

**ADDITIONAL INSTALLATION PARTS AVAILABLE:**

Part #	Description
<b>Rag Joints, Shaft, Drag Link Adapter.</b>	
052543	1967-1982 Rag joint, 1"-48 spline x 11/16"-36 spline. Connects power box to 1"-48 spline column.
052534	1963-1966 Rag joint, 3/4"-36 spline x 11/16"-36 spline. Connects power box to 3/4"-36 spline column.
990046	1963-1966 Replacement inner steering column shaft for Borgeson 800138 conversion box.
990002	1963-1982 Drag Link Adapter for cars with factory installed power steering.
<b>Power Steering Pumps, Pump Brackets, Pulleys and Hoses.</b>	
925115	OEM Style rubber power steering hose set to connect new box to P/S Pump.
800308	GM Saginaw self-contained power steering pump, with early GM style return tube.
802400	Power Steering Pump Bracket for small block Chevy with short water pump.

**REMOVAL:**

- **Cars with manual steering.** Disconnect column coupler at steering box. Remove Pitman arm from steering box and relay rod. Remove bolts holding original steering box and remove it from car.
- **Cars with power steering.** Disconnect column coupler at steering box. Remove Pitman arm from steering box and relay rod. Remove bolts holding original steering box and remove it from car. **Remove** factory ram assembly, control valve, and hoses. (Once flushed clean your original pump may be used.)
- **Steering column removal. (Optional)** Depending on available space and access to a lift you may want to remove your steering column for ease of installation. Loosen or remove the bolts attaching the steering column to dash and floor. Disconnect factory wiring from column. Slide column back and remove from the car. The column will need to be modified to complete the installation. (Detailed Below)

**INSTALLATION:**

**NOTE: Manual steering Relay-Rod or Drag Link Adapter #990002 will be required on cars with factory ram assist style power steering.**

**NOTE: Slight modifications are required to original steering column. (Detailed Below)**

- Install the proper rag joint coupler on to the steering box and center the steering box prior to installation. Bolt the new steering box to the frame. Check that the front of the steering box is not making contact with the frame, or any surrounding brake lines. **Do not grind or alter the steering box.**
- **1963-1966 Column modifications.** Install replacement steering column shaft #990046 or trim 2-1/4" off of the factory steering column shaft spline. **Be sure to leave enough spline for rag joint if trimming the column shaft.**
- **1967-1982 Column modifications.** Gently tap the collapsible column shaft into the column 2-1/4" for the needed clearance. Protect the spline with a block of wood or use a dead blow hammer. **Do not collapse the shaft too far; it can be difficult to get back out.**

*Continued on back,*

## INSTALLATION CONT.

- Reinstall your modified column and be sure to securely fasten all original mounting bolts and hardware. Securely tighten all setscrews and then loc nuts on the rag joint. The existing flat spot on the steering column shaft is not intended to be used for the set screw. Use of this flat spot can cause the steering wheel to be crooked after installation. It will be necessary to file a small flat for the set screw to seat into when installing.
- Original power steering cars will need to install #990002 Drag link adapter or manual steering relay rod at this point.
- Connect Pitman arm to steering box and relay rod and tighten both connections. With the front tires off the ground slowly move the steering through its full range of motion to insure there is no binding or interference.
- If your car is factory manual steering, install the proper pump, bracket and pulley for your application.
- This steering box uses 16mm x 1.5 flare hose connections. The high-pressure port is located closest to the engine and the low pressure return port is closest to the fender / firewall. Connect to the Saginaw self-contained style pump with hose kit #925115
- Ensure fittings are sealed and properly tightened and then slowly fill the pump with GM power steering fluid such as an AC Delco 10-5073 or equivalent. GM Dexron III transmission fluid may also be used.
- With the engine running check new system for leaks and bleed off any air trapped in the system by slowly turning the wheel full left to full right with the wheels off the ground. ***Be sure to keep fluid full.***
- ***It is recommended to get a complete alignment. We recommend increasing caster to 3-4 degrees positive.***