



Steering, Brake & Suspension Specialists

#CP50004 - Power Steering Box Installation Instructions for 1964-95 Fullsize GM Car

Notes:

Vehicles converting from manual steering may need a power steering pitman arm. Most power steering pitman arms are available from CPP:

1964-67 Chevelle arm CPP# 6467PA-P

1968-72 Chevelle arm CPP# 6872PA-P

1967-69 Camaro arm CPP# 6769PA-P

Some vehicles may need to change to the popular 3/4-30 rag joint (CPP# RJC730R).

Most cars will only use three mounting bolts. The fourth mounting bolt is used on all Jeep CJ series trucks.

This steering box uses SAE flare connections at the hose fittings. If your vehicle has O-ring type hose ends, then they will need to be changed.

CPP **highly** recommends adding an inline power steering filter (CPP#20-0038F) whenever a used power steering pump is connected with your new gear box. This simple step will ensure that you will not contaminate your new steering gear and will keep your box eligible for warranty. These types of filters are available through CPP or your local auto parts store.

Specifications:

The pressure fitting is 7/16 tube with 11/16-18 thread.

The return fitting is 3/8 tube with 5/8-18 thread.

The input shaft spline is 3/4-30.

PLEASE NOTE: The installer needs to make sure that nothing can make contact with a brake hose, caliper, or other brake component at any point through the entire range of steering and suspension movement. The installer also needs to make sure none of the steering or braking components can become bound or jammed at any time through the range of suspension or steering movement.

Instructions:

1. If you are reusing the original pitman arm remove it from the steering box. If you are replacing the pitman arm remove it from the center link.
2. If the vehicle already has power steering, remove the power steering hoses from the steering box.
3. Remove the coupler (rag joint or U-joint) from the steering box. *Note: If the coupler is not already a 3/4-30 spline you will need to replace it with a new coupler that is 3/4-30.* CPP# RJC730R
4. Remove the bolts that attach the steering box to the chassis. Remove the steering box from the car.
5. Bolt new steering box to the frame using original mounting hardware. *For metric applications, you will need to use Grade 8 7/16"-14 hardware (not supplied). Length will vary depending on specific make/model.*
6. Center the steering box in its travel.

7. Install the pitman arm onto the steering box. If the pitman is not already attached to the center link, then install the pitman arm into the center link. Then bolt the 3/4-30 splined coupler to the steering box.
8. Connect the pressure and return hoses. The pressure hose is a 7/16 tube with an 11/16-18 SAE flare fitting. The return hose is a 3/8 tube with a 5/8-18 SAE flare fitting. Some vehicles may have O-ring type hoses. O-ring hoses will need to be changed to SAE flare fittings, or need to use hose fitting adapters (available from CPP, part #500IOA).
9. Fill the power steering reservoir with new power steering fluid. When using a new steering gear box with an old pump, CPP recommends using a power steering filter, part number PS10. Run the engine and slowly turn the steering wheel. Stop the engine several times and add fluid to the reservoir as needed. Continue steering the wheel to the ends of its travel and adding fluid until the fluid level doesn't go down as the steering wheel is turned.
10. With the engine running, check for leaks at the hose fittings. To do this have someone in the car hold the steering wheel tight against the left and right steering stops while you watch the hose fittings for leaks (This will operate the box at full pressure). Correct any leaks you find.

RECOMMENDED PRODUCTS TO ASSIST YOUR INSTALL:

POWER STEERING PITMAN ARMS

#6467PA-P
- 1964-67 Chevelle Arm



#6872PA-P
- 1968-72 Chevelle Arm



#6769PA-P
- 1967-69 Camaro Arm



STEERING SHAFT COUPLER "RAG JOINT"

#RJC730R - 3/4" X 30 Spline



INLINE POWER STEERING FILTER

#20-0038F - 3/8" lines



HOSE FITTING ADAPTERS

#500IOA - Inverted Flare Box to O-ring Hose



GENERAL TORQUE SPECIFICATIONS:

1/4"	grade 5	10 lb/ft	1/4"	grade 8	14 lb/ft
5/16"	grade 5	19 lb/ft	5/16"	grade 8	29 lb/ft
3/8"	grade 5	33 lb/ft	3/8"	grade 8	47 lb/ft
7/16"	grade 5	54 lb/ft	7/16"	grade 8	78 lb/ft
1/2"	grade 5	78 lb/ft	1/2"	grade 8	119 lb/ft
9/16"	grade 5	114 lb/ft	9/16"	grade 8	169 lb/ft
5/8"	grade 5	154 lb/ft	5/8"	grade 8	230 lb/ft

NOTE: With 18" and larger wheels we recommend 1/2" wheel studs. The larger the wheel diameter, the greater the force is on the wheel studs. Please inquire about replacement wheel stud kits available from CPP.

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