

# ***Installation Instructions for 8205: Small Block Chevy Power Steering Pump Mount Kit Long Water Pump***

**Read All of the Instructions Before Beginning the Installation**

## **Parts List:**

1. 2-1/4 Billet brackets
2. 2-Billet aluminum hex spacers 3.075 Long
3. 2-Billet aluminum hex spacers ¾ Long
4. 2-Stainless steel 3/8-16 X 2 Studs
5. 4-Stainless steel 3/8-16 X ¾ cap screws
6. 2-Stainless steel 3/8-16 X 1 cap screw
7. 5-Stainless steel 3/8 flat washers
8. 1-Billet aluminum round spacer .350 long
9. 1-Billet aluminum round spacer .475 long

## **Mounting Instructions:**

1. **Note:** Bracket kit to be used with standard GM Saginaw style pump and a long water pump crankshaft pulley. Mounts on the lower left (drivers) side.
2. Before installation remove pump and any mounting brackets if so equipped.
3. Once this is done install two of the 3/8-16 X 2 studs in the lower left block accessory holes located directly below the water pump. Studs will not screw all the way down and should stick out showing about 3/4 of the thread. **Note:** It might be necessary to use some Loctite to keep studs from loosening.
4. After mounting studs are installed you will need to place the two ¾ long hex spacers over the studs. Once the spacers are in place proceed by mounting the inner ¼ bracket over the studs using the two holes closest to each other. **Note:** There is an inner bracket and outer bracket. The brackets are manufactured with a radius on the outer perimeter, that radius will face away from the pump. Once that inner bracket has been installed, using the two aluminum hex spacers supplied with the kit you will screw them on to the studs and tighten down the inner bracket.
5. Now that the inner bracket is in place you can loosely mount your pump to the bracket, but first you must remove and discard any remaining hardware left in the back of your pump. **Note:** It may be necessary to remove the pulley from your pump before installing. The back of your pump should have two 3/8 bolt holes an upper and lower. Using one of the 3/8 -16 X 1 bolts and the .375 long round spacer (spacer will go between bracket and pump) mount the pump using the lower hole in the bracket and the lower hole in the pump. The top hole will receive a 3/8 -16 X ¾ bolt and two washers (washers will also go between the bracket and the pump).
6. Now that your pump is loosely hanging on the inner bracket you can now mount the outer bracket. Using two of the 3/8 -16 X ¾ bolts mount the outer bracket to the two aluminum hex spacers sandwiching the pump. The front of your pump is also equipped with two 3/8 bolt holes an upper and lower. The lower hole will receive one 3/8 -16 X 1 bolt and the .475 long round spacer (spacer will go between the bracket and pump). The top hole will receive a 3/8 -16 X ¾ bolt and three washers (washers will also go between the bracket and pump).
7. Now that your pump is mounted reinstall your pulley if so removed. **Note:** The four bolts holding your pump should still be loose at this time. Once the pulley is in place install your belt and set your correct tension. Once your desired tension is complete tighten the two top bolts first then the two bottom bolts.
8. Congratulations your installation is now complete.



**301-420-2727 [speedunlimited.com](http://speedunlimited.com)**