



Power Steering Straight Axle Installation Instructions

1. Remove stock steering components and steering arms. On F-1 Fords, it is necessary to cut one steering arm off, then grind smooth the spindle. (figure 1.)



figure 1:

2. Bolt steering arms on. We provide you with 3 washers per bolt. Use one washer to space the steering arm away from the spindle. (figure 2, 3.)

figure 2:

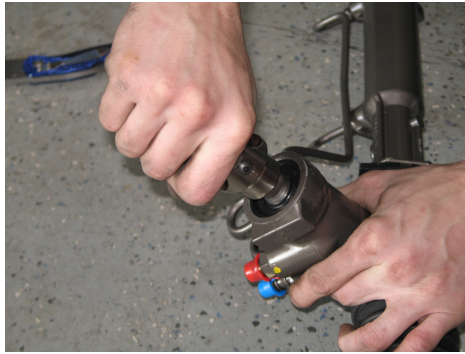


figure 3:



3. Rack preparation – Turn the rack input clockwise (right turn, figure 4) until it stops. Then, turn it back counter clockwise (left turn) until it stops, while counting the turns (should be $3 \frac{1}{8}'' \pm$). Turn it clockwise $\frac{1}{2}$ way back (approx. $1 \frac{1}{2}$ turns). Now the rack is centered in its travel. *If you don't do this, don't call for help!* - Using the provided U-joint makes it easier to turn.

figure 4:



4. Install mounting brackets as shown in photos (figure 5, 6).

figure 5:

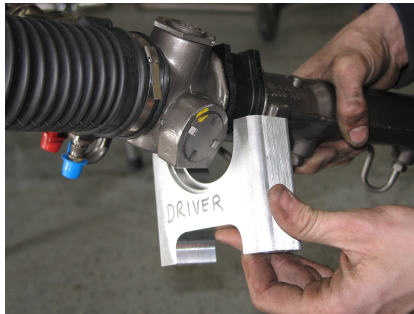


figure 6:



5. There are two different mounts on passenger, on driver side (figure 7). The drivers side mount uses a rubber insulator. Fit the top clamp and snug the 4 bolts (figure 8). The passenger side is a solid mount. Just snug up the 4 bolts. -

figure 7:



figure 8:



6. At this time, fit in the vent tube as shown, through the passenger rack clamp, and into both rack boots (figure 9-11).

figure 9:

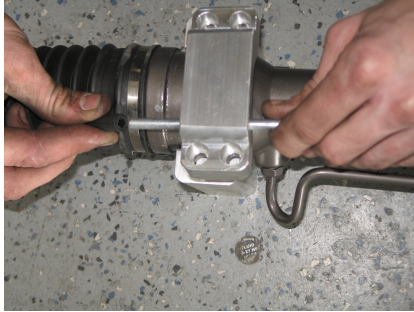
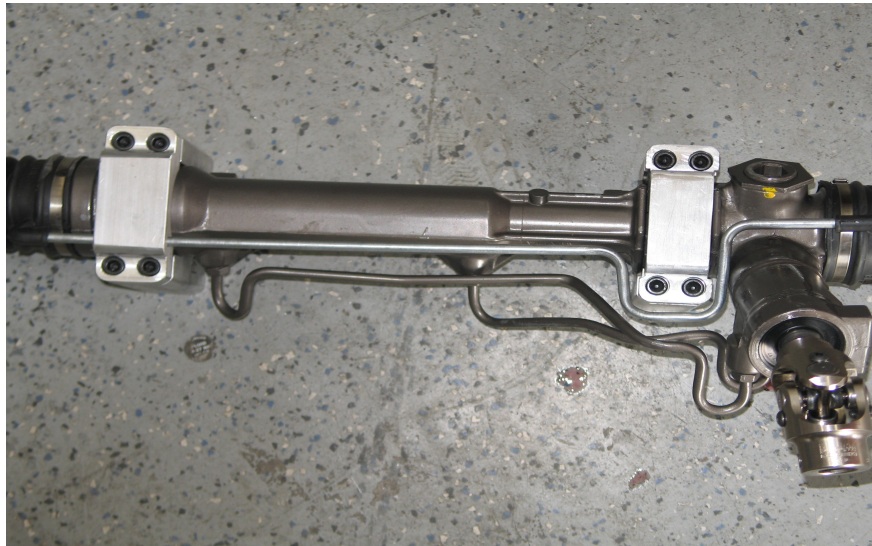


figure 10:



figure 11:



7. Fit the rack to the axle (figure 13). Loosely bolt the axle clamps to the rack mounts. **Center the rack** - This does not mean the clamps or the rack body, but from the tie rod ends to the steering arms, with the spindles straight (figure 12).

figure 13:



figure 12:



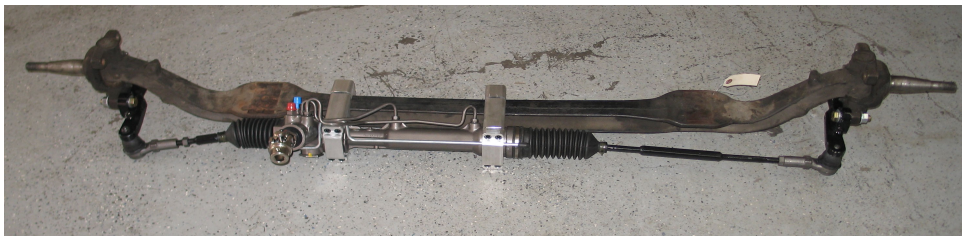
8. Tighten all rack mount bolts, torque to 30 ft/lbs (figure 14). - If you strip it, you own it!

figure 14:



