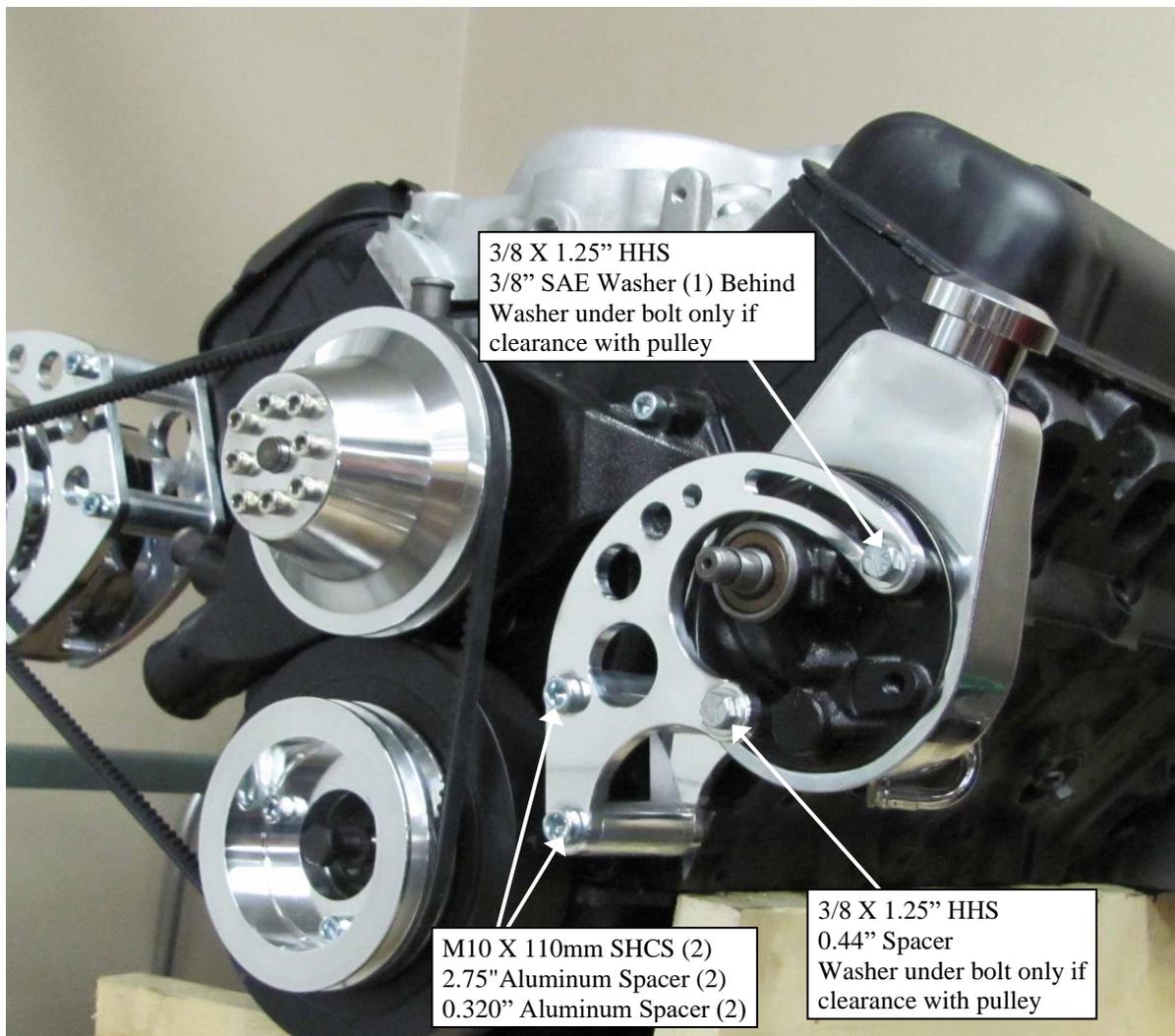


L18-PSBRKT-C-SERP Instructions Rev A

Chevy Big Block Power Steering Bracket Parts List Mechanical or Electric Water Pump – Serpentine Pulleys

Item	Description	Qty	Comments
1	M10-1.5mm x 110mm	2	Power Steering Bracket to Engine Block
2	3/8-16 X 1.0" HHS	2	Rear bracket to back of Pump Front Bracket to Pump (top bolt)
3	3/8-16 X 1.25" HHS	1	Front Bracket to Pump (bottom bolt)
4	P/N 6257722-044 (0.44" Spacer)	1	Spacer between Bracket and Pump (Bottom bolt)
5	P/N 10007722-312 (0.320" Alum Spacer)	2	Spacer between Rear Bracket and Engine Block
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 Bracket
	Total Parts	18	

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 M10 X 110mm SHCS, with 2.75" Spacers between the brackets. Use 0.320" Aluminum Spacer between Rear Bracket and Engine.

