

## NOTICE

TO PROTECT & PRESERVE YOUR BLACK POWDER PAINTED OR CHROME PLATED BRACKETS' FINISH, BE SURE AND APPLY A GOOD QUALITY WAX SUCH AS CARNAUBA, AS NEEDED.



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## INSTALLATION INSTRUCTIONS

**916-67961**

**501L / 502L / 503L**

**LONG WATER PUMP VERSION**

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TO MAKE INSTALLATION EASIER, PLEASE READ ALL THE INSTRUCTIONS BEFORE INSTALLING THE BRACKET.

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### BIG BLOCK / **LONG WATER PUMP** / POWER STEERING BRACKET INFORMATION

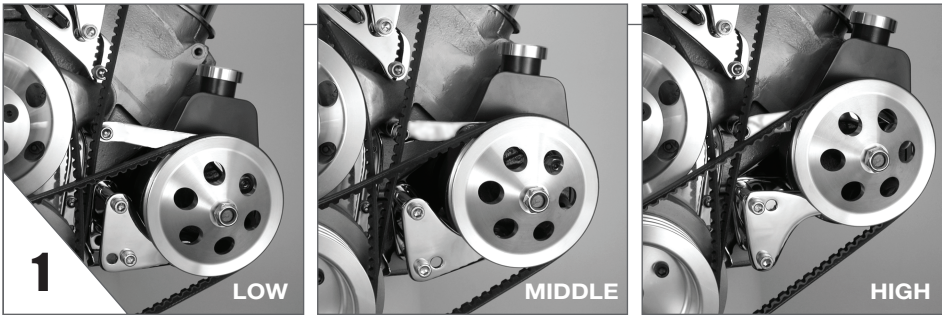
- Power Steering bracket designed for the Big Block Chevy.
- For use with the **LONG WATER PUMP**.
- The bracket mounts to the lower left front of the block using the two lower bolt holes by the timing chain cover.
- All bracket hardware is pre-assembled in the proper location as it will need be when installed.
- When installing the bracket, leave all the bolts snug but not tight UNTIL alignment of the belt, belt length and bracket positioning have been verified. If it looks good, go ahead and tighten the bolts and adjust the belt tension.
- Use LOCTITE #242 (blue) on all bolts for final assembly.

**TOOLS REQUIRED FOR INSTALLATION ARE:** 1/4" Allen Wrench, 5/16" Allen Wrench, 9/16" Wrench.

### POWER STEERING PUMP USED WITH THIS APPLICATION IS:

- **SAGINAW** Power Steering Pump with attached reservoir.  
Recommended pumps; 1971-1974 Camaro, Chevelle or Monte Carlo V-8, or the 1973-1974 Chevy Truck 6 Cyl.

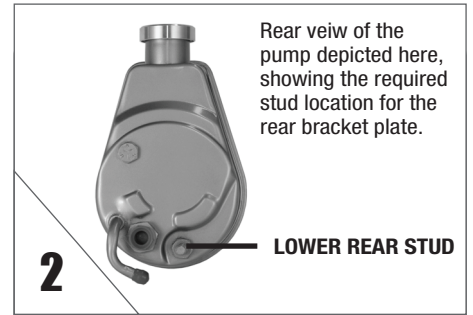
## HOW TO INSTALL YOUR BIG BLOCK CHEVY POWER STEERING BRACKET



### BEFORE INSTALLING THE BRACKET:

You will need to decide which position you would like the bracket to position the pump.

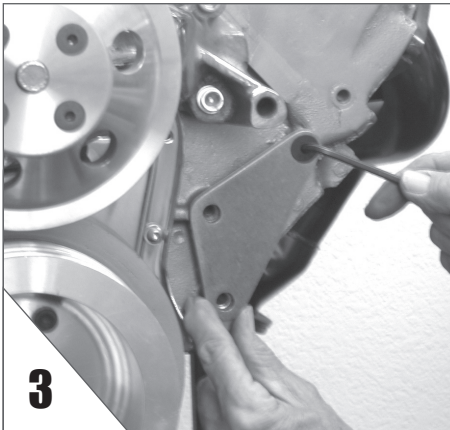
- **LOW POSITION:** Bracket comes pre-assembled in the position (as shown above - far left).
- **MIDDLE POSITION:** Simply move the lower bolt to the inside hole (as shown above - middle).
- **HIGH POSITION:** Flip over the bases and reverse the bolts (as shown above - far right).



