

INSTRUCTIONS

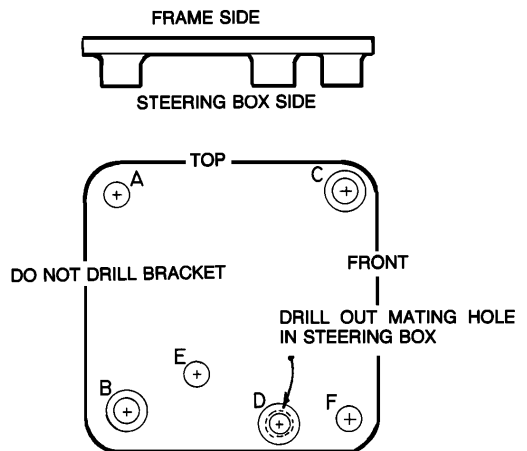
916-32004

INSTALLATION INSTRUCTIONS SAGINAW STEERING BOX INTO A 1941 TO 1948 FORD

- **Before you start, take inventory. You should have the following parts:**

- 1 - **GM Saginaw Steering Box**
- 1 - **'37 - '48 Ford**
- 1 - **Mounting Bracket (KIT)**
- 3 - **7/16" UNC X 1" Bolts (KIT)**
- 1 - **7/16" UNC X 1 1/4" Bolt (KIT)**
- 1 - **7/16" UNC X 1 1/2" Bolt (KIT)**
- 1 - **7/16" UNC X 1 3/4" Bolt (KIT)**
- 5 - **7/6" Lock Washers (KIT)**
- 2 - **7/16" UNC Nuts (KIT)**

- To begin the installation, it is suggested that the left side of the exhaust be removed. (Depending on the engine you have, you may need to change the exhaust routing). We recommend that you not purchase your exhaust system until after you have installed your steering box and have identified the clearance requirements.
- Remove the old Ford steering box and column.
- If the steering arm on the Saginaw Steering Box does not point forward, remove it, (you may have to heat it and use a puller). Set the arm aside for later installation.
- For the following instructions, refer to illustration. A slight modification of the Saginaw steering box is required. The tapped hole "D" must be drilled out to 1/2", and the cast gussets on the box must be filed down. A bolt will be installed through this hole and into the bracket at the tapped hole "D".
- Fasten the bracket to the frame by installing 1" bolts through hole "E" and "F". Assemble nuts and lockwashers inside the frame and tighten finger tight.
- Install the 1 1/4" bolt into the hole you drilled in the steering box at hole "D". Note that no lockwasher or nut is required.
- Position the box against the bracket and screw the bolt in hole "D" into the steering bracket. DO NOT tighten.
- Screw the 1 3/4" bolt through the frame and bracket into hole "C". DO NOT tighten.
- Screw a 1" bolt through the bracket into hole "A", using a lockwasher under the head of the bolt. DO NOT tighten.
- Screw the 1 1/2" bolt through bracket into the box at "B", using a lockwasher under the head of the bolt.
- Tighten the bolts at "A", "B", and "D".
- The box is now loosely attached to the frame. The steering column should now be installed to determine the final position of the steering box.
- Once the box has been located, tighten the bolts at "C", "E", and "F".
- Fasten the steering column to the steering box.
- Locate the steering arm that you removed, and slide it on the shaft pointing toward the front of the car. DO NOT tighten it yet, you may need to move it again.
- Turn the steering wheel all the way to the right. Note the position of the steering arm.
- Turn the steering wheel all the way to the left. Note the position of the steering arm.
- From the travel you noted, center the steering arm. It should be pointed toward the front of the car. If it is not, take it off and position it so that it is.
- Note the angle that the arm hangs down at, and look for any interferences when the drag link is attached. If necessary, remove the arm, heat it, and bend as needed.
- Tighten the nut that is holding the steering arm on the box.
- Install your drag link.



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