

# 1966-71 Ford Bronco Tilt Steering Column Installation Kit Instruction Sheet

PLEASE READ BEFORE YOU BEGIN TO INSTALL COLUMN

*Flaming River all new parts pledge.*

The best in the business and a three-year warranty. Flaming River tilt steering columns come complete with aluminum dress-up kit, which includes: turn signal arm with Phillips screw, tilt lever, hazard knob with screw, and steering wheel hold nut. Flaming River also has a full range of steering column accessories including steering wheels, custom wheel adapters, floor mounts, and column drops.



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## STEERING COLUMN INSTALLATION TIPS

- Be sure the column you have selected is the proper length before you begin installation.
- DO NOT activate the column "tilt" mechanism before installation. This can cause injury or damage to the column.
- You must install a neutral safety switch on all automatic transmissions. Your vehicle will start in any gear without it.
- The end of the Flaming River column is a 1"DD hollow shaft and Flaming River has a complete line of universal joints and shafts available to complete your steering installation after the column is installed in your vehicle.



## PARTS LIST

Qty	Description
1	Steering column with OEM style dash mount
1	Wiring harness
1	Canceling cam, compression spring and horn contact wire
1	Steering wheel hold down nut
1	Dress-up kit
1	Swivel floor mount
1	Slip shaft kit with U-Joint

# TILT STEERING COLUMN INSTALLATION

(See facing page for reference photos)

1. Position column so that the tube extends through the firewall and into the engine compartment approx. 4".
2. Attach the included OEM dash mount to hold the column in place.
3. Slide floor mount over bottom of column tube inside engine compartment. Position floor mount against firewall and screw into place.
4. Make any final adjustments and tighten all the clamps.
5. Install the turn signal arm using the phillips screw provided. Then the tilt arm, and finally the hazard knob using the allen screw provided.
6. Connect the included wiring harness to your vehicle's wiring.  
(If not using included wiring harness, you may want to order FR20118, Female Wiring Connector Kit)

## INSTALLING THE STEERING WHEEL

The spline on your new Flaming River steering column is a GM spline designed from 69 to present steering wheels without an airbag. The horn wire is furnished with your steering column and is pre-installed into the canceling cam.

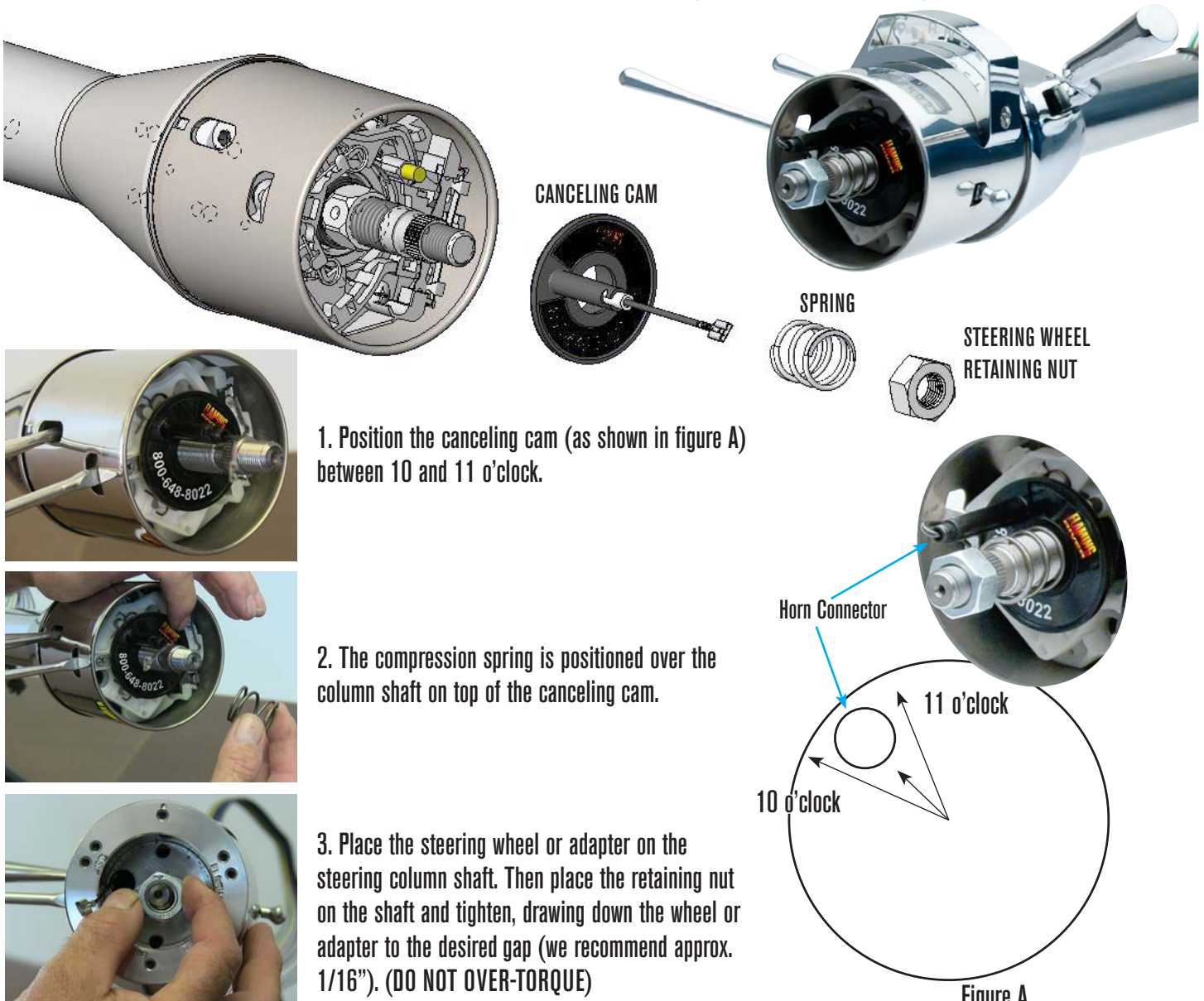
For More Tech Tips Visit  
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or call 1-800-648-8022



