



Detroit Speed
SBF Power Steering Pump Bracket
 P/N: 092104DS & 092105DS

The Detroit Speed Power Steering Pump Bracket allows simple installation of DSE's GM Type II power steering pump onto Ford small block engines. The mount is CNC machined from 6061 billet aluminum and includes all hardware to attach the pump and powder coated steel bracket to your engine. Detroit Speed offers kits for Ford engines with and without A/C.



Figure 1 - PN: 092104DS (with A/C)

| Item # | Description (PN: 092104DS) | Quantity |
|--------|----------------------------------|----------|
| 1 | SBF Power Steering Pump Mount | 1 |
| 2 | Power Steering Pump Bracket | 1 |
| 3 | Aluminum Spacer - 2.487" L | 1 |
| 4 | Aluminum Spacer - 1.663" L | 1 |
| 5 | Aluminum Spacer - 1.119" L | 1 |
| 6 | Aluminum Spacer - .138" L | 1 |
| 7 | 7/16"-14 x 2" L Socket Head Bolt | 1 |
| 8 | 7/16"-14 x 5" L Hex Head Bolt | 2 |
| 9 | 5/16"-18 x 3" L Hex Head Bolt | 2 |
| 10 | M8-1.25 x 25mm Hex Head Bolt | 1 |
| 11 | 7/16" AN Washer | 2 |
| 12 | 5/16" AN Washer | 2 |
| 13 | Instructions | 1 |

| Item # | Description (PN: 092105DS) | Quantity |
|--------|--------------------------------------|----------|
| 1 | SBF Power Steering Pump Mount | 1 |
| 2 | Power Steering Pump Bracket | 1 |
| 3 | Aluminum Spacer - 3.103" L | 3 |
| 4 | Aluminum Spacer - .375" L | 1 |
| 5 | 7/16"-14 x 4-1/4" L Socket Head Bolt | 1 |
| 6 | 7/16"-14 x 5" L Hex Head Bolt | 2 |
| 7 | 5/16"-18 x 3" L Hex Head Bolt | 2 |
| 8 | M8-1.25 x 25mm Hex Head Bolt | 1 |
| 9 | 7/16" AN Washer | 2 |
| 10 | 5/16" AN Washer | 3 |
| 11 | Instructions | 1 |

NOTE: Detroit Speed recommends using the following belt sizes:

PN: 092104DS use belt #6K820 (13/16" x 82-1/2" L)

PN: 092105DS use belt #6K690 (13/16" x 69-1/2" L)

NOTE: The 1985-93 Mustang A/C Compressor Mounting Bracket used in these instructions can be purchased at LMR – PN: LRS-9998929.

Installation:

1. If your engine is not equipped with A/C, skip to step 5. For engines equipped with A/C, you will need to modify the A/C compressor bracket. Cut out the provided template and line it up on the A/C bracket (Figure 1).



Figure 1 – Cut Out Template

2. Draw a cut line onto the A/C bracket using the template (Figure 2 on the next page). Remove the template from the bracket and remove this section of the bracket. Grind smooth for a clean finish. Re-install the bracket back onto the engine.



Figure 2 - Draw Cut Line

- Place the provided $7/16$ "-14 x 1-1/2" L socket head bolt through the counter-bored hole located in the center of the pump mount. Place the provided 1.119" L aluminum spacer over the exposed threads of the bolt (Figure 3).

