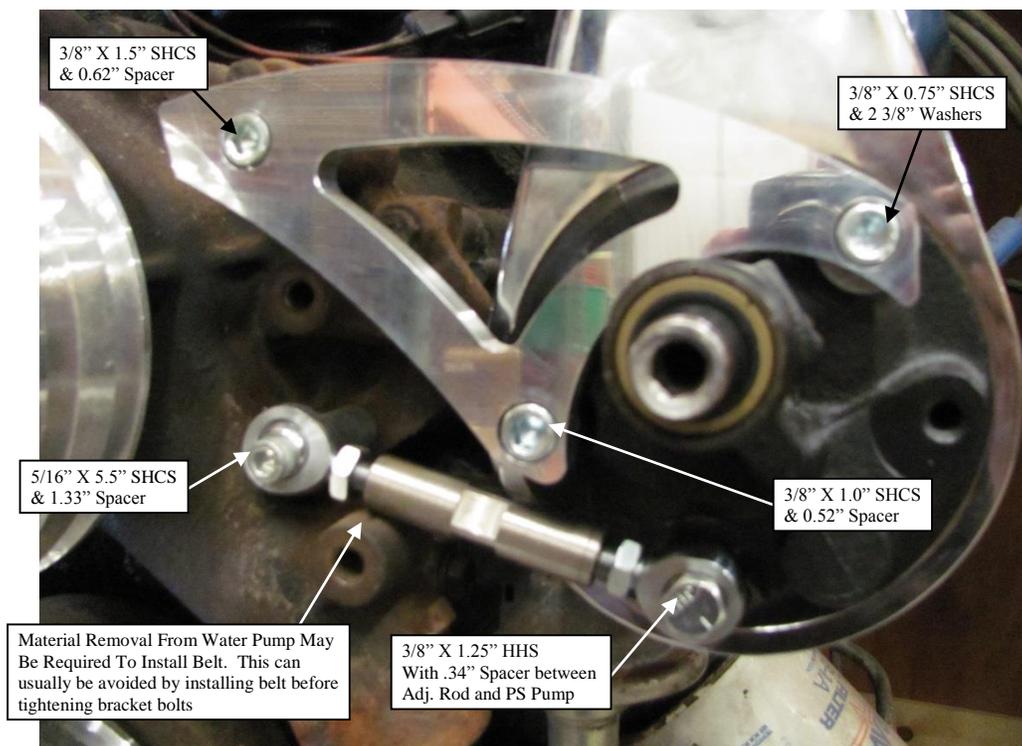


# 460-PSBRKT-S Instructions (Saginaw PS Pump) Rev D

460 Big Block Saginaw Power Steering Bracket Parts List			
Item	Description	Qty	Comments
1	3/8-16 X 0.75" SHCS	1	Main Bracket Power Steering Pump Bolt (Top)
2	3/8-16 X 1.00" SHCS	1	Main Bracket Power Steering Pump Bolt (Bottom)
3	3/8-16 X 1.50" SHCS	1	Main Bracket to Water Pump
4	3/8-16 X 1.25" HHS	1	Adjusting Rod to Power Steering Pump Bolt
5	3/8-16 X 2.00" HHS	1	Rear Support Bracket to Power Steering Pump Bolt
6	5/16-18 X 5.50" SHCS	1	Adj. Rod to Water Pump Bolt
7	7/16-14 X 2.00" SHCS	1	Rear Support Bracket to Cylinder Head
8	3/8" USS Washer	3	Washer for mounting pump to Bracket (2) Washer between bolt and Rear Support Bracket (1)
9	1.00" X 1.0" Dia Aluminum Spacer	1	Spacer between Rear Support Bracket and PS Pump
10	1.25" 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	0.34" X .625" Dia Spacer	1	Spacer between Adjusting Rod and Steering Pump
13	0.62" X .625" Dia Spacer	1	Spacer between Main Bracket and Water Pump
14	1.33" X .625" Dia Spacer	1	Spacer between Adjusting Rod and Water Pump
15	2.50" Adjusting Rod	1	Adjusting Rod
16	P/N 4605777	1	Rear Support Bracket that Bolts to Back of PS Pump
17	P/N 440677	1	Main Bracket that Bolts to Front of PS Pump
	Total Parts	<b>19</b>	

Note: SHCS = Socket Head Cap Screw, HHS = Hex Head Screw



Step 1: Remove old power steering bracket.

