

## 6190 INSTRUCTIONS FOR STEERING COLUMN TUBE SET

<u>ITEM</u>	<u>QTY</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
1	1	A18.058-024.000	Tube 1-1/8 - .049 x 24" (steering column)
2	2	A12.049-048.000	Tube 3/4 - .049 x 48" (steering shaft)
4	2	3333	Column bushing - 1 x 3/4
5	3	899-023-313-24	Locknut 5/16 - 24, all metal
6	3	3109	Bolt 5/16 - 24 x 1 1/2

ALSO NEEDED BUT NOT INCLUDED: 1) Splined coupler or universal joint to attach 3/4" tube to steering box; 2) a universal joint to attach the 3/4" tubes together and 3) a steering wheel flange or quick release hub to attach steering wheel to 3/4" tube:

<u>PART NO.</u>	<u>DESCRIPTION</u>
6195	Female coupler 9/16-26 spline with 3/4 bore; female end for Pinto/Mustang II manual rack-n-pinion
6196	Male coupler 9/16-26 spline with male end that fits into 3/4" bore for Pinto/Mustang II manual rack-n-pinion
6197	U-joint dual 3/4 bore pin-&-block style with 1" outside diameter
6198	U-joint 9/16-26 x 3/4 bore pin-&-block style with 1" outside diameter for Pinto/Mustang II manual rack-n-pinion
6117	Steering wheel flange round, 3 hole
6162	Quick release steering hub, 3 hole
6163	Quick release steering hub, Grant GT, 5 hole
6168	Quick release steering hub, blank - no holes
6101	Mil-Spec U-joint 3/4 x 3/4 bores
6103	Column tube 3/4-36 spline adapter for 3/4-.049 tube
6160	Steering shaft auxillary bushing
3382	GM rage flange to 1-DD u-joint needle bearing style
3393	GM rag flange to 3/4-36 u-joint needle bearing style
FR1708	U-joint 9/16-26 x 3/4-36 needle bearing style
FR1711	U-joint 3/4-36 x 3/4-36 needle bearing style
FR1713	U-joint 1-48 x 3/4-36 needle bearing style
FR1723	U-joint 13/16-36 x 3/4-36 needle bearing style
FR1724	U-joint 3/4-30 x 3/4-36 needle bearing style
FR1726	U-joint 5/8-36 x 3/4-36 needle bearing style
FR1736DD	U-joint 17mm DD x 3/4-36 needle bearing style
FR1788	U-joint TRILOBE x 3/4-36 needle bearing style
FR1792	Double U-joint 3/4-36 x 3/4-36 needle bearing style
FR1793	Double U-joint 9/16-26 x 3/4-36 needle bearing style

Call for other available sizes

1. Install universal joint (or coupler) (with splined end) on Pinto rack and pinion. The splined shaft on the steering box has one flat side and one side with a ground notch. The drilled bolt or set screw must be screwed down into the notch. Wrap the safety wire around the tube and pass through the hole in the drilled bolt. Twist the ends of the safety wire together to prevent the drilled bolt from vibrating out. Set screws lock in place with a jam nut; use Loctite™ on the jam nut only.

2. Slide both the column tube plastic bushings into the column tube (1-1/8 OD x 24"). Slide the tube with bushings in place over one of the 3/4 OD tube shafts. If the 3/4 tube steering shaft does not rotate freely, use a flap wheel to sand the inside diameter of the plastic bushing.

3. Attach the steering wheel to the 3/4" tube approximately 1" from the end of the 1-1/8" tube. Position the steering wheel where it is comfortable to the driver. Use the other 3/4" tube to connect the coupler on the steering box and the universal joint on the steering shaft upper tube. Cut the tubes to length and slide them into the universal joints and couplers. Rotate the universal joints on the shafts to make sure the angle is not so severe that the universal joints bind.

4. Use the remnants of the 3/4" tube to attach the 1-1/8" diameter steering column to the chassis on the mid mount bar or the driver's cage side. Do not weld the steering column with the plastic bushing in place. Weld the lower steering shaft to the steering box coupler and upper shaft universal joint. Use the 5/16" bolt to attach the upper steering shaft to its universal joint. This will allow you to be able to remove the steering shaft.

5. Needle bearing u-joints attach to the 3/4 tube column shaft by welding Part No. 6103 into the 3/4 tube shaft. Part No. 6103 converts the tube to 3/4-36 spline to attach to the u-joints.

6. Every double u-joint used in the system will require an additional Part No. 6160 steering shaft auxiliary bushing.

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