



## Saginaw to Ford FE engines power steering pump kit # BWSFEKIT

### Installation instructions

1. If equipped, unbolt AC compressor and move out of the way, remove AC compressor mount.
2. Loosen alternator belt adjustment to remove and disregard outer belt.
3. Remove and disregard the two left (driver) side water pump mounting bolts.
4. Install large mounting Power Steering bracket on rear side of the pump, make sure adjuster slot is on top, use the 10mm whiz nuts on studs on back of p/s pump, snug tight, but still allowing the pump to pivot for belt adjustment.  
**NOTE: ALL BOLTS AND NUTS ARE TO BE TIGHTENED WITH HAND TOOLS THROUGH OUT THE WHOLE INSTALLATION**
5. Use 1-3/8" x 1 3/4" bolt, 1- 3/8" x 3/4" spacer, and lock washer to install front support strap to front side of the P/S pump (Front lower left mount of the water pump)  
**NOTE: ROUNDED END OF STRAP NEEDS TO BE TOWARDS CENTER OF ENGINE**
6. Install power steering pump pulley (puller hub out) with provided installation tool.
7. Mount power steering pump assembly to water pump mounting holes using 2-3/8" x 2" bolts, 2-3/8" x 3/4" spacers, and lock washer. Also mount the front support strap to the lower end of the water pump. And tighten all pump mounting bolts.
8. Install power steering belt and set tension 1/2" end play and tighten pump down.
9. Reinstall AC mount, compressor, and belt.
10. Connect power steering hoses
11. Fill with (**approximately 2 quarts of Dextron III or your favorite power steering fluid**). Start engine, check fluid level with engine running, add as necessary, wait to steer vehicle until power steering fluid is at operation temperature, turn steering wheel slow one direction about a half turn, (check fluid) wait one minute then turn steering wheel the other direction a full turn, (check fluid) wait another minute then steer to full lock in both directions (do not hold steering wheel at full lock)
12. Check for loose bolts, fluid leaks and level,

13. Test drives enjoy!!

Note: Our kit is designed for the Ford FE truck series engines with dual pulleys, however there has been some design changes thru the years along with aftermarket parts that could have been installed;

Some minor modifications may be necessary.

Feel free to pass along suggestion to us to improve our products

[questons@benchworksteering.com](mailto:questons@benchworksteering.com)

### Bleeding Instructions

1. Fill pump reservoir till it is full with factory fluid.
  2. Start engine check power steering fluid
  3. When Engine is at operate temp. Steer vehicle on ground.
    - Steering wheel starting at 12 o'clock, go to 1 & 2 o'clock (check fluid)
    - Back to 12 o'clock. Turn to 11 & 10 o'clock (check fluid )
    - Back to 12 o'clock. Now steer 360 Deg. either direction.
    - Then 360 Deg. the opposite direction
- [Noisy Pump-let vehicle idle until noise is gone (some noise is normal)  
Last steer SLOWLY fully to the left, and then again SLOWLY to the right  
Now check the fluid, take a test drive and recheck fluid.  
(If engine needs breaking in. Run with the Power Steering belt off)