



S&W Race Cars and Components, Inc.

11 Mennonite Church Road
Spring City, PA 19475

TECH & INFORMATION: 610-948-7303

ORDERS: 1-800-523-3353

OFFICE FAX: 610-948-7342

CAUTION!!! - The most important requirement for a successful installation of this, or any, S&W chassis component is that you take your time and use good common sense. Check & recheck all measurements before cutting or welding. If you have any questions, before or during the installation - STOP - and call our tech line at 610-948-7303 and we will gladly explain in more detail any step in the installation.

Please read complete instructions thoroughly before beginning! Installation Instructions for Steering Column Kit 35-372

This kit contains chrome-moly tubing which will require the use of the TIG (Heli-arc) welder for proper installation.

- 1) Before installing your column, with the engine and headers installed determine the route the steering column will take from the rack & pinion to the drivers compartment. When determining this keep in mind the straighter the column angle the smoother the steering will be and that the maximum angle of the steering u-joints will be 30 degrees, if you need to have more angle for your application you can purchase additional u-joints from S&W Race Cars.
- 2) Install the splined adaptor to the rack & pinion.
- 3) Insert the desired length of 3/4" x .065 chrome-moly into the adaptor and tack weld in position, (the length will vary for your application).
- 4) Insert the steering u-joint onto the end of the 3/4" x .065 chrome-moly and tack weld .
- 5) Insert a second length of 3/4" x .065 chrome-moly (the length will vary for your application) into the steering u-joint then drill a 1/4" hole through the u-joint and the 3/4" chrome-moly securing the chrome-moly to the u-joint with a 1/4" x 1 3/4" bolt and 1/4" nylock nut.

Note: this will complete the assembly of the inner column if you need to install additional u-joints repeat step 4 at this time.

- 6) Insert the two black bushings into each end of the 1 1/4" x .058 chrome-moly.
- 7) Slip the 1 1/4" x .058 chrome-moly with bushings installed over the last section of 3/4" x .065 chrome-moly for the outer column. This will place the outer column on the section of the inner column that will pass through the firewall.
- 8) Place the outer column up to the roll cage or supports from the roll cage and **tack weld** in place.
Note: do not hose clamp in place.
- 9) Place the steering wheel quick disconnect on the end of the inner column and tack weld the inner adapter sleeve to the inner column.
- 10) Install the steering wheel to the quick disconnect.
- 11) Turn the steering wheel through it's travel, checking the clearances between the column and the headers, frame rails, roll cage, motor, motor plate, etc..
- 12) If all clearances are okay, remove the inner column from the outer column and the black bushings from the outer column.
- 13) Finish weld all welds on the inner and outer column.
- 14) Reinstall the bushings in the outer column securing them in place with the 1/8" pop rivets by drilling an 1/8" hole into the tubing and the black bushings (make sure that you don't drill all the way through the bushings it will put the inner column in bind if the rivet comes in contact with it).
- 15) Reinstall the inner column in the outer column resecuring it with the 1/4" x 1 3/4" bolt and nylock nut.

<u>QTY</u>	<u>Part #</u>	<u>Description</u>
1	95-400	Steering wheel quick disconnect
1	35-378F	Pinto splined adapter-female
1	35-067	S/G steering u-joint 3/4" x 3/4"
2	35-390	Bushings for outer column
2	65-800	1/8" x 1/16"-1/8" grip steel pop rivet
1	65-008	1/4" x 1 3/4" g8 fine bolt
1	65-130	1/4" fine nylock nut
1	750x065cmx24	3/4"x065 chrome-moly tubing 24" long
1	750x065cmx60	3/4"x065 chrome-moly tubing 60" long
1	1250x058cmx36	1 1/4"x058 chrome-moly tubing 36" long