



# FJ40 Power Steering Kit Installation Instructions

## Kit Contents:

- Remanufactured 85+ FJ60 PS Gearbox
- Borgeson telescoping steering shaft and joints
- Saginaw PS pump, cap and mounting bracket for 2F
- High pressure line
- Low pressure line and clamps
- V-belt and correct width v-belt Pulley w/taper lock hub
- Steering Column support bearing
- Return tube nipple
- Pitman arm with nut and washer
- Laser cut frame plate with compression sleeves to fit 85+ gearbox
- Gearbox mounting hardware

**\*NOTE: Drag link will need to be replaced, contact IPOR for your application – 540-361-7400**

## Tools Required:

- Metric socket and wrench set
- Grinder and cut off wheel
- Drill
- Welder

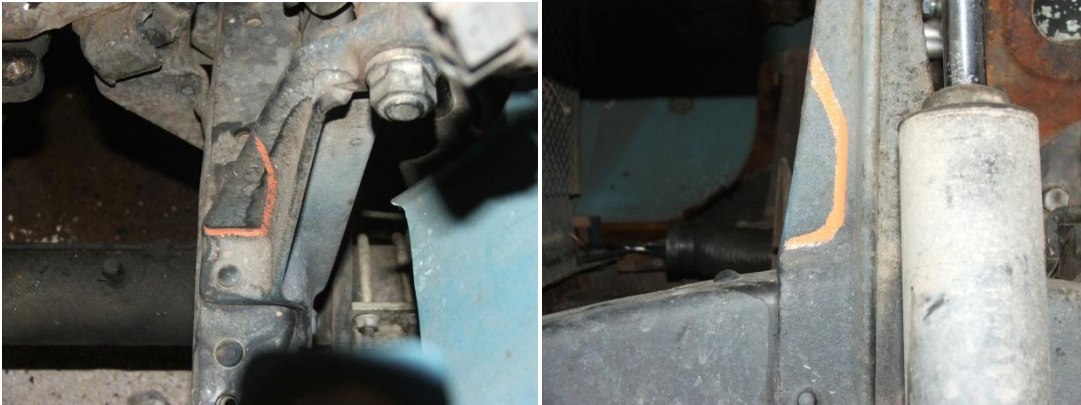
This is what your gear box should look like after installation:





**Instructions:**

1. Remove factory power steering gearbox, relay rod, center arm and drag link.
2. Remove factory steering box pedestal from frame.
3. Drain coolant and remove radiator.
4. Remove radiator support.
5. Grind out back side of shock mount to provide adequate clearance for gear box and u-joint.



6. Cut out inner fender as needed to clear gear box.



7. Align steering box template provided with the edge of the shock tower. Drill holes to 1/2".



8. Cut out inner frame box section and bolt frame plate provided in place. Tack plate to frame.



9. Test fit steering box with pitman arm installed to verify proper frame clearance of pitman arm .



10. Remove steering box and finish welding. Allow to cool. Paint any bare metal.
11. Bolt steering gear box to frame. Place radiator support in engine bay noting interference with steering gearbox. Mark radiator support and cut out interference area. Place Radiator in support and fabricate new lower corner for support that does not interfere with radiator or gearbox. Weld, cool and paint support but do not reinstall at this time.



12. Cut steering column approximately 2" from outermost edge of firewall plate. Dress edges with sander and slide bearing up shaft to edge of firewall plate and tack weld bearing to firewall plate. (do not fully weld or damage to the bearing may occur)
13. Fit  $\frac{3}{4}$ "-1"DD u-joint to steering column, mark set screw and drill pinning hole into steering column.
14. Paint and install steering shaft and gearbox. Apply small tack weld to ujoint at column. (do not fully weld or damage to the u-joint may occur)
15. Install pitman arm and drag link. Torque pitman arm nut to 130 ft/lbs.
16. Install power steering pump onto pump bracket and install pulley onto pump.
17. Install power steering pump bracket using front two head bolts. Be sure to verify belt alignment before tightening head bolts. Torque head bolts to 90 ft/lbs.



18. Install power steering belt and hoses. Fill with Synthetic ATF.
19. Install radiator support and radiator. Fill with coolant.
20. Start engine and bleed power steering system by turning steering left and right repeatedly, adding ATF as needed, until bubbles stop.
21. Verify all bolts have been tightened properly and test drive.
22. Re-check bots after 100 miles.