



1964-67 GM A-Body Steering Shaft Instructions
8051380

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Kit Contents:

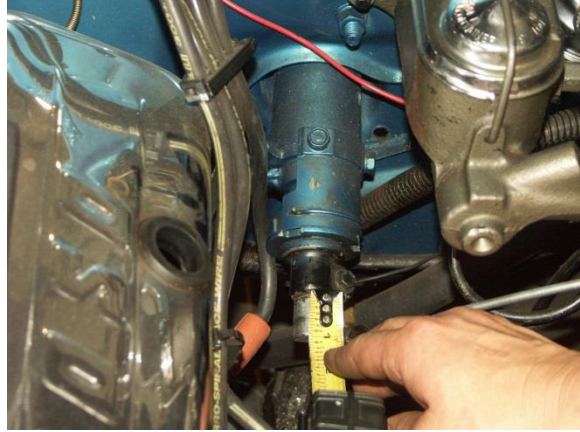
#	Part Number	Description	Quantity	Inspected by
1	543790	Upper Shaft	1	
2	543800	Lower Shaft	1	
3	8022270	Support Bracket	1	
4	8050240	3/4"-36 x 3/4"-DD U-Joint	1	
5	8050250	9/16"-30 x 3/4"-DD U-Joint	1	
6	8050890	3/4"-36 x 9/16"-30 U-Joint	1	
7	8050760	Shaft Support w/ Nut	1	

Inspected by: _____

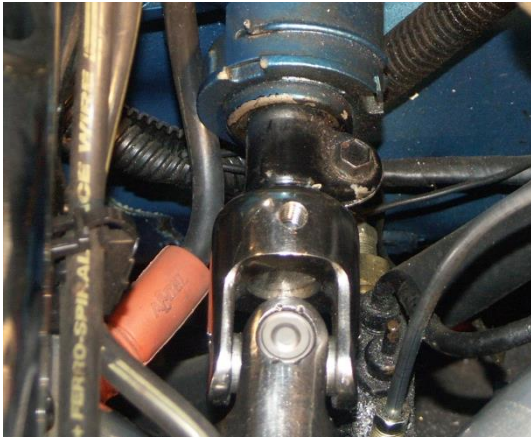
Date: _____

Shaft Installation:

1. Cut the steering column 1" from the bottom support bearing (see below).



2. Install column joint end onto stock steering shaft & tighten. **Note:** On big block cars it is necessary to slide shaft under header tube to clear & attach to column shaft.
3. Tighten the allen style screw in place in order to hold the u-joint to the column. Rotate the column shaft joint to access the thru hole (see pic below).



4. Use supplied drill bit to drill through column shaft and blank side of u joint. Install the larger roll pin provided by tapping it into place until flush with the side of the u joint. Next tap the smaller pin into the larger pin already installed until it is flush as well. This will ensure a positive lock.
 - a. If the u-joint has two thru holes, drill halfway thru the column shaft. Then rotate the joint 180 degrees and use thru hole to finish drilling the column shaft.
5. Remove the allen set screw and apply **"RED" Loctite** thread lock to threads and reinstall & tighten.
6. Install Heim joint into threaded hole of column support bracket so about five threads are showing. Install jam nut on bracket. Do Not Tighten.



7. Slide lower shaft through Heim joint & install bracket over the driver side from bolts & mounting bracket.
8. Install u-joint on pinion of rack & slide lower shaft into u-joint.

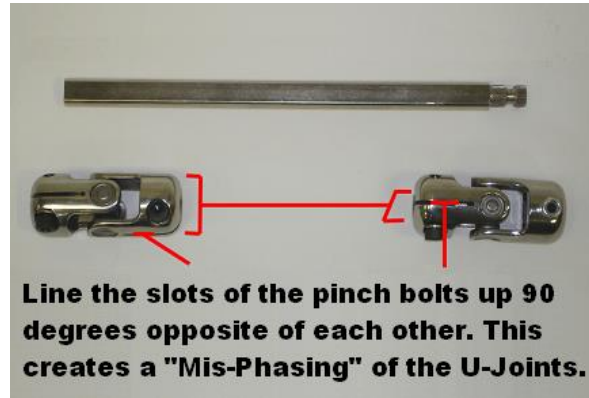
Note: It may be necessary to slide out diver side bolts & lower rack assembly to enable clearance of u-joint to shaft.

9. Tighten passenger side bolts and driver side bolts to 40 lbs.

10. Check clearance between header tube & u-joints of shafts.

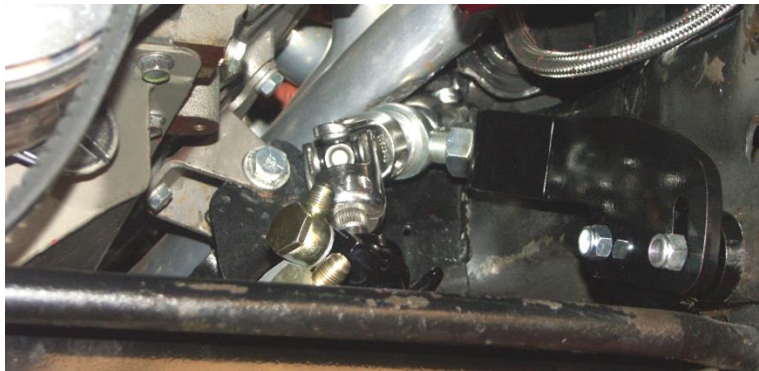
Note: It may be necessary to adjust Heim joint in or out of bracket (up or down) to clear. To do so, perform steps 2-4 again until adjustment is made.

11. Also, make sure you phase your u-joints. The lower u-joints at the pinion & at the Heim must work opposite of each other. Set them up so that they are 90 degrees apart as they turn.



12. If you rotate your steering wheel and it bumps or binds your phasing is wrong. Continue to adjust by rotating u-joints.

13. After installation make sure mounting bracket bolts to frame are torqued to 40 lbs.



14. Make sure u-joint bolts are installed & torqued to 25lbs.

15. Tighten jam nuts on u-joints & Heim joint.

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

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