



#20150

Power Steering Bracket Installation Chevy Big Block Long Water Pump

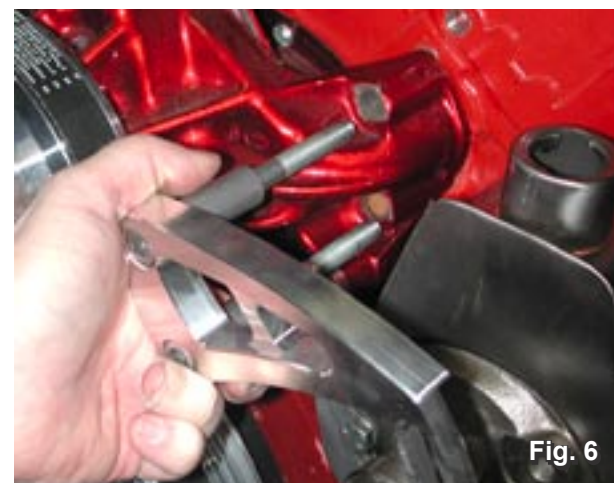
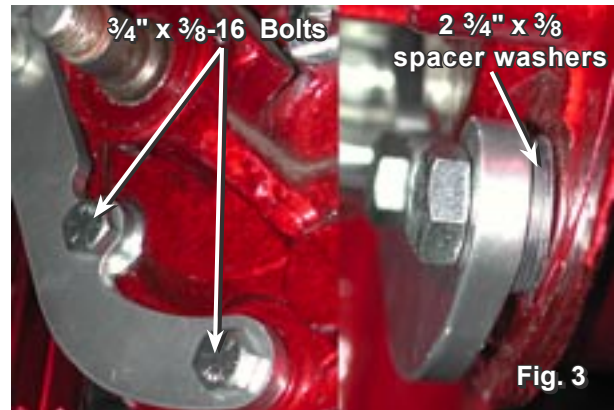
1. If your power steering pump came equipped with a mounting stud at the rear of the pump use a $1\frac{1}{16}$ " wrench to remove the mounting stud from the pump unit (fig. 1).

2. Mount the lower support brackets to the water pump using the $2\frac{3}{4}$ " x $\frac{3}{8}$ "-16 socket head bolt. Place one (1) $\frac{3}{8}$ " x 1" spacer washers between the water pump and the rear support bracket and start threads (fig. 2) (do not tighten at this time). Due to production variances in OEM and aftermarket water pumps the number of spacer washers required may change (read on).

NOTE: On some later model water pumps it may be necessary to drill the lower mounting hole through with a .406 drill.

3. Secure pump to front lower support brackets using two (2) $\frac{3}{4}$ " x $\frac{3}{8}$ "-16 hex head bolts placing four (4) $\frac{3}{8}$ " x $\frac{3}{4}$ " washer between the bracket and the pump (two washers per bolt as shown. (fig. 3) Secure pump to rear lower support brackets using one (1) $\frac{3}{4}$ " x $\frac{3}{8}$ "-16 hex head bolts placing four (1) $\frac{3}{8}$ " x 1" washer between the bracket and the pump as shown. (fig. 4) Snug down bolts at pump and at water pump (fig. 5).

4. Mount upper bracket to water pump using two (2) $4\frac{3}{4}$ " x $\frac{3}{8}$ "-16 socket head bolts and two (2) spacer tubes. Snug down bolts at this time (fig. 6).



5. Referring to (fig. 7) check distance between upper mount bracket and power steering pump. This distance should be approximately the thickness of one (1) $\frac{3}{8}$ " x 1" spacer washer ($\frac{3}{32}$ "). If this distance is too great it may be necessary to move the pump forward. This is accomplished by moving the spacer from the lower bracket to water pump mount forward from the rear bracket position to the front bracket (fig. 8). Moving this spacer will move the pump forward approximately $\frac{3}{32}$ ".

6. Once proper pump to upper bracket spacing has been achieved secure the pump to the upper mounting bracket using one (1) $\frac{3}{4}$ " x $\frac{3}{8}$ "-16 hex head head bolt with a $\frac{3}{4}$ " washer in front of the upper bracket and a 1" washer between the power steering pump and the upper bracket (fig. 9). All other mounting bolts may be tighten at this time.

7. Mount power steering pulley to pump shaft and secure with a proper nut. recheck power steering to crank pulley alignment. install belt and adjust belt tension by pulling up on power steering pump. Belt tension is correct when there is no more than $\frac{1}{4}$ " play in the belt at mid point between the power steering pulley and the crank pulley. Lock the belt tension by tightening the adjustment bolt with a $\frac{9}{16}$ " opened wrench (fig. 10).

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