



Camaro Steering Shaft Instructions (Small Block Chevy motor)
8050490, 8050510, 8050720

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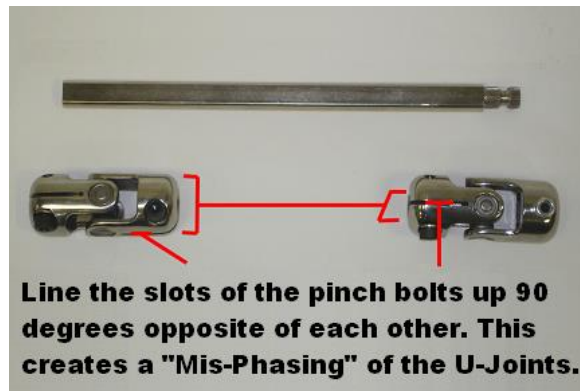
Kit Contents:

#	Part Number	Description	Quantity	Inspected By
1	542950	DD Shaft w/ Spline	1	
2	8050640	17mm DD x 3/4" DD U-Joint	1	
3a	8050350	1"-48 x 9/16"-30 U-Joint (Only in Kit # 8050490)	1	
3b	8050340	1"-DD x 9/16"-30 U-Joint Only in Kit # 8050510)	1	
3c	8050890	3/4"-36 x 9/16"-30 U-Joint (Only in Kit # 8050720)	1	

Inspected by: _____
 Date: _____

These Steering shafts require some assembly and some trimming. Please follow these instructions carefully and read completely before starting.

1. Thread the support bearing with the jam nut into the steering shaft support bracket until the shank is flush to the frame side of the support bracket (note the bracket is labeled frame side).
2. With the support bearing flush the curved side of the bracket should be pointing slightly toward the ground.
3. Insert the two 7/16 bracket bolts provided, thru two of the steering box mounting holes in the frame that are farthest apart (bolt heads to the outside of the frame).
4. Thread the bolts into the bracket and hand-tighten them. Fasten the column u-joint on to the upper steering shaft (the upper shaft is the shaft that has a groove on the double D end).
5. Slide the upper shaft into the support bearing and attach the middle joint to it. Be sure the u-joint is positioned at least 45 degrees out of phase.
6. Attach the top U-joint to the column. Attach the splined side of the lower shaft in the middle u-joint, but don't tighten, since this will need to be trimmed.
7. Attach the rack and pinion u-joint on the steering gear and determine how much will need to be trimmed from the lower shaft.
8. Remove the shaft and trim to size. You will also need to put a groove in the shaft, like the one on top steering shaft. You can do this with either a grinder or a file.
9. Reassemble the lower shaft, again making sure the U-joint are at least 45 degrees out of phase. Now that your shaft is the right length, turn it to make sure it is smooth. You may have to thread the support either in or out if you feel a bump or bind.
10. Once you feel your shaft is smooth tighten all fasteners. If this is a manual kit the lower U-joint that goes on the pinion should be tightened to 40 ft. pounds.



If you have any questions or problems regarding this product, please contact:

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