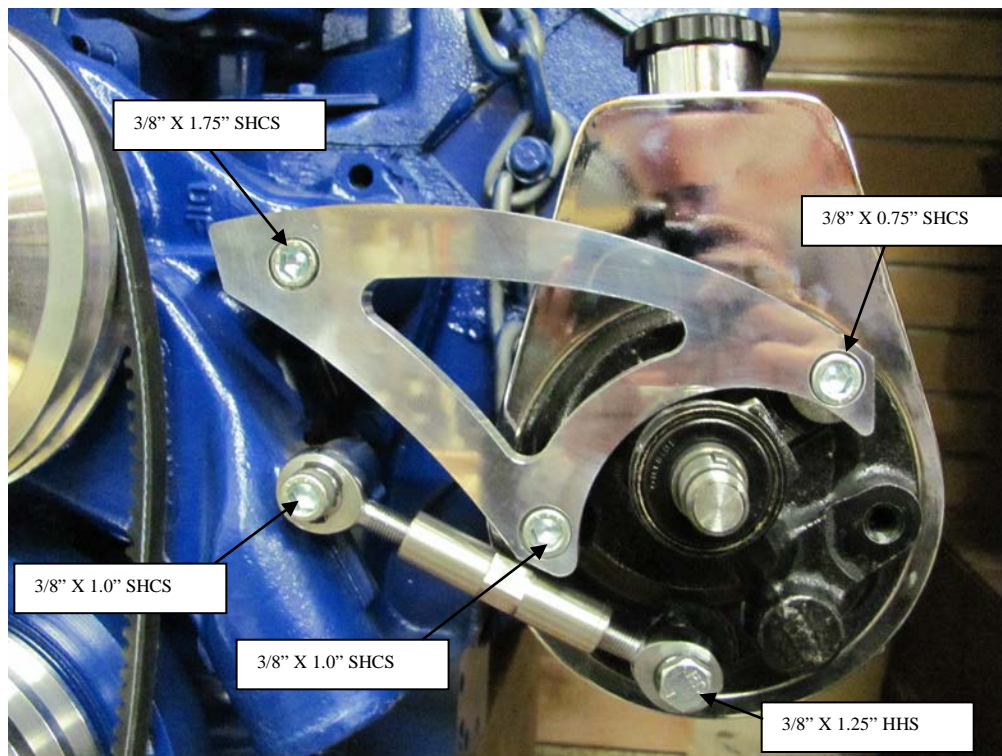


390-PSBRKT-S Instructions (Saginaw PS Pump) Rev C

390 FE Engine Saginaw Power Steering Bracket Parts List			
Item	Description	Qty	Comments
1	3/8-16 X ¾" SHCS	1	Main Bracket Power Steering Pump Bolt (Top)
2	3/8-16 X 1.0" SHCS	2	Main Bracket Power Steering Pump Bolt (Bottom) Adj. Rod to Water Pump Pump Bolt
4	3/8-16 X 1.75" SHCS	1	Main Bracket to Water Pump
3	3/8-16 X 2.0" SHCS	1	Rear Support Bracket to Power Steering Pump Bolt
5	3/8-16 X 1.25" HHS	1	Adj. Rod to Water Pump Pump Bolt
6	3/8-16 X 2.25" HHS	1	Rear Support Bracket to Cylinder Head
7	3/8" USS Washer	3	Washer for mounting pump to Bracket (2) Washer between bolt and Rear Support Bracket (1)
8	1.0" X 1.25" Dia Aluminum Spacer	1	Spacer between Rear Support Bracket and PS Pump
9	1.0" X 1.25" Dia Aluminum Spacer	1	Spacer between Rear Support Bracket and Cylinder Head
10	.340" X .625" Dia Spacer	1	Spacer between Adjusting Rod and Steering Pump
11	.520" X .625" Dia Spacer	1	Spacer between Bracket and Steering Pump
12	1.04" X .625" Dia Spacer	1	Spacer between Main Bracket and Water Pump
13	2.50" Adjusting Rod	1	Adjusting Rod
14	390 Rear Support Bracket	1	Bracket that Bolts to Back of PS Pump
15	Main Bracket (P/N 440677)	1	Bracket that Bolts to Front of PS Pump
	Note: SHCS = Socket Head Cap Screw HHS = Hex Head Screw		



Step 1: Remove old power steering bracket.

Step 2: Attach Main Power Steering Bracket (14) to Water Pump using 3/8 X 1.75" SHCS (4). Use 1.04" Steel spacer (11) between bracket and water pump.

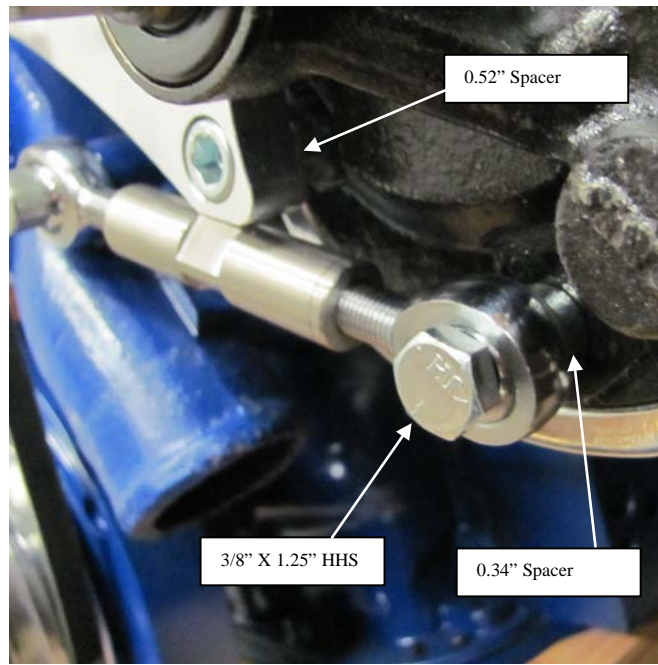
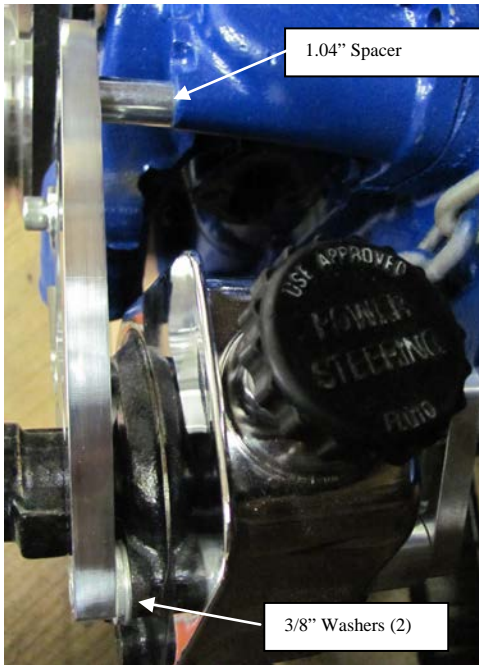
IMPORTANT: Do not tighten any bolts until the end.

Step 3: Attach adjusting rod to water pump with 3/8 X 1.0" SHCS (2).

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 between the bracket and pump.



Step 5: Attach adjusting Rod to power steering pump using 3/8 X 1.0" SHCS with 0.34" Steel Spacer between pump and adjusting rod.

Step 6: Attach rear support bracket to cylinder head using 3/8" X 2.25" HHS, 3/8" Washer and 1.25" Aluminum Spacer between bracket and cylinder head.

Step 7: Attach rear support bracket to power steering pump using 3/8" X 2.0" SHCS (3) with 1.25" 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.