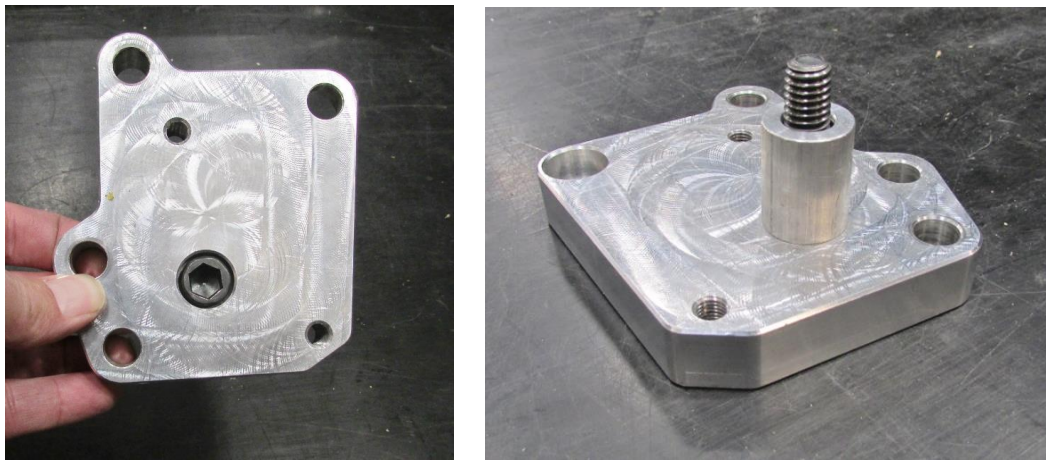


Figure 3 - Install Socket Head Bolt & Spacer

- Install the two provided $7/16$ "-14 x 5" L hex head bolts with $7/16$ " AN washers through two of the holes in the pump mount (Figure 4). Place the 1.663" L aluminum spacer of the threads of the top bolt and the 2.487" L aluminum spacer of the threads of the bottom bolt (Figure 5). Skip to Step 7.

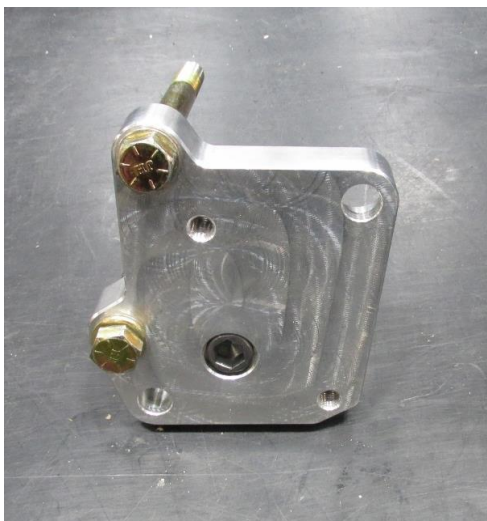


Figure 4 - Install $7/16$ " Bolts



Figure 5 - Install Spacers

5. For engines not equipped with A/C, place the provided 7/16"-14 x 4-1/2" L socket head bolt through the counter-bored hole located in the corner of the pump mount. Place one of the provided 3.103" L aluminum spacer over the exposed threads of the bolt (Figure 6).

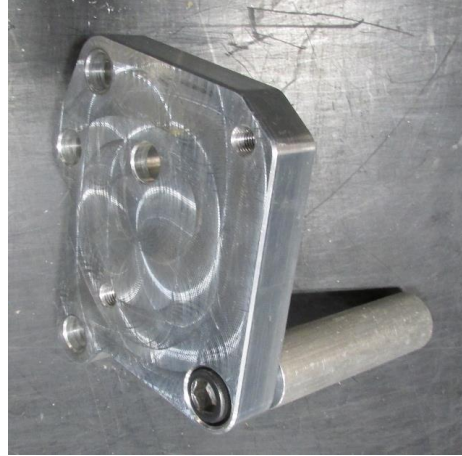


Figure 6 - Install Socket Head Bolt & Spacer

6. Install the two provided 7/16"-14 x 5" L hex head bolts with 7/16" AN washer through two of the holes in the pump mount (Figure 7). Place the other two 3.103" L aluminum spacers over the exposed threads of the bolts (Figure 8).



Figure 7 - Install 7/16" Bolts



Figure 8 - Install Spacers

7. Attach the mount by threading the bolts into the tapped accessory holes on the driver's side cylinder head/front drive bracket (Figure 9). Use medium strength blue Loctite 242 on the threads of the bolts. Torque the socket head bolt to 25 ft-lbs. Torque the hex head bolts to 35 ft-lbs.



Figure 9a - P/N: 092104DS



Figure 9b - P/N: 092105DS

8. Place the provided powder coated bracket on the front side of the pump. Install the provided 5/16"-18 hex head bolts and 5/16" AN washers through the top and bottom holes in the bracket and the pump. Thread the provided M8-1.25 x 25mm hex bolt through the side hole in the bracket and into the pump (Figure 10). Use medium strength blue Loctite 242 on the threads of the M8 bolt and torque to 19 ft-lbs.

