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# INSTALLATION GUIDE



## TCP PBS-FD-03 Pump Bracket Set Ford 03 Ford FE Block 390, 427 & 428



### DESCRIPTION:

Pump bracket set Ford 03 includes billet aluminum bracket; spacers and hardware; attaches power steering pump to driver side cylinder head and water pump

### APPLICATIONS:

Fits Ford FE block 390, 427 and 428

# PARTS LIST

## TCP PBS-FD-03 - Power Steering Pump Bracket Set - Ford FE

Qty	Part Number	Description
1	7900-146	KRC Pump Bracket FE Ford Block 390-427-428
1	7918-010	Hardware Bag for TCP PBS-FD-03
1	7918-012	Spacer Set Ford Power Steering Pump Bracket

### 7918-010 - Hardware Bag

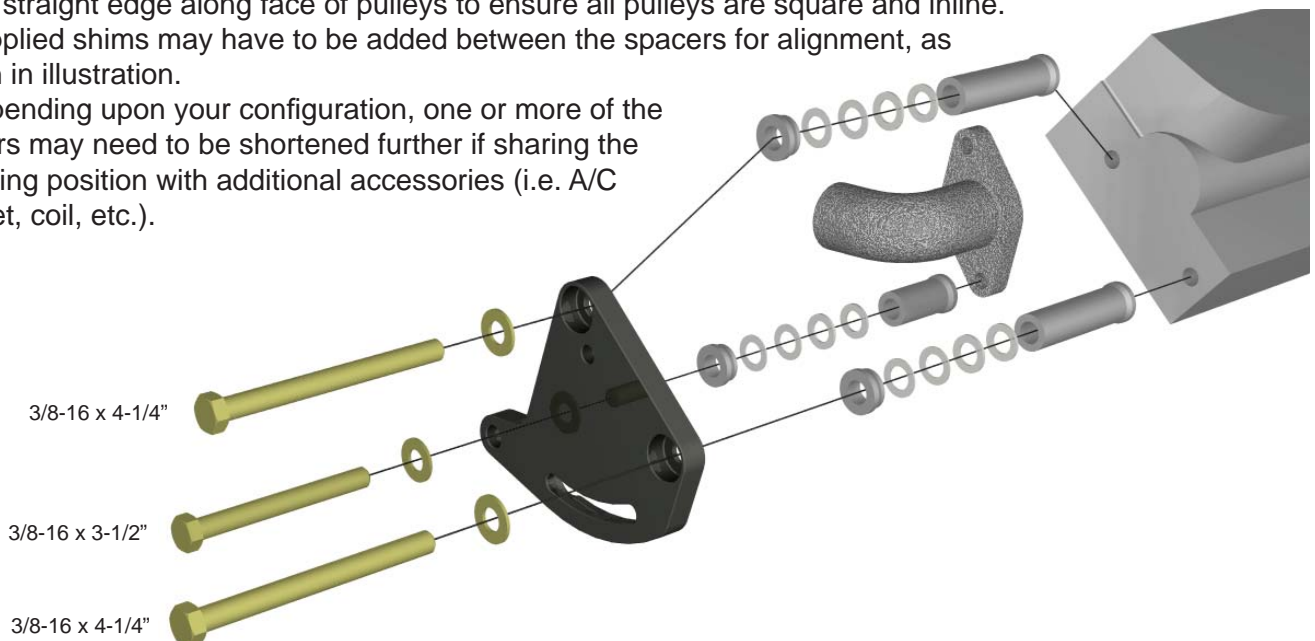
Qty	Part Number	Description
2	3100-031C2.75Y	Bolt 5/16-18 x 2-3/4" Hex Head Cap Screw
2	3100-031C3.50Y	Bolt 5/16-18 x 3-1/2" Hex Head Cap Screw
1	3100-038C3.50Y	Bolt 3/8-16 x 3-1/2" Hex Head Cap Screw
2	3100-038C4.25Y	Bolt 3/8-16 x 4-1/4" Hex Head Cap Screw
1	3119-031-18C	Flange Nut 5/16-18; 1/2 Hex
2	3120-031S-Y	Washer 5/16 Flat SAE .345 x .690 x .060 Thick
3	3120-038S-Y	Washer 3/8 Flat SAE .410 x .810 x .060 Thick

