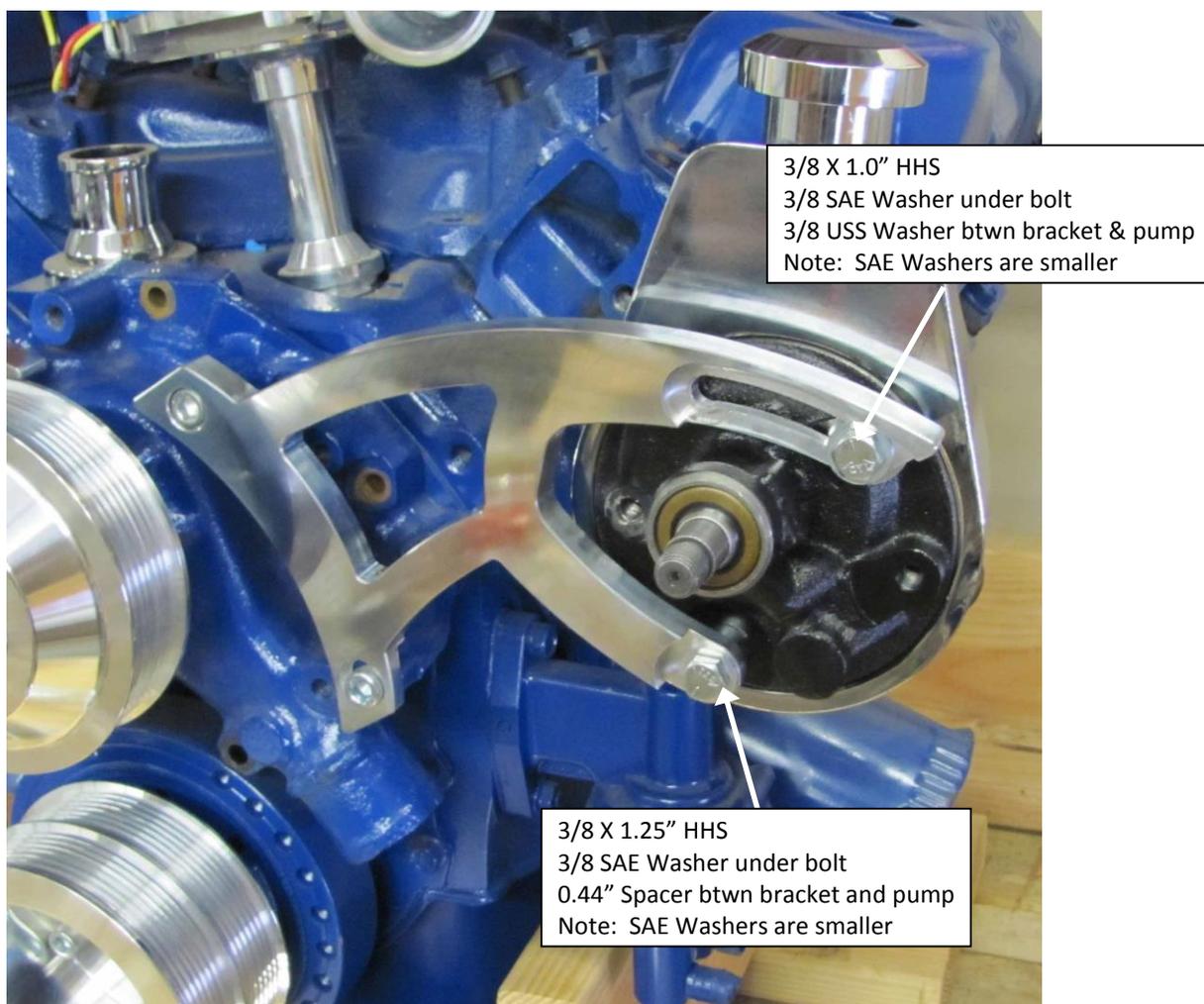


400-PSBRKT-SERP Instructions Rev C

Ford 351M & 400 Power Steering Bracket Parts List			
Item	Description	Qty	Comments
1	SHCS 3/8-16 X 0.75"	2	Bracket to Water Pump Bolts
2	HHS 3/8-16 X 1.0"	1	Pump to Main Bracket (Top)
3	HHS 3/8-16 X 1.25"	1	Pump to Main Bracket (Bottom)
4	HHS 3/8-16 X 2.0"	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	2	Washer between pump and bracket (top bolt) Washer between rear support bracket and pump
7	3/8 SAE Washer	2	Washers for PS pump mounting
8	0.44" Spacer (6257722-044)	1	Spacer between Pump and Bracket (Bottom)
9	1" x 1.00" Spacer	1	Spacer for Rear Support Bracket to Pump
10	1" x 0.50" Spacer	1	Spacer for Rear Support Bracket to Cylinder Head
11	9/16 X 0.078" Washer	1	Thin washer for shimming power steering pulley if required
12	P/N 351C77-S	1	Main Bracket (with recessed bolts)
13	P/N 4605777	1	Rear Support Bracket (Pontiac / Ford 400 Rear Support)
	Total Parts	16	

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.

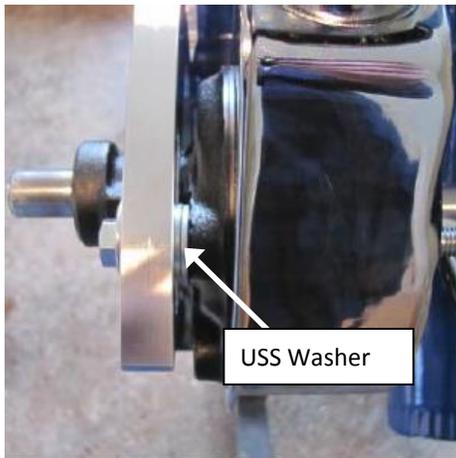
Step 2: Bolt Main Bracket to water pump using two 3/8-16 X 0.75" SHCS.

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: With a dremmel or die grinder, carefully remove a small amount of material on the corner of the casting. (see photo to right)



