



Southwest Speed Mopar Manual 16:1 Steering Gear Box Instructions 1966-1993 Dodge, Plymouth, Chrysler Passenger Cars, & Vans (SWS # 105-3532)

IMPORTANT!!! It is critical that the steering box be at the center position **BEFORE** installation. Incorrect centering will cause loose steering and premature wear. You should feel the box tighten when at the center.

NOTE: All boxes are pre-lubricated and pre-adjusted to factory specifications.
DO NOT ADJUST THE STEERING BOX!!!

16:1 RATIO SOUTHWEST SPEED GEAR BOX Centering Instructions

- 1) Place the steering box in a bench vise and be certain the box is held securely.
- 2) Install a 3/4"-36 u-joint to the steering gear input shaft
- 3) Turn the shaft to the right (Clockwise) all the way to the right lock position.
- 4) Turn the shaft to the left (Counter Clockwise) all the way to the left lock position (Approximately 4 1/8 turns)
- 5) Turn the shaft to the right (Clockwise) half the number of turns. (approx. 2-1/16 turns) *You should feel the box tighten when at the center.*
- 6) Align the wide spline on the sector shaft shaft of the box with the center of the sector area of the casting.