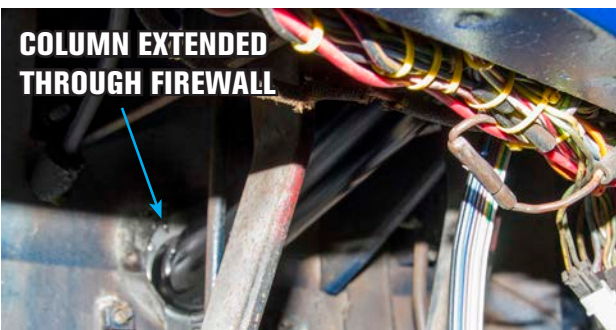
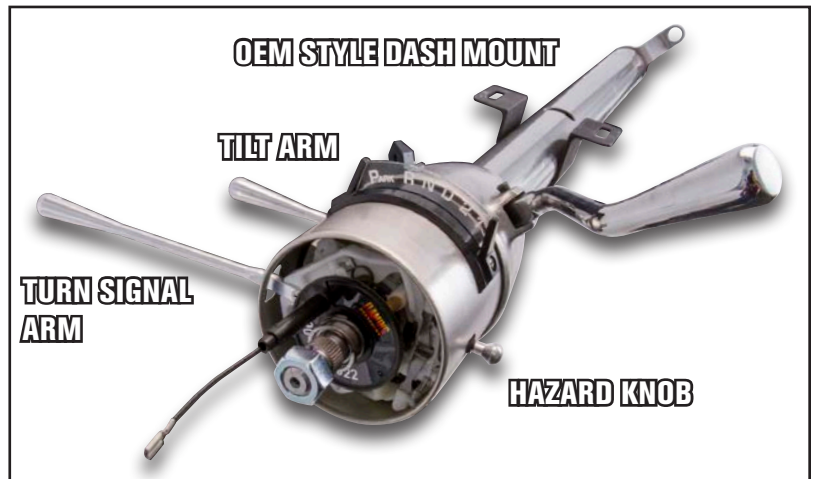
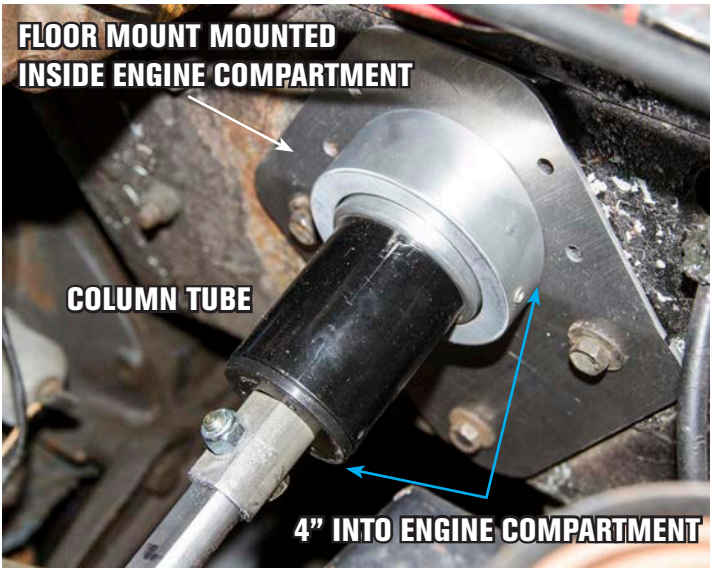
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## INSTALLING THE CANCELING CAM (NON-KEY COLUMN)

