

TECHNICAL BULLETIN # 1011

WARRANTY: ONE (1) YEAR FROM DATE OF PURCHASE. REPLACEMENT OF PRODUCT DEEMED DEFECTIVE BY THE FACTORY. *ANY LABOR INCURRED IS SPECIFICALLY EXCLUDED.*

STEERING BOX INSTALLATION INSTRUCTIONS – 1964-1/2-1966 Mustang, 1960-66 Ford Falcon & Ranchero FR1497-series Long Shaft (including special order units)

NEEDED PARTS (not supplied): None

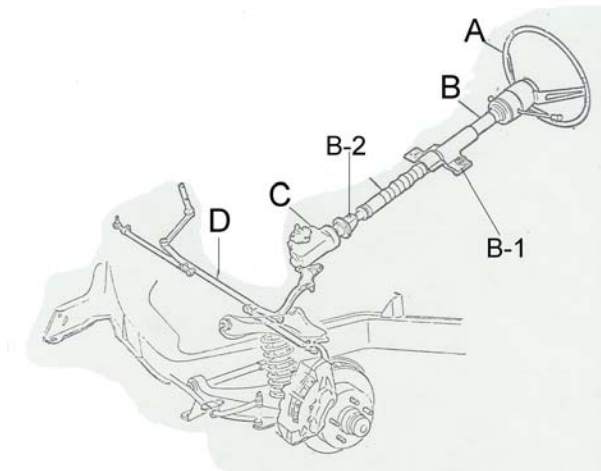
IMPORTANT: Make certain the wheels are straight ahead before beginning and the vehicle is properly supported on jack stands. With the wheels straight, mark the top center of the steering wheel with a piece of tape around the grip to assure the wheel is centered.

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

Removal of Steering Column

The first part of replacement of the steering box is the removal of the steering column. To remove the column, follow these steps.

1) Disconnect the ground (–) terminal from the battery.



- 2) Remove horn button by pushing down on horn hub and turning counter clockwise.
- 3) Remove steering wheel retaining nut and remove steering wheel (A) by using a steering wheel puller.
- 4) Disconnect the electrical plug towards the base of the column (B).
- 5) Before removing the column, see PAGE 3. Fill out wiring color verification form before proceeding.
- 6) Remove the column support bracket under the dash. There are two nuts one on each side of the column. (B-1)
- 7) Remove the upper bushing located at the center of the turn signal switch.

- 8) Remove the column tube by sliding it up off the steering box shaft.

Removal of Steering Box

NOTE: The next steps are performed under the vehicle. For safety, the vehicle must be properly supported with 4 jack stands.

- 1) Remove the bolt securing the steering drag link to the pitman arm. (SAVE THE BOLT, NUT, WASHER; DISCARD COTTER PIN)
- 2) Remove the pitman arm retaining nut.
- 3) Using the pitman puller remove the pitman arm.
- 4) Remove the three bolts that hold the box to the frame rail. (SAVE MOUNTING BOLTS)
- 5) Remove the box from the vehicle.

Mounting the steering box

IMPORTANT! Center the steering box before installation. Refer to Flaming River Instruction Bulletin #1012 (enclosed) and follow the procedures to center the steering box's sector (output) shaft.

- 1) Slide long shaft upward through the opening in the firewall.
- 2) Install the steering box to the frame. Using the torque wrench, tighten the mounting bolts to 50-65 ft-lb.
- 3) Attach the pitman arm to the steering box. Using the torque wrench, tighten the sector shaft bolt to 115 ft-lb.
- 4) Reattach the center link to the pitman arm. Install washer and nut. Tighten nut to 40-45 ft-lb, install new cotter pin, and bend over ends.

NOTE: For 1960-66 Ford Falcons/Rancheros and Mercury Comets equipped with an automatic column shifter, some grinding or filing is required on the coupler to clear the shifting mechanism at the base of the steering column. Carefully remove only enough material until the column will slide over the coupler.

Reinstall the steering column

- 1) Reinstall the floor mount bracket using the four mounting screws. Be certain to reinstall the original seals that were removed.
- 2) Slide the column over the shaft extending upward from the steering box and continue downward through the floor mount.
- 3) Insert the alignment bushing into the turn signal switch assembly
- 4) Fasten floor mount to column and tighten clamp.
- 5) Reattach turn signal/horn wiring to column.
- 6) Insert spring over steering shaft
- 7) Reinstall steering wheel with the tape at the 12 o'clock position and tighten retaining nut to 45-50 ft-lb of torque.
- 8) Connect horn contact wire to contact on wheel.
- 9) Reinstall horn button by pushing down and turning clockwise (right).
- 10) Reconnect the battery terminal

NOTE: Front-end alignment by a service professional following installation is advised.

NOTE: Flaming River recommends periodic inspection of all u-joint setscrews for tightness.

Warranty Disclaimer

Because of their intended usage, the manufacturer makes no warranties whatsoever expressed or implied, oral or written, to purchasers of their products regarding performance, safety, fit, merchantability, or length of service. Purchasers are responsible for selection of proper goods and must rely on their own skill or judgment that such goods are suitable for the purchaser's application.