



Retrofit Steering Column Installation Instructions

for 1973-77 Ford Trucks

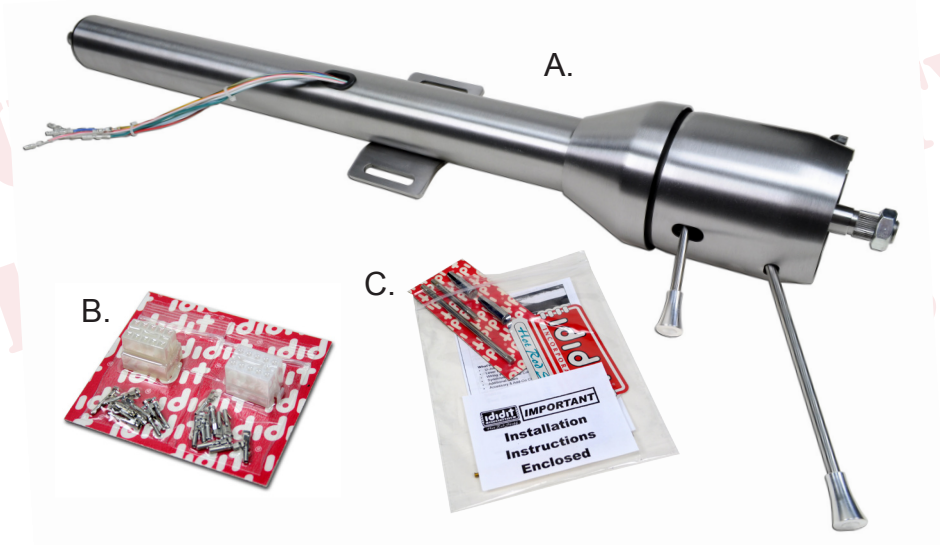
For #'s 1170755010, 1170755020, 1170755051



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Instruction #: 8000000041 REV 10/10



These are the components that come with the column.
 (Paintable Steel Column pictured)

- A.) 1. Column
- B.) 1. Ford Wire Plug
- C.) 1. Instructions & Dress Up Kit (2 knobs & levers)
 (Dress Up Kit installed on this column)

***Installation will require a 3/4" DD x 3/4" 36 Rag Joint.
 The original joint cannot be used.***

We will work through this installation using all these parts. For instruction purposes we will assume your truck is all original and has a factory manual steering gear box and an OEM harness.

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This column is unique. We hated the idea of having one column for 2 wheel drive and a different one for 4X4, let alone power vs. manual steering. So “Voila” **this column is a variable length column**. If you grab the lower shaft and pull, it extends to all the lengths you may need. It is a pretty well known fact that the Bendix power box and the Saginaw power box were interchanged fairly regularly. This requires a different length column.

The shaft of the column telescopes; it creates a relief point for the flex in the frame and body mounts. This protects and increases the life expectancy of the Rag-Joint.

The column is shipped with the shaft collapsed so don't panic if the steering column looks short when you lay it next to the OEM column. Just pull the shaft out and match it up.



Shaft Collapsed



Shaft Extended

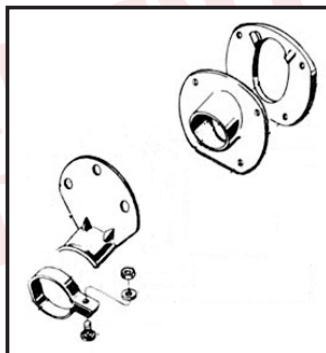
REMOVAL of OEM Column: Disconnect positive battery cable.

- 1.) Loosen and remove the pinch bolt on the rag joint.
- 2.) Loosen and remove the clamp that is on the firewall mount on the engine side of the firewall.
- 3.) From the inside of the cab remove the bolts that hold the seal to the firewall. Slide this mount up the column to make sure it is loose from the floor.
- 4.) Carefully disconnect the wiring connector/connectors from the dash harness. (Please take care when doing this as the connectors are fragile and we will be re-using them)
- 5.) Loosen the two remaining bolts that hold the column to the dash. (Note that when these last two bolts are removed the column will fall free.)
- 6.) Now you should be able to pull the column toward you and this should release from the rag-joint. If this is being difficult to remove, you may need to pry or split the rag-joint open a little in the engine bay. Normally by using a regular screwdriver in the split and twisting is sufficient.

