

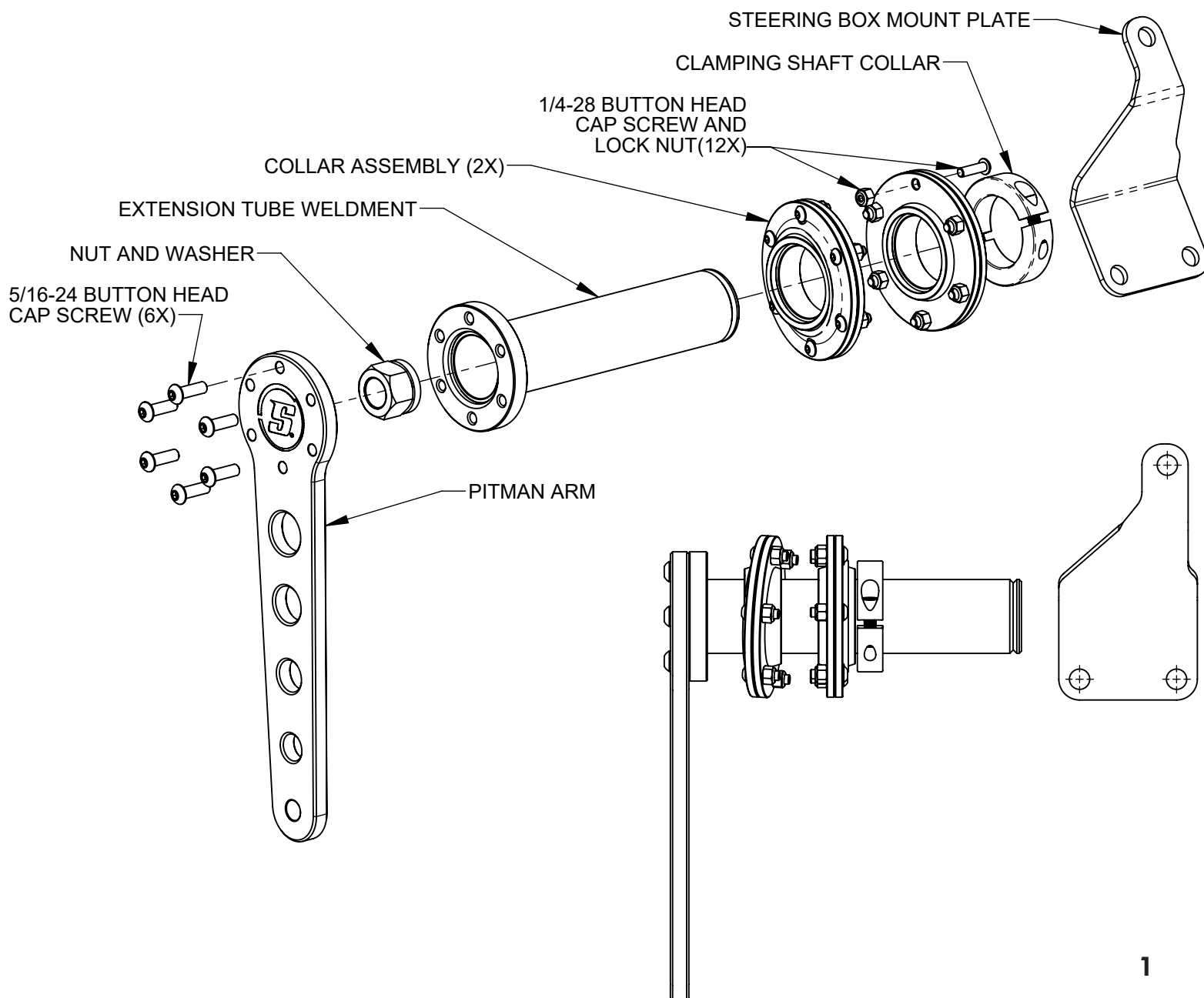
INSTRUCTIONS

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910-32196 - Cowl Steering Kit

Kit Contents		
Qty	Part #	Description
1	910-32196.1	Extension Tube Weldment
1	910-32196.2	Steering Box Mount Plate
1	910-32196.3	Pitman Arm - 6 Bolt
2	910-32196.4	Support Collar Assembly
1	910-32196.5	Clamping Shaft Collar
1	910-32196.6	Hardware Kitt



INSTRUCTIONS

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- 1.** Mount the steering box to the mounting plate and position the assembly in the vehicle at desired location and angle. The steering wheel can be attached to the box input shaft directly with a coupler and shaft or through a shaft with a u-joint. It helps to have the driver seated in position to find the best location and angle for the steering wheel. The steering mount plate will need to be sturdily attached to the vehicle structure to handle the steering loads. Temporarily mount the plate and check clearance for the tube and pitman arm before final welding is performed.
- 2.** Determine where the extension tube will go through the body and using a hole saw, cut a 3" diameter hole for the support collar assembly. Slip the support collar over the tube with the flat side facing the splined end and install the extension tube to the steering box with the collar outside the body. Mark and drill the six 5/16" diameter holes and mount the support collar to the body leaving the bolts loose at this time. Rotate the steering wheel and check for any binding on the tube. Once satisfied with the fit up, tighten the fasteners to lock the angle of the bushing to the shaft.
- 3.** Temporarily mount the pitman arm to the extension shaft flange and check for clearance with the body through steering travel. The pitman arm is reversible to allow for the tapered hole to face in or out. If all looks good, proceed to the next step.
- 4.** Since the body is generally not sturdy enough to fully support the tube under steering load, a second support collar is needed and must be mounted over the tube just inside the body. This collar should be mounted to a plate that is strong enough to keep the tube from moving under the steering load. Once this plate is positioned and securely tacked in place, remove the support collars (to avoid heat damage to the inner bushings) and all bracketry can be welded in place.
- 5.** Once the brackets are cooled and the support collars are back in place, center the steering box travel and install the extension tube over the splined output shaft with one set of holes oriented vertically so that the pitman arm can be installed straight up and down. Next, using a long extension and socket, install the internal retaining nut and washer on the steering box output shaft. This nut must be installed using a heavy duty thread locker such as red Loctite.
- 6.** When all components are ready to be permanently mounted, adding the clamp collar inboard of the support collar will prevent the tube from separating from the steering box should the internal nut ever back off. Leave about 1/16" gap between the support collar and the clamp.
- 7.** Attach the pitman arm using the six button head screws and thread locker.
- 8.** Connect the pitman arm to the steering arm with the appropriate length drag link. The pitman arm should be straight up and down with the wheels straight ahead. Double check all fasteners and for clearance before attempting to drive the vehicle.

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