### 7918-012 - Hardware Bag, Spacer Set

6	3109-044S1-S	Aircraft Washer 7/16 Flat .453 x .750 x .032 Thick
6	3109-044S2-S	Aircraft Washer 7/16 Flat .453 x .750 x .063 Thick
3	7900-170-0370	Spacer .453 ID x .370 Long x .75 OD with .850 Shoulder
3	7900-170-2910	Spacer .453 ID x 2.910 Long x .75 OD with .850 Shoulder

## INSTRUCTIONS

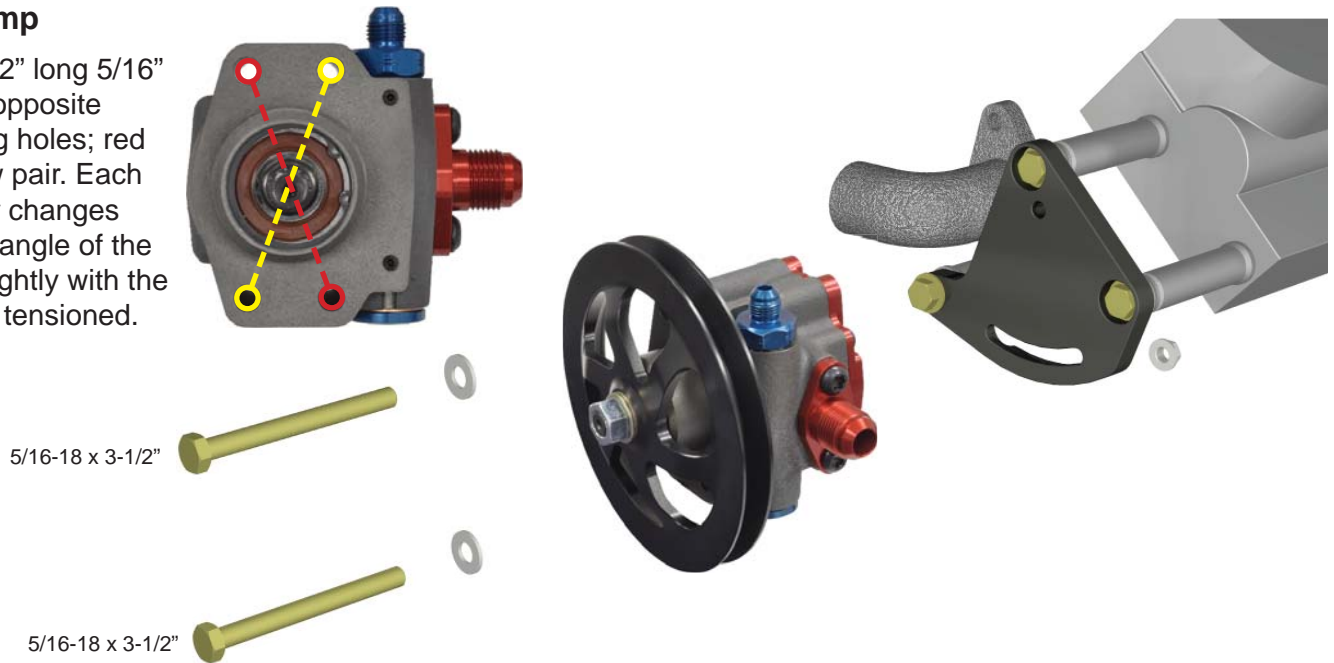
- Loosely bolt pump to bracket using 5/16" hardware.
- Loosely bolt pump bracket assembly to cylinder head using a 3/8" bolts in locations shown in illustration.
  - This is to verify the correct length for the spacers; all bolts do not need to be inserted.
- The spacer for the water pump bolt will need to be cut for a correct fit due to variations in castings from different manufacturers.
  - The correct length for a stock water pump application is 1-5/8", your application may vary.
  - Cut should be made to narrow end of spacer and must be square.
- Use a straight edge along face of pulleys to ensure all pulleys are square and inline.
  - Supplied shims may have to be added between the spacers for alignment, as shown in illustration.
  - Depending upon your configuration, one or more of the spacers may need to be shortened further if sharing the mounting position with additional accessories (i.e. A/C bracket, coil, etc.).



