

NOTES:

The crimped fittings are to be installed at the steering box or rack and pinion connections.

Hose kit includes 3' of PTFE pressure hose and 3' of rubber return hose. Make sure the PTFE hose is used for the pressure connection. Failure to do so can cause hose failure and damage to people and property.

Crush washers are single use. Replacements are a standard M16 X 22 X 2 copper crush washer.

Installation, Pressure Hose Connections:

- 1)** Identify PTFE lined hose, this is the pressure hose and is the smaller diameter hose identified by the white rigid lining. Match with proper banjo bolt for pressure connection.
- 2)** Dry fit line to determine final length needed and mark hose to cut. Tightly wrap area to be cut in masking tape to protect hose and prevent fraying. Cut braided hose with a narrow abrasive cutoff wheel. While still taped dress on belt sander if needed. Blow out any debris from cutting. A good square cut is necessary for proper assembly.
- 3)** Assemble power steering pump pressure fitting. Unscrew the outer nut from the pump pressure fitting and slide it over the taped cut hose end with the threads toward the cut end. Remove tape, insert brass olive, tapered end first between the outer braiding and the inner Teflon liner until the Teflon liner bottoms out on the stop ridge. Insert the threaded barbed banjo fitting into the pressure hose. Slide outer nut up and thread onto banjo fitting. Verify hose clocking and orientation before tightening. Tighten with a crow's foot, torque to 20 ft. lbs.
- 4)** Install one copper crush washer over banjo bolts and insert banjo bolts through fittings. Install second copper crush washer under banjo fittings. Thread fittings into pressure ports on the box and pump and torque to 40 ft. lbs.
- 5) 925131 Hose kit only.** Insert 18mm stud into steering box. Slide one crush washer over stud. Slide banjo fitting over stud. Install another crush washer then the cap nut. Torque cap nut to 40ft. lbs.

Installation, Return Hose Connections:

- 1)** Identify rubber lined hose, this is the return hose and is identified by the standard black rubber lining. Match with proper banjo bolt for return connection.
- 2)** Dry fit line to determine final length needed and mark hose to cut. Wrap area to be cut in masking tape to protect hose and prevent fraying. Cut braided hose with a narrow abrasive cutoff wheel. While still taped dress on belt sander if needed. Blow out any debris from cutting.
- 2)** Install one copper crush washer over banjo bolt and insert banjo bolt through fitting. Install second copper crush washer under banjo fitting. Thread fitting into steering box or rack return port and torque to 40 ft. lbs.
- 3)** Slide the hose clamp trim cover over the cut end of the hose. Install the hose onto the return hose barb of the power steering pump. Position the trim cover and then tighten the hose clamp.