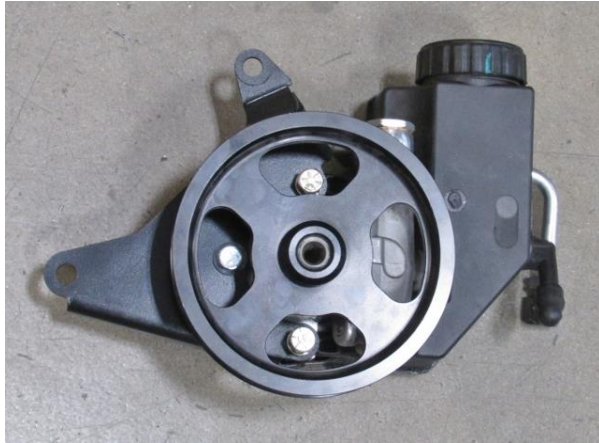


Figure 10a - PN: 092104DS

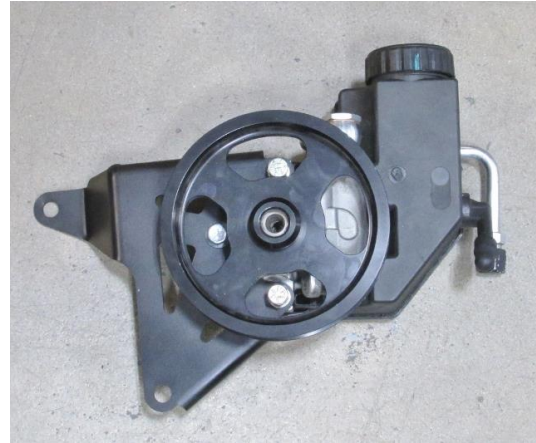


Figure 10b - PN: 092105DS

9. For A/C applications, place the provided 0.138" L aluminum spacer in front of the A/C bracket on the lower front cover stud (Figure 11a). For non-A/C applications, place the provided 0.375" L aluminum spacer on the lower front cover stud (Figure 11b).

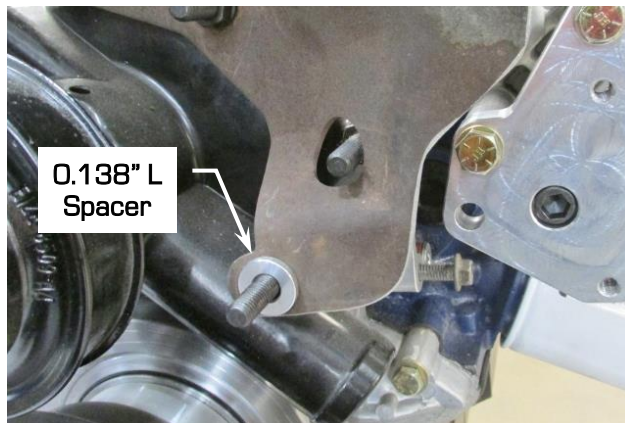


Figure 11a - PN: 092104DS



Figure 11b - PN: 092105DS

10. Attach the pump and bracket to the mount by lining up the bracket holes with the front cover studs. Thread the two 5/16"-18 hex bolts into the tapped holes on the mount (Figure 12). Use medium strength blue Loctite 242 on the threads and torque to 19 ft-lbs.