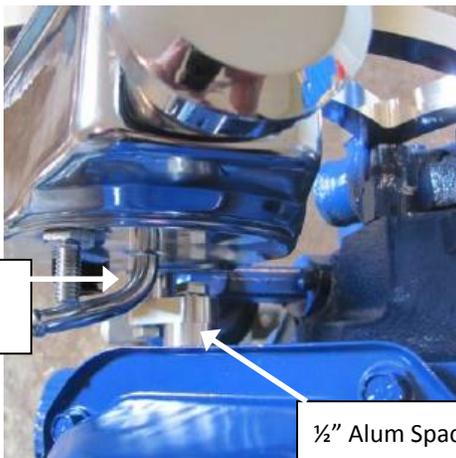
Step 4: Bolt bottom of pump to the Bracket using 3/8-16 X 1.25" HHS with 0.44" spacer between bracket and pump. Use 3/8" SAE washer under bolt. (Note: SAE washers are smaller than USS)



Step 4: Bolt top of Bracket to pump using 3/8-16 X 1.0" HHS. Place 3/8" USS Washer between Pump and Bracket. Place one 3/8" SAE Washer under bolt head. (Note: SAE washers are smaller than USS)

Step 5: Bolt Rear Support Bracket to Cylinder Head using 7/16-14 X 1.50" with 0.50" Spacer between Bracket and Head.

Step 6: Bolt Rear Support Bracket to Power Steering Pump using 3/8-16 X 2.00" HHS with 1.00" Spacer and USS washer between Bracket and Pump. (Remove the stud from the back of your pump)



Check power steering pulley clearance with bracket. Shim as necessary. (1/32" Min)

Check Belt Clearance – Min of 1/32":
- Lower Radiator Hose (wire tie if necessary)
- Water Pump Pulley

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

Step 8: Install Power Steering Pulley – note that washer may be required to provide clearance between pulleys and bracket, two washers of different thickness is included. (See photo)

Step 9: Install 41 & 3/8" long belt, set proper belt tension and tighten all remaining bolts.