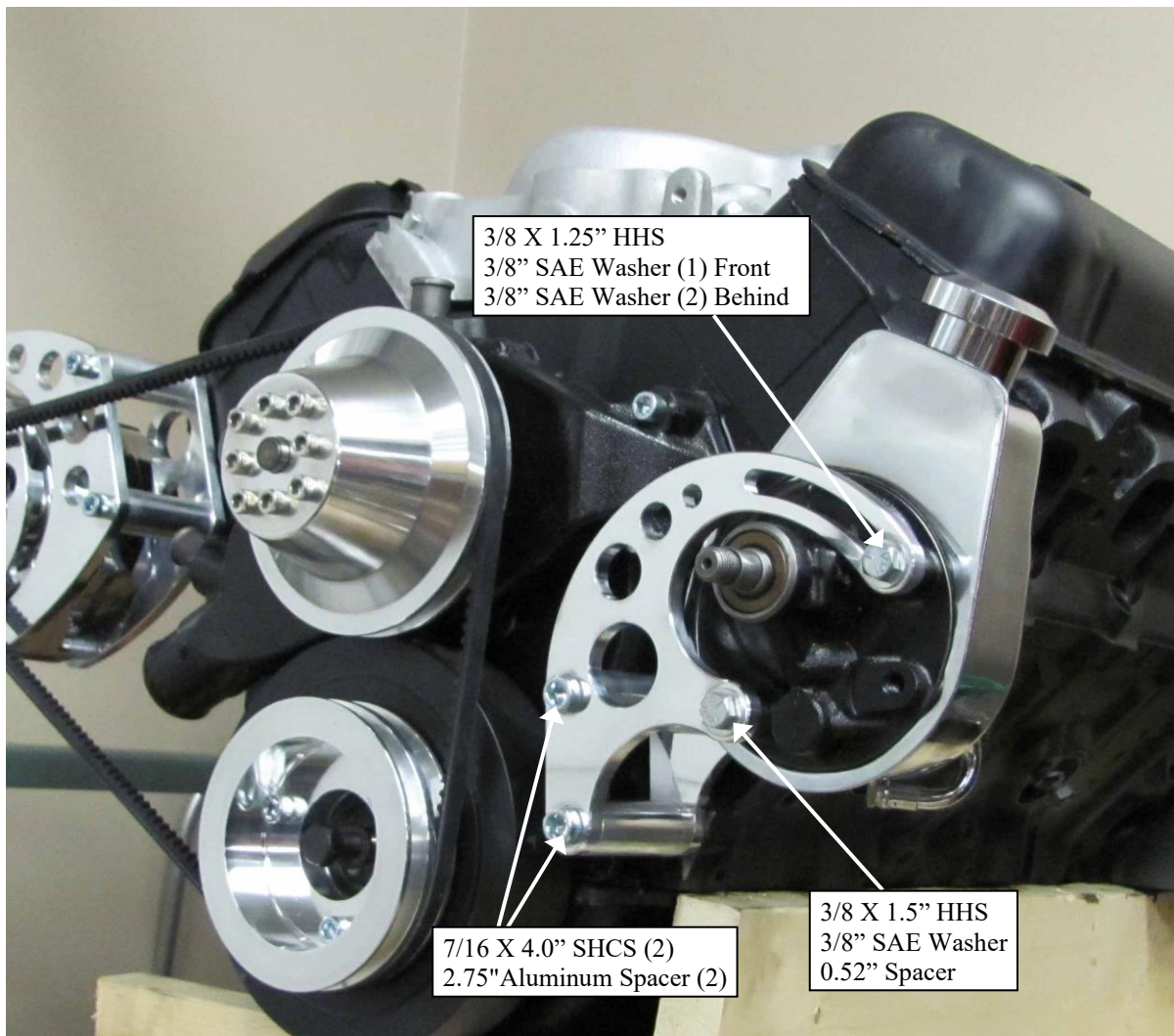


## 454-PSBRKT-C-SWP Instructions Rev C

### Chevy Big Block Power Steering Bracket Parts List Mechanical or Electric Water Pump Applications – SWP Pulleys

Item	Description	Qty	Comments
1	7/16-14 X 4.0" SHCS	2	Power Steering Bracket to Engine Block
2	3/8-16 X 1.0" HHS	1	Rear bracket to back of Pump
3	3/8-16 X 1.25" HHS	1	Front Bracket to Pump (top bolt)
4	3/8-16 X 1.5" HHS	1	Front Bracket to Pump (bottom bolt)
5	P/N 6257722-052 (0.52" Spacer)	1	Spacer between Bracket and Pump (Bottom bolt)
6	P/N 6957722-2750 (2.75" Steel Spacer)	2	Spacer between Front and Rear Bracket
7	3/8 SAE Washer	6	Washer / Spacer – Multiple locations
8	P/N 454577-R	1	Rear Bracket
9	P/N 454577-C	1	Main Front Bracket
	Total Parts	<b>16</b>	8X6X2 BOX

Notes: SHCS = Socket Head Cap Screw, BHCS = Button Head Cap Screw, HHS = Hex Head Screw



Step 1: Remove old power steering bracket.

**IMPORTANT:** Do not tighten any bolts until the end.

Step 2: Attach Front and Rear power steering bracket to engine block using 4.0" SHCS, with 2.75" Spacers between the brackets

Step 3: Attach Power Steering pump to Bracket using:

Bottom Bolt: 3/8 X 1.5" HHS, washer and 0.52" spacer.

Top Bolt: 3/8 X 1.25" HHS, washer and 2 Washers as Spacers.

Rear Bolt: 3/8 X 1" HHS, washer and another washer as a spacer (**Remove stud from back of pump and use this supplied hardware to attach the rear bracket**).

Step 4: 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.

**Belts:** If using CVF Racing Pulleys, 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 autoparts stores sell these belts in 1" increments.

**Freeze Plugs:** Some Applications may require a shorter freeze plug on front of engine or you may need to grind the freeze plug flush to prevent it from hitting the back of pump.

**Power Steering Pulley:** Use with CVF Racing keyway power steering pulley part number SBC3PS to Align with SWP 2 Groove Crank Pulley