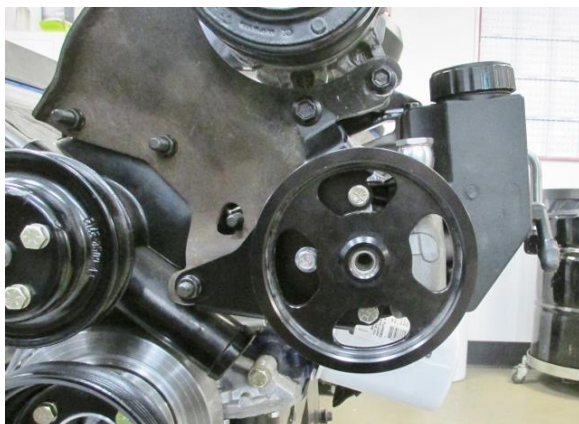


Figure 12a - PN: 092104DS

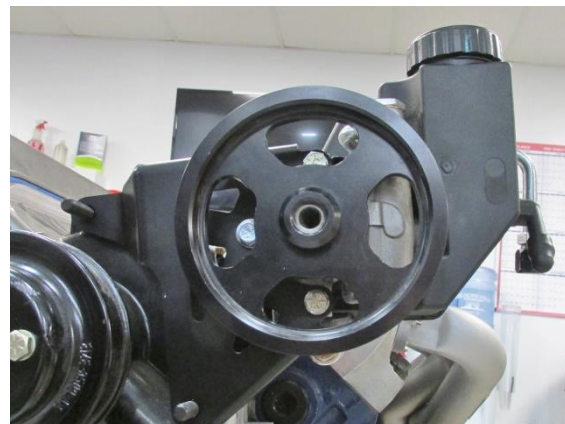


Figure 12b - PN: 092105DS

11. For engines equipped with A/C, install the factory bolt through the bracket and the A/C bracket underneath the compressor. Install the factory hex nut onto the lower front cover stud and tighten (Figure 13). For non-A/C applications, install the factory hex nut onto the upper and lower front cover stud and tighten (Figure 14).

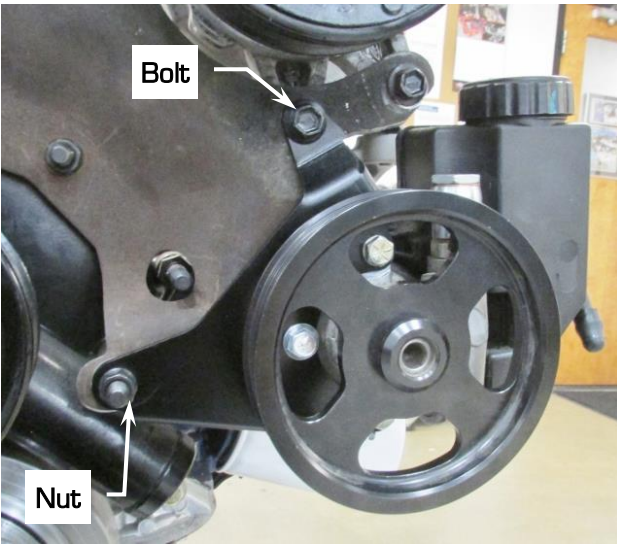


Figure 13 - PN: 092104DS

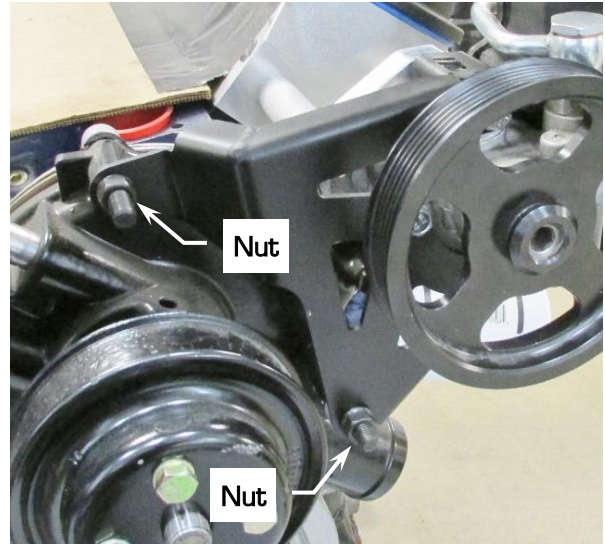


Figure 14 - PN: 092105DS

12. Install the power steering pump belt and adjust the tension (Figure 15).



Figure 15a - PN: 092104DS



Figure 15b - PN: 092105DS

If you have any questions before or during the installation of this product, please contact Detroit Speed at tech@detroitsspeed.com or 704.662.3272

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