



FM1225PC BBC GM Type II Power Steering Kit

Tools Required: 7/16-14 Thread Chaser (If necessary)
1/4" Allen Wrench Anti-Seize
3/8" Allen wrench

We recommend applying Anti-Seize to all threads when assembling bracket.

Recommended Belt: Goodyear 6 Rib #4060345 (34.5") or Dayco #5060345 (34.5")

- 1) Locate the two bosses on the lower driver side of the engine block as shown. Prep the threads with a 7/16-14 thread chaser if necessary.
- 2) Apply anti-seize to the threads of the two 5/16-24 X 3" socket head cap screws followed by installing the two 5/16 split lock washers.
- 3) Attach the pump & pulley to the bracket by installing the top fastener first and finger tighten.
Next install the bottom fastener through the pump and bracket and into the steel slide spacer, finger-tighten.
- 4) Apply anti-seize to the two 7/16-14 X 1-1/2" socket head cap screws. Follow by attaching the assembly to the engine block and tighten firmly (60 ft/lb).
- 5) Install the recommended Belt on the inner ring of the crank pulley and around the power steering pulley. Adjust the belt tension and tighten the two 5/16" socket head cap screws firmly (23 ft/lb).
- 6) Install power steering hoses and fittings. Follow the power steering bleed procedure provided with your Billet Specialties hose kit.

**IMPORTANT! DO NOT RUN THE MOTOR WITHOUT THE COMPLETE POWER STEERING SYSTEM INSTALLED AND BLED.
SERIOUS DAMAGE WILL OCCUR TO THE PUMP AND VOID THE WARRANTY!**

