



Steering, Brake & Suspension Specialists

# #M21400-P736 Installation Instructions

## for Mustang II Power Rack & Pinion

### Rack and Pinion Specifications:

Input shaft is 3/4"-36 splined shaft.  
 Pressure fitting is -6AN. The pressure port is M14-1.5 O-ring.  
 (High pressure from the pump into the rack.)  
 The return fitting is -6AN. The return port is M16-1.5 O-ring.  
 (Low pressure from the rack into the reservoir.)  
 Tie rod thread is 9/16-18.

### Recommendations:

Power steering reservoir part #19-6969SB (black) or #19-6969SB-C (Chrome) is ideal for most small block Chevrolet installations.  
 Power steering reservoir part #19-6969BB (black) or #19-6969BB-C (Chrome) is ideal for most big block Chevrolet installations.  
 Power steering pump part #19-PUMP.  
 Hose kit part #M2PSH-RT.  
 Rack extender 1" part #300-3234-16.  
 Rack extender 2" part #300-3232-16.  
 Outer tie rod 3.4" part #ES429R.  
 Outer tie rod 5.0" part #ES2128.

### General Applications for Rack Extenders:

23-1/4" arm to arm and 2-1/2" arm to rack uses a 1" extender on the passenger side.  
 23-1/4" arm to arm and 3-1/2" arm to rack uses a 1" extender on the driver side.  
 24-1/4" arm to arm and 3-1/2" arm to rack uses a 1" extender on each side.  
 24-1/4" arm to arm and 2-1/2" arm to rack uses a 2" extender on the passenger side.  
 24-1/4" arm to arm and 4-1/2" arm to rack uses a 2" extender on the driver side.  
 26-1/4" arm to arm and 4-1/2" arm to rack uses a 2" extender on each side.  
 26-1/4" arm to arm and 2-1/2" arm to rack uses a 4" extender on the passenger side.  
 26-1/4" arm to arm and 6-1/2" arm to rack uses a 4" extender on the driver side.

### Heidt's recommendations for rack extenders:

48-64 Ford Pickups, 55-59 Chevrolet pickups, and 60-1/2" track width uses a 2" extender on each side.

### TCI's recommendations for rack extenders:

48-64 Ford Pickups, and 55-59 Chevrolet pickups uses a 2" extender on the drivers side.  
 49-54 Chevrolet car and all Corvette use a 1" extender on the drivers side.  
 35-40 Ford car & pickup and 47-54 Chevrolet pickup do not use extenders.

### Fat Man's recommendations for rack extenders:

All extenders will go on the passenger side.

### Instructions:

- Using the 2 mounting bolts and mounting bushings bolt the rack and pinion onto its mount; the flanged side of the bushing will be towards the crossmember. The mounting bolts are spaced 15-1/2" apart. The mounting bolts are 5/8" diameter. Some installations may need to use the rack and pinion spacers.
- Connect the steering shafts from the column to the rack and pinion. The rack and pinion will move on its mounts. The frame will flex. The body will flex and move on its mounts. Make sure the steering shafts can allow for this movement without binding or transferring any forces into the rack and pinion or the steering column. We recommend using 2 U-Joints in the steering shafts; one at the steering column, and one at the rack and pinion.
- Install the rack extenders if needed. Some applications will require the use of rack extenders. They are installed on the end of the rack/piston. To install the extender, start by removing the clamp on the rubber boot where the extender needs to be. Carefully remove the rubber boot from the end of the rack housing. Remove the inner tie rod. Install the rack extender on the end of the rack/piston shaft. Re-install the inner tie rod onto the rack extender. Re-install the rubber boot onto the rack housing. Re-install the clamp on the rubber boot.
- Install the outer tie rods onto the inner tie rods. Adjust the toe in to 1/16" of toe in for now. Be sure to have the vehicle professionally aligned after the vehicle is completed. Tighten the jam nuts against the outer tie rods.
- Connect the high pressure hose from the power steering pump to the lower fitting on the rack and pinion. Connect the other end of the high pressure hose to the fitting on the power steering pump. Always use new clean hoses, pump, and reservoir. Re-using old or dirty parts will contaminate the new rack and pinion, and can prevent the rack from working correctly. **Warning: The warranty will be void if the hoses are connected**

### GENERAL TORQUE SPECIFICATIONS:

1/4"	grade 5	10lb/ft	1/4"	grade 8	14lb/ft
5/16"	grade 5	19lb/ft	5/16"	grade 8	29lb/ft
3/8"	grade 5	33lb/ft	3/8"	grade 8	47lb/ft
7/16"	grade 5	54lb/ft	7/16"	grade 8	78lb/ft
1/2"	grade 5	78lb/ft	1/2"	grade 8	119lb/ft
9/16"	grade 5	114lb/ft	9/16"	grade 8	169lb/ft
5/8"	grade 5	154lb/ft	5/8"	grade 8	230lb/ft