Step 2: Attach Main Power Steering Bracket (16) to Water Pump using 3/8 X 1.5" SHCS (4). Use 0.85" Steel spacer (12) between bracket and water pump.

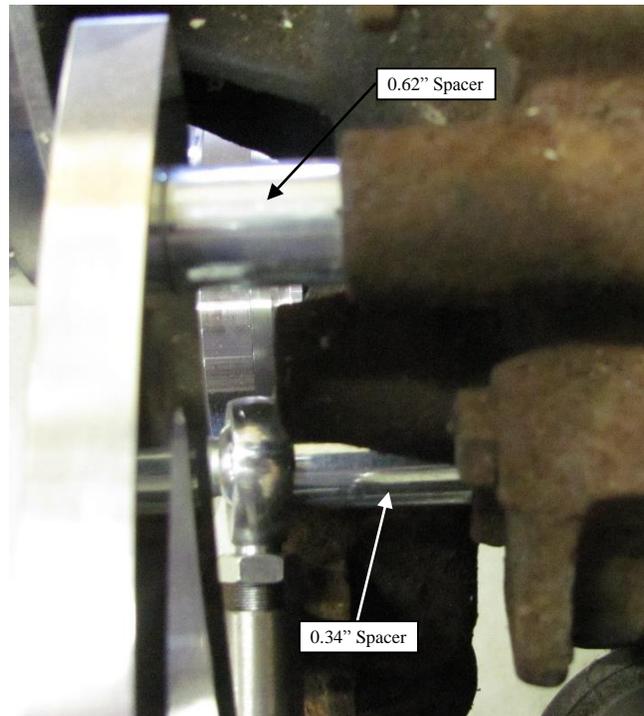
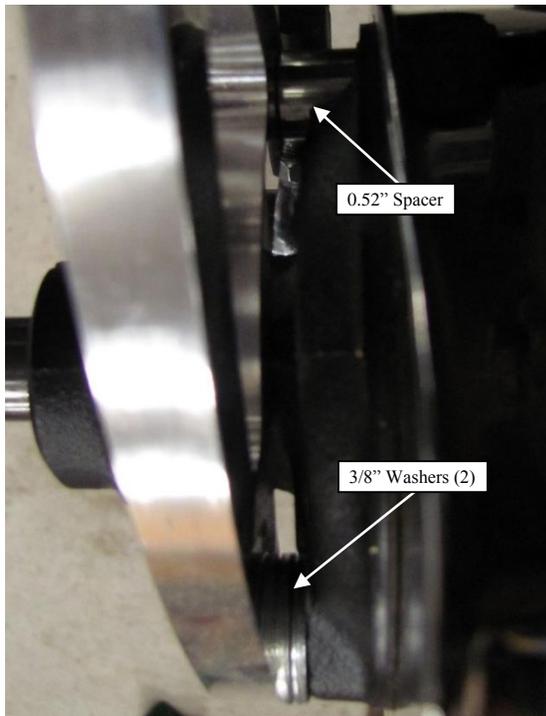
**IMPORTANT:** Do not tighten any bolts until the end.

Step 3: Attach adjusting rod to water pump with 5/16 X 5.5" SHCS (7) and 1.33" Spacer between adjusting rod and water pump.

Step 4: Attach power steering pump to main bracket using:

Top Bolt: 3/8" X 0.75" SHCS (1) and two 3/8" Washers (7) between the bracket and pump.

Bottom Bolt: 3/8" X 1.0" SHCS (2) and 0.52" Steel Spacer (10a) between the bracket and pump.



Step 5: Attach adjusting Rod to power steering pump using 3/8 X 1.25" HHS with 0.34" Steel Spacer between pump and adjusting rod.

Step 6: Attach rear support bracket to cylinder head using 7/16" X 2.00" SHCS with 1.25" Aluminum Spacer between bracket and cylinder Head.

Step 7: Attach rear support bracket to power steering pump using 3/8" X 2.00" HHS, 3/8" Washer and 1.00" Aluminum Spacer between bracket and pump.

Step 8: Tighten all bolts except the ones that will need to move during belt tensioning.

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

