

Contents Listing for 153775RE Conversion Kit

Before starting, check to see that you have the following parts included in this kit:

Qty. 1 - Steering Control Unit

Qty. 1 – Steering Column Assembly

Qty. 2 – 3/8-16 X 3/4" 12 point screw

Qty. 2 – 3/8-16 X 1-1/2" hex head cap screws w/lockwashers

Qty. 1 – Universal Mounting Bracket

Qty. 1 – 12503 17" Steering Wheel

Qty. 1 – 13/16"-20 Nut

Qty. 1 – Horn Button Kit

Qty. 2 – 7/8" to 3/4" O-Ring Port Adapters

Installation Instructions for Converting Power Assist Steering Gears to Hydrostatic Steering Control Units

1. Before removing old gear assembly, it may be helpful to measure the distance from the upper column mounting bracket to the top of the steering wheel so that new assembly can be placed in a similar position. You will need to determine where each of the four hydraulic hoses are routed to, carefully marking each, as the old steering valve on gear is usually not marked as to its function. Generally, the two larger hoses are the pressure from pump and return to tank. The smaller hoses each flow to left and right sides of power steering cylinder.
2. Remove old power assist gear, pitman arm, and drag link. It may also be necessary to remove brake or clutch booster hardware only to allow clearance for drilling new bracket mounting holes in frame rail. Bracket may also be welded to frame as an alternative.

3. Loosely assemble new column on to steering control unit with the two 3/8" 12 point screws supplied on opposing corners of column mounting flange. Add mounting bracket to assembly loosely using two hex head 3/8 bolts provided and attach new steering wheel with new nut provided.
4. Trial fit the assembly into truck to provide proper steering wheel height, also noting if horn wire contact and hydraulic ports are facing the direction that will facilitate easiest horn wire routing and hydraulic hose attachment.
5. Using an assistant to hold assembly in position, mark location of two holes to be drilled in frame. Drill two 17/32" holes through frame rail, or clamp bracket to frame and weld into position.
6. Make final adjustments in column/steering unit/bracket orientation and tighten all bolts securely.
7. Attach mounting bracket with steering unit to frame with supplied bolts, and tighten securely.
8. Attach original hydraulic fittings and hoses to new unit, using provided adapters (in most cases) on pressure and return ports. New steering control unit is marked at ports or on bottom cover as to proper hose attachment and there is an ENCLOSED ILLUSTRATION on separate sheet. **IT IS IMPERATIVE THAT YOU INSTALL HOSES IN CORRECT POSITIONS OR SERIOUS INJURY COULD RESULT WHEN TRUCK IS STARTED.** Retrace hoses to their origination points again at this time if necessary.
9. Tighten steering wheel retaining nut securely, install horn button kit, and attach lead wire to terminal on column.
10. Start truck and turn steering wheel back and forth several times with wheels raised off ground. You will need to purge air out of the system and it may be helpful to slightly loosen the lines at the steering cylinder. Make sure at this time that turning the steering wheel left and right results in the correct movement of steered wheels. If incorrect, turn off truck and switch the cylinder port hoses on steering unit.