Steering Box Bracket Installation

1. Make sure the steering box and/or tires are centered and straight ahead.

2. Before removing anything, measure the distance between the drag link and the shock. This will be needed later to position the new box.

3. Remove the drag link from the pitman arm and the pitman arm from the gearbox.

4. Remove the steering column from the gear box. (Leave the rag joint on the column). Remove the four bolts at the bottom of the steering column at the fire wall and loosen the two bolts that support the column under the dash.

5. Remove the old steering box from the mounting bracket then cut the four rivets that hold the brackets to the frame and remove the old bracket.

6. The new bracket is predrilled to match the holes in the frame. Install the new bracket using 3/8" bolts. (just snug them up because you will have to remove the bracket later for drilling).

7. Making sure the new steering box is at its center of travel, set the box on the new bracket and temporarily clamp it down.

8. Using your old pitman arm, install the drag link on the arm and slide the pitman arm on the steering box. **DO NOT TIGHTEN**.

9. Install the steering column on the steering box.
NOTE : The new power steering box is about 1" longer than the manual box so the steering column will have to be shimmed towards the driver inside the cab at the firewall to make up the difference later. Do not tighten the column yet.

10. Check the distance between the drag link and the shock. Check to make sure the steering column is centered in the opening in the firewall. Also look to see if the box is positioned properly in the cut out of the inner fender. Loosen the clamp and reposition the box as needed for proper alignment.
NOTE: To move the box closer too or away from the firewall, you must remove the pitman arm from the gearbox so you don't loose your center of travel.

11. Once the box is positioned properly and clamped, mark the holes needed to be drilled in the bracket. Remove the bracket and drill (3/8 bit).
NOTE: Because of the body mount wear and tub positioning on the

frame, the holes could not be predrilled.

12. Reinstall the bracket and gear box and tighten using grade 8 bolts. Install the pitman arm and tighten.

13. Install the steering column on the box and tighten. using the necessary amount of washers to shim the column at the firewall, install the four bolts and tighten. Tighten the two bolts under the dash.

14. After the installation is complete and road tested. You can adjust the left and right travel to be equal by adjusting the drag link and/or the center link

The steering box must be from a 79 - 85 straight axle 4x4 Toyota Mini Truck.