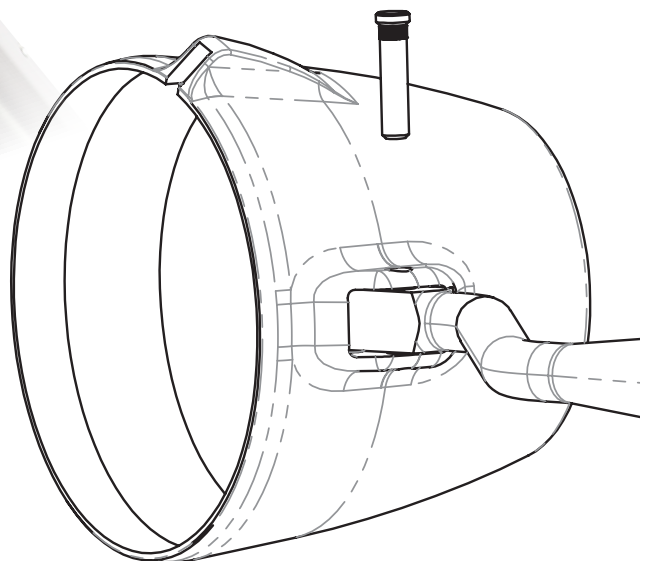
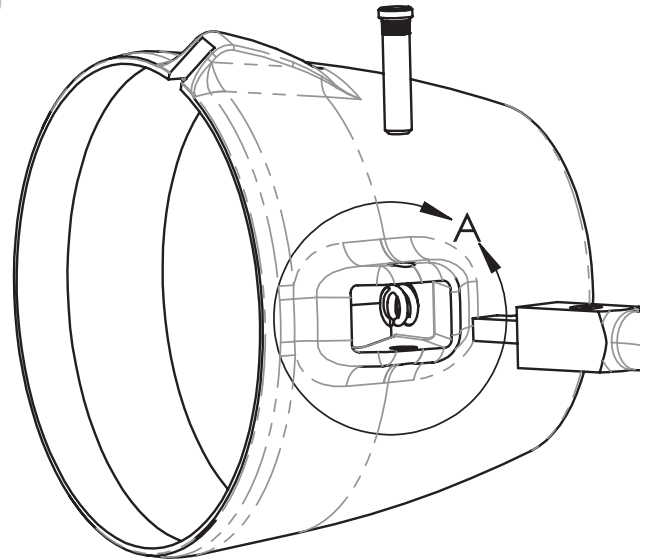
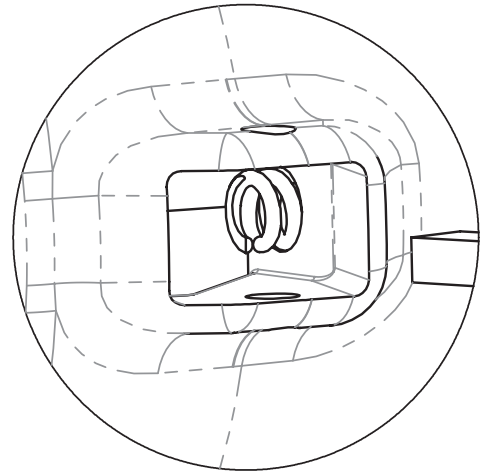


# COLUMN INSTALLATION PHOTOS



## **GEAR SHIFT ARM INSTALLATION - APPLIES TO COLUMN SHIFT COLUMNS ONLY**

1. Grease spring and insert it into the casting hole. Care must be taken not to drop the spring into the casting. Grease and a small screw driver may help with installation.
2. Position the arm into the casting so the pin hole in the arm is in relation to the pin hole in the casting.
3. Grease the smooth end of the pin and start it into the casting pin hole.
4. Using a hammer and drift, gently tap the pin into the casting until flush. **DO NOT USE EXCESSIVE FORCE** - this may damage the casting.