5. Unbolt assembly.
6. Install bracket and spacers using 3/8" hardware as shown in first illustration.
  - a. Torque bolts to 12-18 lb. ft.
7. Attach pump to bracket using 5/16" hardware.
  - a. Hardware can be inserted through pulley.
  - b. Upper bolt is the pivot bolt and should be installed 'finger-tight' until belt has been tensioned.
  - c. Lower bolt goes into flange nut and is tightened while holding tension on belt.
  - d. Torque bolt to 12-18 lb. ft.
8. See Hose Kit instructions for hose assembly, routing and hook-up.

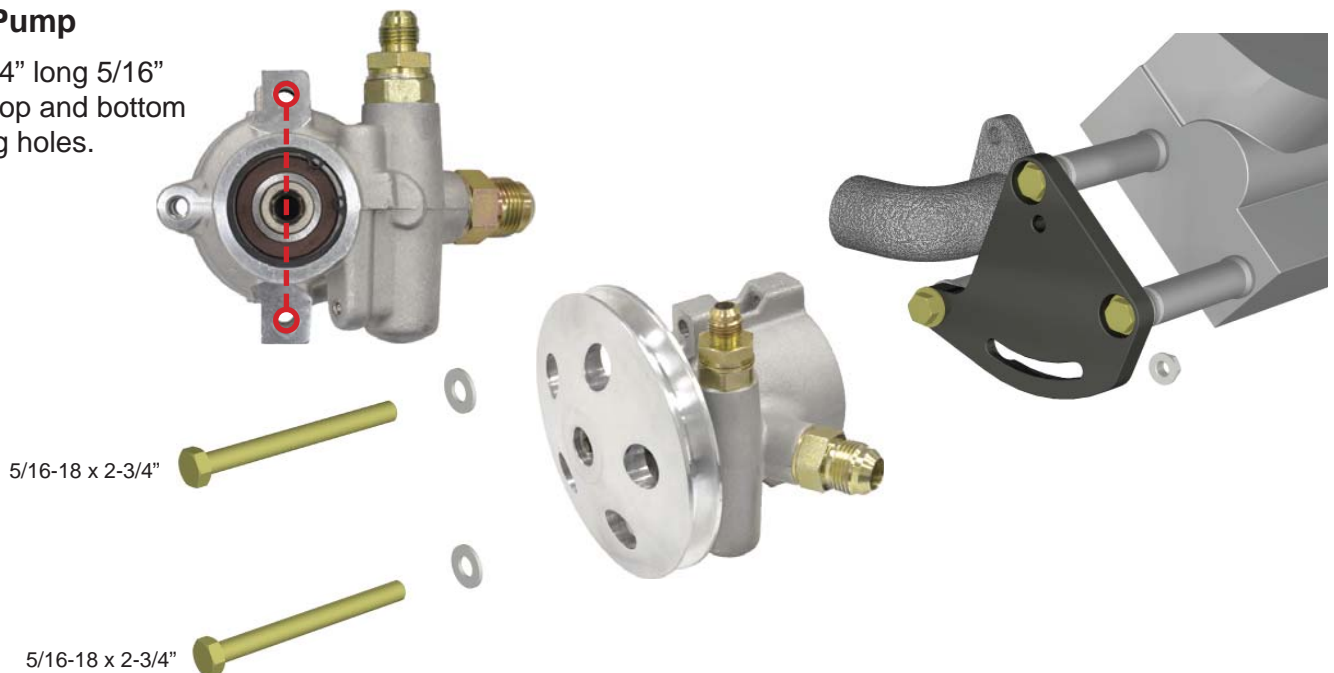
### Pro Pump

Use 3-1/2" long 5/16" bolts at opposite mounting holes; red or yellow pair. Each hole pair changes the final angle of the pump slightly with the belt fully tensioned.



### Street Pump

Use 2-3/4" long 5/16" bolts at top and bottom mounting holes.



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