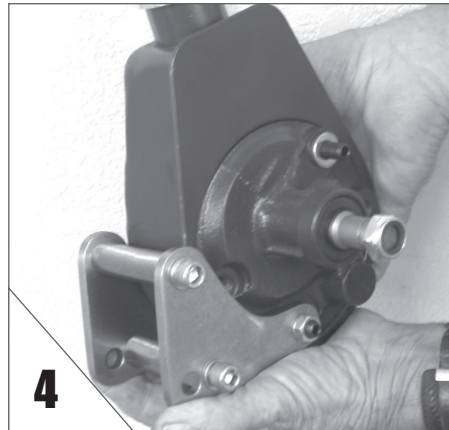
**LOWER REAR STUD** is required for installation.

Inside the shim package you will find an enclosed 3/8" nut and A.N. washer. Use them on the lower rear part of the power steering pump.

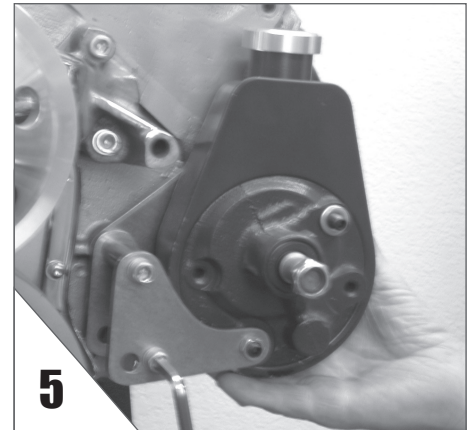
If your pump has a bolt without a stud, see your local G.M. dealer and ask for part #5689546.



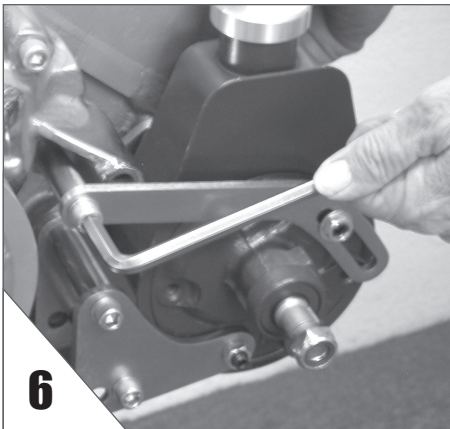
**BOLT** the spacer plate to the block.



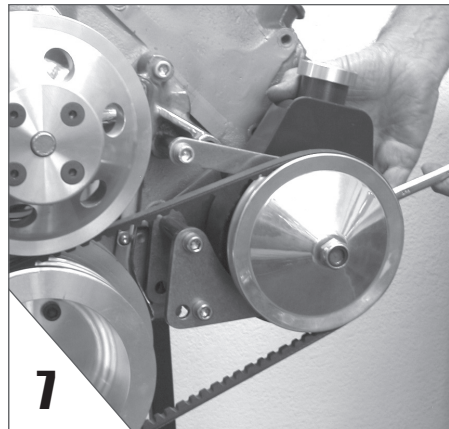
**ATTACH** the bracket to the pump as shown above.



**BOLT** the pump to the block.



**ATTACH** the arm by removing the lower bolt and installing the arm as shown. Add washers to keep the arm square with the pump face if needed.



**TIGHTEN** all the bolts and install the belt. Adjust for tension, check that all bolts are tight and the pump is properly aligned.



- **LOW POSITON** - Try Gates **7375**
- **MEDIUM POSITON** - Try Gates **7385**
- **HIGH POSITON** - Try Gates **7400**

The power steering pump will be using one belt from the crank pulley to the power steering pump.

**PLEASE NOTE:** These belt numbers will work with either the SHORT or LONG water pump set-up, using a 3 groove Crank Pulley with a 6 3/4" diameter, along with a 5 3/4" diameter Power Steering Pulley.