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or call 1-800-648-8022**



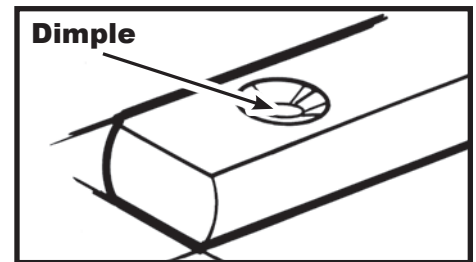
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## **SLIP SHAFT KIT/U-JOINT INSTALLATION**

1. Before removing anything from your steering system, be sure your truck steering is in the central position. Compare your new Flaming River shaft unit to the original steering shaft, visually compare the length, & note the column and steering box spline size.
2. Remove the OEM steering shaft & rag joint from the steering box.
3. Position the 3/4"-36 side of universal joint in place on the steering box, then place 1" DD side of shaft into u-joint. Snug set screw to hold the u-joint in place on box shaft. Tighten set screw onto 1" DD shaft to mark for indenting.
4. Mark top portion of slip shaft (3/4" DD Shaft) to a length that allows 2-3" to extend into column shaft, remove from steering box and then cut with a hacksaw.
5. Insert 3/4" DD shaft 2-3" into column shaft, then using a 5/16" drill bit, drill through column shaft and slip shaft. Insert 5/16" grade 8 bolt and nut and tighten.
6. Follow shaft indent instructions below to finalize installation. If the steering wheel is off center, you may have to adjust the steering box u-joint to the right or left by one spline. No front-end alignment should be necessary.

- Set screws are supplied on all Splined & "Double D" u-joints. However, it is necessary to indent (by drilling) the shaft to properly secure the set-screw mechanism. Loc-Tite should also be used.
- The shaft should be flush with the ends of the u-joint yoke – too short could sacrifice strength, and too long will cause the shaft to interfere with the operation on the u-joint.



### **IMPORTANT:**

When fitting these parts, it is imperative that the instructions in the vehicle manufacturer's workshop manual are followed implicitly in the interest of the safety of the vehicle & satisfactory performance of the part

### **CAUTION:**

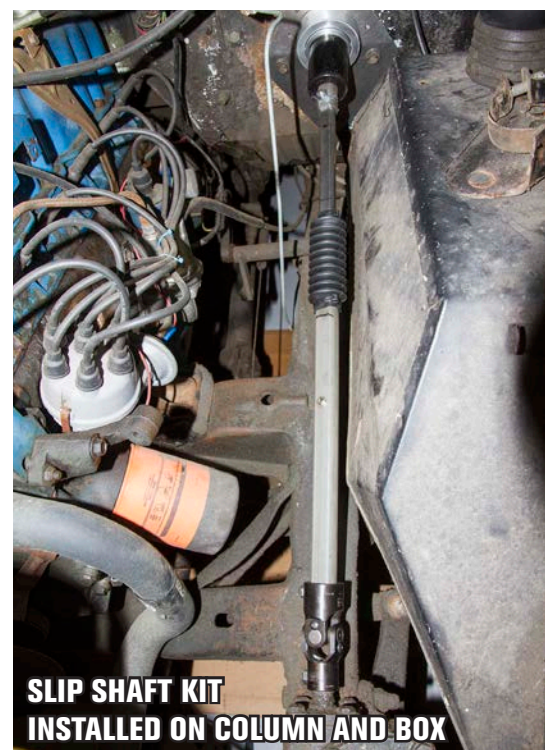
Safe chassis repairs require specialized tools, techniques, & experience. These parts should be installed by competent professional mechanics. **NEVER WELD U-JOINTS.**