Step 3: Attach Power Steering pump to Bracket using:

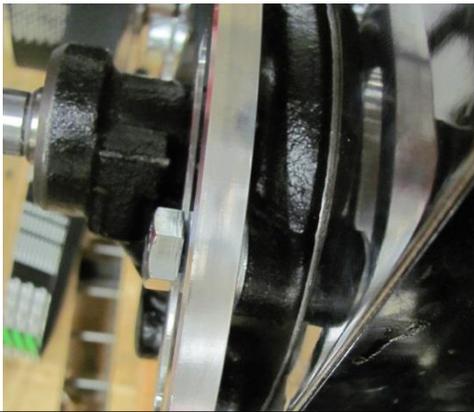
Bottom Bolt: 3/8 X 1.5" HHS, washer and 0.44" spacer.

Top Bolt: 3/8 X 1.25" HHS, washer and 1 Washer as Spacer.

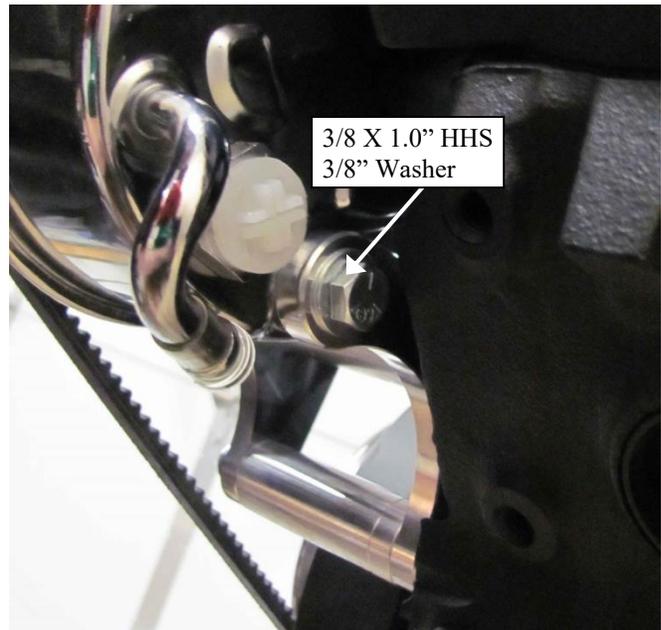
Rear Bolt: 3/8 X 1" HHS, washer and another washer as a spacer

Note: Extra washers are provided. If there is clearance between pump and bolts you can add them under the hex head bolts but often there is not enough clearance. These washers are not required for proper function of the bracket.

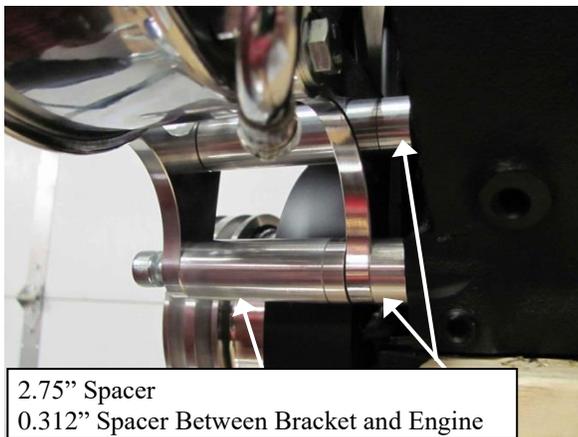
Step 4: Tighten all bolts except the ones that will need to move during belt tensioning. Install belt, set proper belt tension and tighten all remaining bolts.



3/8 X 1.0" HHS
3/8" Washer as spacer
Use 2nd washer under bolt only if clearance with pulley



3/8 X 1.0" HHS
3/8" Washer



2.75" Spacer
0.312" Spacer Between Bracket and Engine



Low Pressure Fitting Must
Be on Lower Right