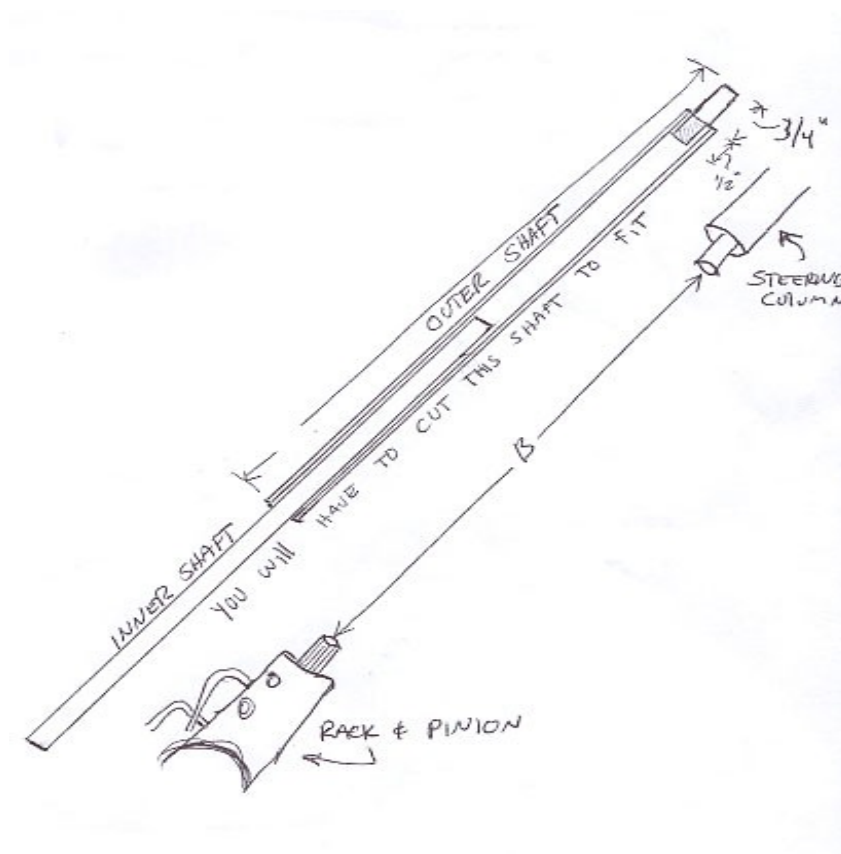
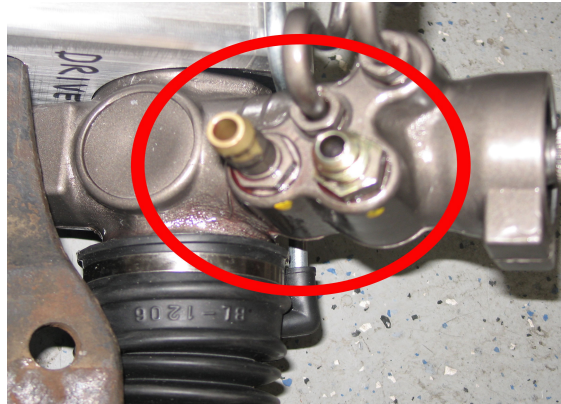
9. Install the outer tie rod ends and jam nuts (figure 15). They should be even on both sides (figure 16).

figure 15:



10. Slip shaft and column – see last page

11. P/S hoses. We supplied fittings in the rack. The high pressure fitting is a #6 A.N. The return is 3/8 hose. Any pump is fine. We suggest a remote reservoir for additional fluid capacity.



SLIP SHAFT FITMENT

With the front shocks in place, jack up the chassis so that the axle is in full "hang".

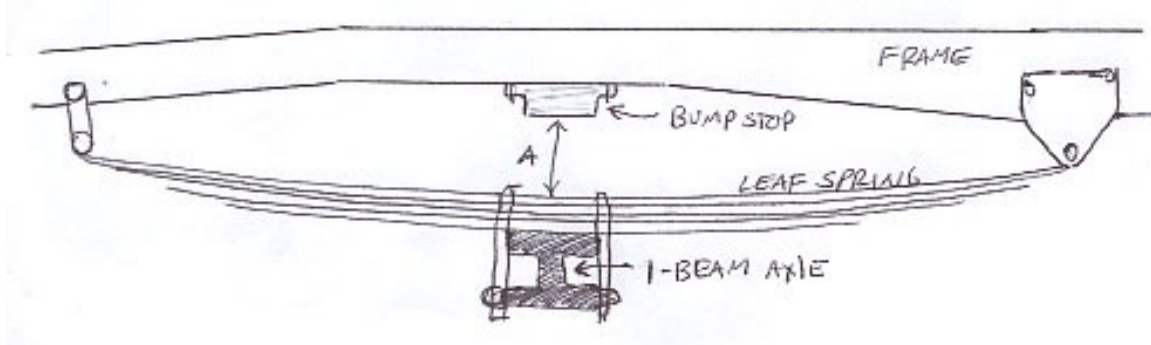


figure 16:

1. Measure from the bump stop to the spring
A. _____
2. Measure from the end of the rack, to the end of the steering column.
(fig 18)
B. _____
3. Calculate total slip shaft travel. Multiply 'A' x .8
= _____
Shaft Travel
4. Calculate total shaft length -- Extended
 $B - 3" =$ _____ Extended Length
5. Calculate total shaft length -- Collapsed
Extended Length (from #4) - Shaft travel (from #3) = _____
collapsed length

Cut the outer shaft to 'collapsed length' - 1" _____

Cut the inner shaft to 'collapsed length' - 2 1/4" _____