**DRILL 5/16" HOLE AND  
INSERT BOLT**

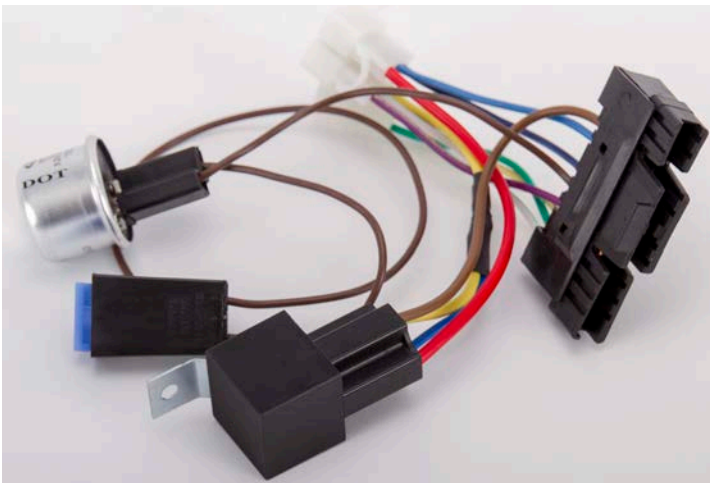


**U-JOINT INSTALLED ON  
BOX AND SHAFT**



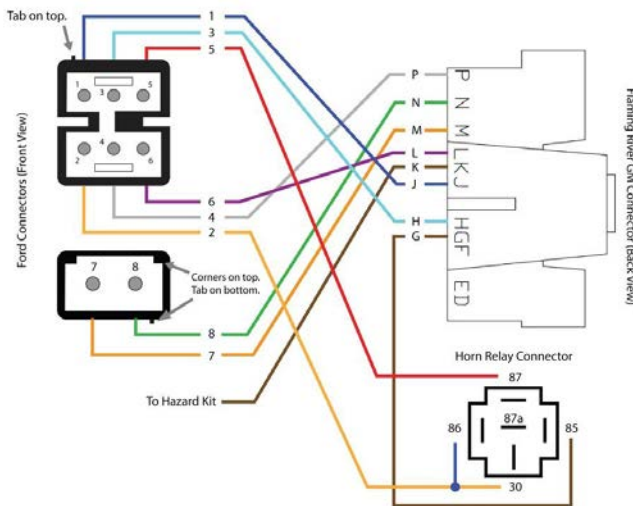
**SLIP SHAFT KIT  
INSTALLED ON COLUMN AND BOX**

## FR20301 WIRING HARNESS FOR 1966 BRONCO.



The Ford Mustang Wiring Adapter (FR20301) unites the 4-1/4" female connector from your Flaming River column wiring harness with the two stock Ford connectors in your vehicle while adding hazard light functionality, and includes a horn relay. This adapter is designed for Ford Mustang models 1965 -1966 that use this style connector in turn signal switch wiring harnesses. Also fits the 1966 Ford Bronco.

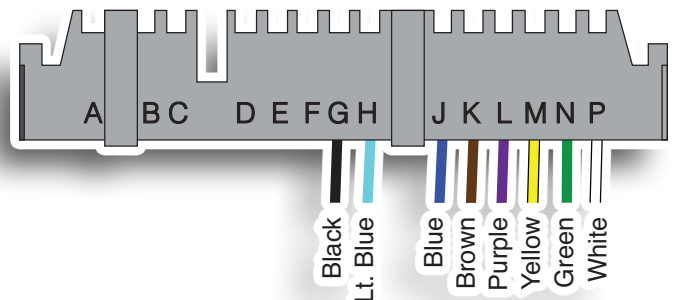
### FR20301 PIN-OUT.



Function	FR Conn.	Ford Conn.	Relay
Horn Relay (+12V)	G	---	85, Brown
Left Front Turn Signal	H	3	---
Right Front Turn Signal	J	1	---
Hazard Power (+12V)	K	---	---
Turn Signal Power (+12V)	L	6	---
Left Rear Turn Signal	M	7	---
Right Rear Turn Signal	N	8	---
Brake Light Power (+12V)	P	4	---
Ford Horn 1	---	2	30, Yellow & 86, Blue
Ford Horn 2	---	5	87, Red

**IF NOT USING THE BRONCO WIRING HARNESS, REFER TO THE DIAGRAM BELOW FOR WIRING INFORMATION.**

Pin Location	Column Wiring	Wiring Circuit
P	White	Brake Light Switch
N	Dark Green	Right Rear Turn Signal
M	Yellow	Left Rear Turn Signal
L	Purple	Turn Signal Power
K	Brown	Hazard Power
J	Dark Blue	Right Front Turn Signal
H	Light Blue	Left Front Turn Signal
G	G	Horn



**NOTE: If your vehicle (female plug) is not the correct size, you can purchase the FR2018 adapter kit.**





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