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INSTALLATION INSTRUCTIONS

1955-1957 CHEVROLET SB 500 BOX POWER STEERING CONVERSION

THE KIT INCLUDES

- 1) 500 STEERING BOX
- 1) POWER STEERING PUMP
- 2) HOSES (1 HIGH PRESSURE & 1 LOW PRESSURE)
- 1) SET OF PUMP BRACKETS
- 1) RAG JOINT (optional)
- 1) "STACK-ON" PULLEY FOR CRANKSHAFT

VEHICLE PREP AND DISASSEMBLY

It is a tight fit in the front of your engine compartment, so it is highly advisable that you remove the fan and shroud and radiator before starting to give yourself a little working room.

1. Unbolt your steering column and remove it completely to give yourself some room to work.
2. Remove the manual steering box.

Steps 3-4 are for FRONT MOUNT ONLY (skip these steps if you have a side mount bracket)

3. Support or lift the engine slightly.
4. Remove the original front motor mount to make room for the front lower pump mount bracket.
 - Save the motor mount bushings to be reused when you install the front power steering pump mount.

POWER STEERING ASSEMBLY

(STEPS 5-9 ARE FOR SIDE MOUNT STEERING PUMP BRACKETS, SKIP TO STEPS 10-13 IF YOU HAVE THE FRONT MOUNT STEERING PUMP BRACKETS)

Small blocks come with all the bolt holes for the power steering pump brackets pre-drilled.

Small Block Side Mount Pump Bracket Install (steps 5-9)

5. Locate the 3 holes marked with circles in this picture that will be used to bolt your power steering pump brackets to the block.



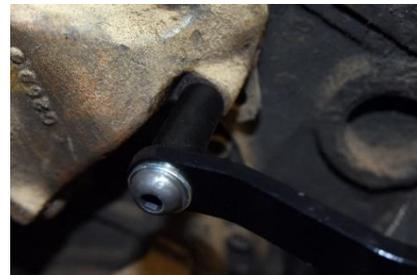
6. Ensure your lower bracket is assembled as pictured here to install properly on the block.



7. Bolt the lower bracket into place on the block into the lower 2 holes identified in the picture above.
- You may choose to only install the bolts hand tight until you finish the install with the pump.



8. Install the upper adjusting bracket into the lower water pump bolt hole as shown in this picture.
- Be sure to use the short 1" spacer between the bracket and the water pump as show in this picture.
 - You may choose to only install the bolt hand tight until you finish the install with the pump.



9. Bolt the new power steering pump to the brackets using the bolt holes in the pump identified in this picture.
- If you did not tighten the bolts on the brackets do so now.



Small Block Front Mount Pump Bracket Install (steps 10-13)

You should already have your motor supported and the original front motor mount removed from the car.

Locate the 3 holes marked with circles in this picture that will be used to bolt your power steering pump brackets to the block.



10. Bolt the lower bracket into place on the block into the lower 2 holes identified in the picture above.

- You will want to tighten these bolts prior to the next step.



11. Reinstall the motor mount bushings and hardware and allow the engine to rest again on the new mount.

12. Install the upper adjusting bracket into the lower water pump bolt hole as shown in this picture.

- Notice the bend in the bracket going backward toward the block so the bracket can go to the back of the pump when installed.
- You may choose to only install the bolt hand tight until you finish the install with the pump.



13. Bolt the new power steering pump to the brackets using the bolt holes in the pump identified in the pictures below.

- Take note that the lower bracket bolts to the front and back and the adjuster bracket bolts to the back of the pump.
- If you did not tighten the bolts on the brackets do so now.



Resume instructions for both style of brackets (Side Mount and Front Mount)

14. Bolt the new 500 box into place on the frame.
 - The holes are already in the frame to mount this new box.
15. Install both the high-pressure and low-pressure hoses.
16. Install the stack-on crank pulley.
17. Purchase and install the appropriate belt.
18. Adjust the pump as needed to get the necessary tension on the belt.

The final steps of connecting the steering shaft to the new steering box will need to be determined by you taking into consideration the column you are using and what parts you have available. Auto City Classic does have a wide range of rag joints, u-joints, and DD bars available.