Steps before mounting the column:

Floor Mount

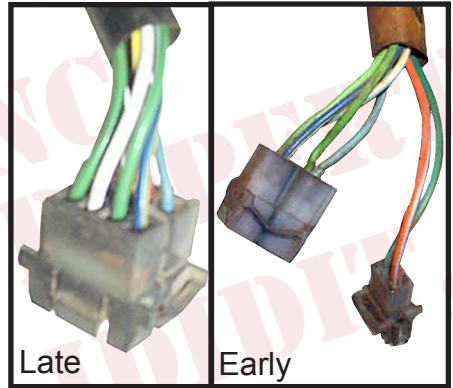
The OEM column mount will be re-used as is. This might be a good time to replace the seal at the firewall as this is what keeps the water and fumes out of the cab. Many aftermarket reproduction businesses should sell these types of floor mount seals.



Please note there are two different versions of this mount. One is for power steering with a Saginaw box and one is for manual or power with a Bendix type power box. If you don't know which one you have the Bendix box has a large "B" cast into the side of it. The Bendix box is the same length as the manual box. The Saginaw box is two inches longer.

Wiring

If your wiring is still intact, you could use your original plug. You would plug one wire at a time (matching the original colors on both sides) into the original terminal. Unfortunately, most of the original plugs we were working with were cracked or damaged. ididit has provided an extra set of connectors and terminals with this column. You will have to plug



each wire terminal into these plugs before installation. Remember that these wires have to match the color on the adjoining side.

Rag joint installation

It is easier to install the rag-joint onto the column before installing the column. To install this joint, identify the 3/4DD end and remove the setscrews and jam nuts. Slip the joint over the shaft 7/8 of an inch and install the setscrews into the threaded holes. This should create a witness mark where the set screws will hit. Now remove the setscrews and the joint. With a center punch, create a prick mark so you can use a 1/4 inch drill bit and create a relief for the setscrew. This relief only needs to be approximately 3/16 inch deep.



Now install the rag-joint onto the column using locktite on the setscrews and jam nuts.

INSTALLING NEW COLUMN

(A helper would be a big benefit for the 2-5 steps.)

- 1.) Mask off about 8 inches of the lower part of the tube with masking tape to ensure you are not going to scratch the column following these next few steps. Next, install lower plate and firewall seal. Slide these up the column about 7 inches and tape them into place.
- 2.) From inside the truck, slip the column down thru the hole in the firewall and into the rag-joint. The shaft of the column should engage into the rag joint 7/8 of an inch. Install the two dash bolts loosely.
- 3.) From the engine bay side install and tighten the gearbox side of the rag joint. Remember the rag-joint should be flat and not under stress. Slide the shaft of the column in or out to neutralize the rag joint.
- 4.) Return to the firewall mount and assemble and align the firewall seal and mount. Install the bolts loosely.
- 5.) Finally, tighten the bolts for the dash mount and then the firewall mount. Don't forget the clamp on the engine side that goes around the mount and the steering column.
- 6.) Join the wiring plugs together. If there was damage to the catches on the plug, we would recommend using a zip tie through the middle of the plug. This should keep the plug from coming apart.

Knobs & Levers:

After removing all items from the package, assemble the knobs onto the levers. The tilt lever (shorter of the two levers) goes on the left side of the column in the hole closest to the dash. The column has a threaded hole that this lever threads into.

The turn signal lever (longer of the two levers) goes on the left side of the column in the hole closest to the driver. The column has a threaded hole that this lever threads into.



Wheel Installation:

Make sure your road wheels are pointing straight forward and your column and all mounts are completely secure. Next install your OEM wheel with all of the original components or add an aftermarket wheel with an adaptor. Slide the wheel on top of the splined top shaft of the column. You may need to adjust your wheel a little to fit into the splines. Place wheel nut on top of wheel and torque wheel nut to 35lbs.

Final Check:

Test the electrical system (KEY ON)

- 1.) Turn Key on and test turn signals for function and to verify they cancel when turning the wheel.
- 2.) Test the brake lights by depressing the brake pedal.
- 3.) Test the horn

Your installation is now complete!

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