Cylinder Head
6	3/8 USS Washer	4	Washers for PS pump mounting
7	0.52" X .625" OD Steel Spacer	1	Spacer Between Pump and Bracket (Bottom)
8	1" x 0.50" Spacer	1	Spacers between Rear Support Bracket and Cyl Head
9	1" x 1.00" Spacer	1	Spacers between Rear Support Bracket and Pump
10	P/N - 351C77	1	Main Bracket
11	P/N - 4605777	1	Rear support Bracket for Pontiac and Ford 400
	Total Parts	15	
Note: SHCS = Socket Head Cap Screw HHS = Hex Head Screw			



Step 1: Remove water pump pulley and old steering bracket.

Important: Install bracket and pump without pulley installed. You may not be able to assemble the bolts if you try to assemble with pulley on the pump.

Step 2: Bolt Main Bracket (2) to water pump using two 3/8-16 X 0.75" SHCS (3).

Important: Do not tighten any bolts until the end. This will allow you to adjust the bracket position and align the bolts holes correctly.

Step 3: Bolt bottom of power steering pump to the Main Bracket (2) using 3/8-16 X 1.5" HHS (5) with 0.52" steel spacer (9) between bracket and pump. Use one 3/8" USS washer (8) under bolt.



Step 4: Bolt top of Main Bracket (2) to pump using 3/8-16 X 1.25" HHS (4). Place two 3/8" USS Washers (8) between Pump and Main Bracket. Place one 3/8" USS Washer (8) between Bolt and Bracket.

Step 5: Bolt Rear Support Bracket (1) to Cylinder Head using 7/16-14 X 1.00" with 0.50" Spacer (10) between Bracket and Head.

Step 6: Bolt Rear Support Bracket (1) to Power Steering Pump using 3/8-16 X 2.0" HHS (6) with 1.00" Spacer (11) between Bracket and Pump. (Remove the stud from the back of your pump)



Step 7: Tighten all bolts except the ones that will need to move during belt tensioning.

Step 8: Install Power Steering Pulley.

Step 9: Install belt, set proper belt tension and tighten all remaining bolts.

If using CVF Racing Pulley, use a Series 15 belt (15/32" wide at the top). To determine the proper length, cut your old belt and use it to measure. Most auto-parts stores sell these belts in 1" increments.