



IBEX 4409 GM VORTEC TRUCK P-PUMP & CBR/TC BRACKET

Thank you for purchasing Goat Built components, before starting your installation, we recommend that you read through these instructions to familiarize yourself with the steps and parts so you can plan and prepare for your install accordingly.

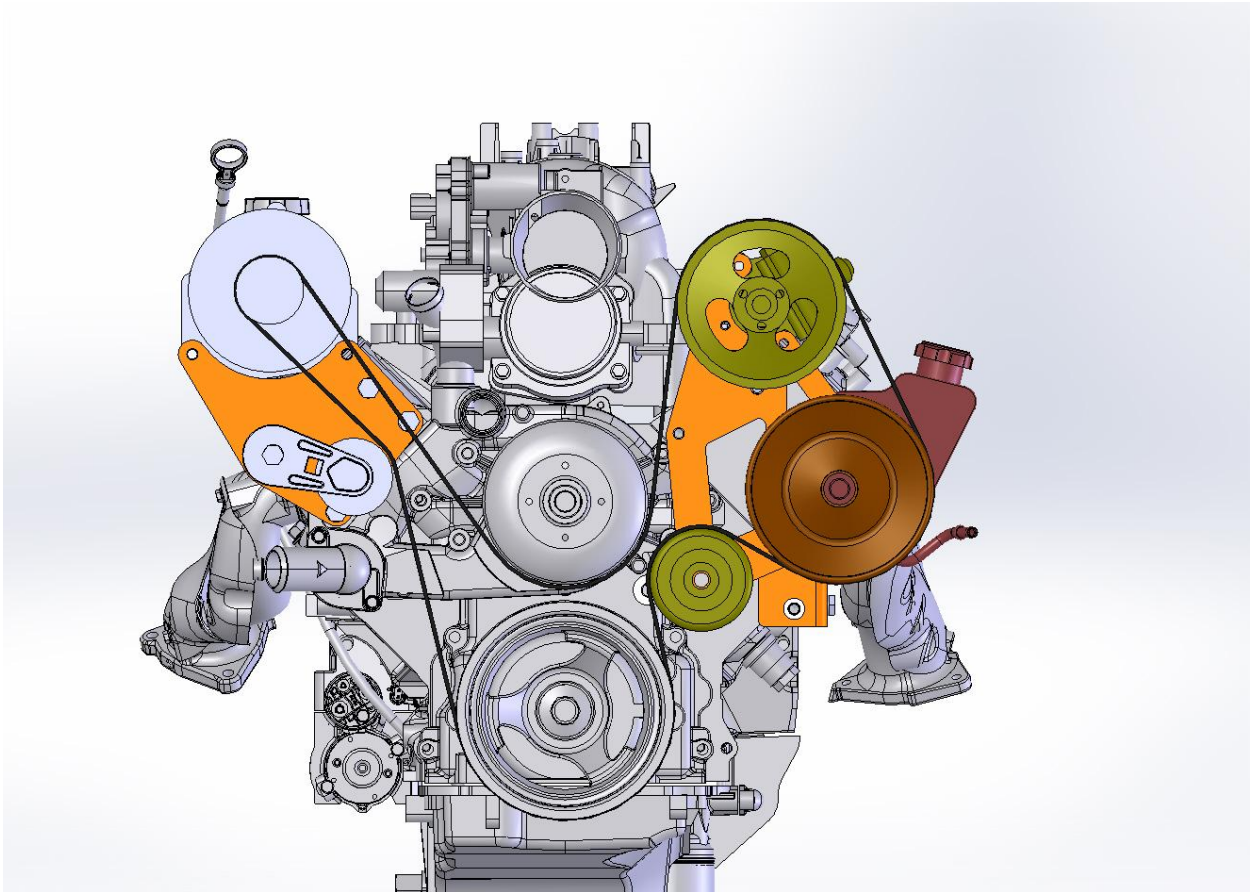
A few notes about the 4409 P-pump CBR/TC bracket:

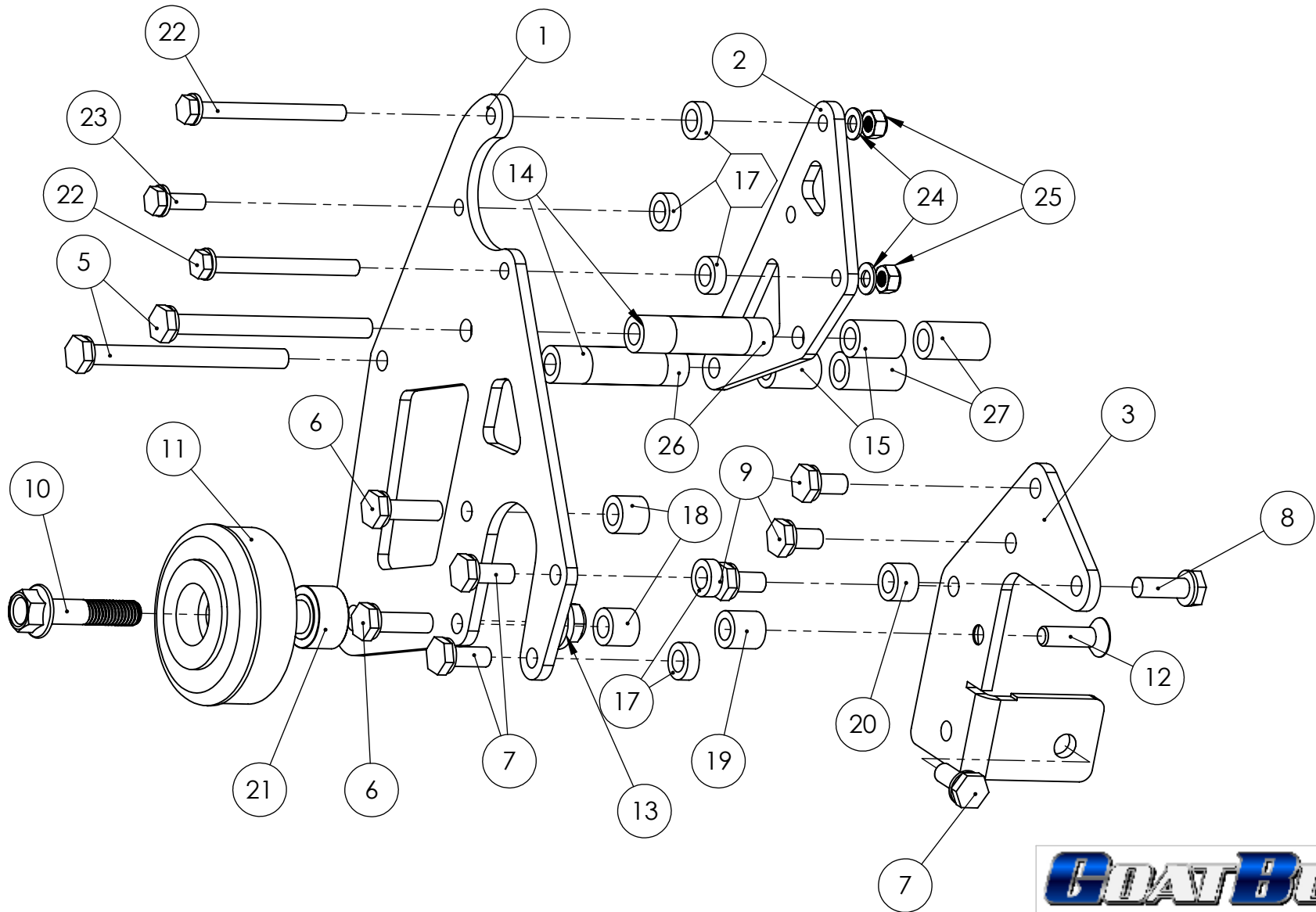
- This bracket kit is intended for 99 to current GM truck Vortec 4.8/5.3/6.0 pulley spacing, including balancer water pump and idler pulley.
- You can use a CBR or TC pump on the top, you will use different spacers for the different pumps, spacers for both pumps are included, refer to the attached drawing for the correct ones, you will end up with extra spacers in the end.
- A 90 degree pressure fitting is recommended at the back of the P-pump for head clearance.
- If you want to use an F-body water pump you will need 3/4" water pump spacers with the F-body water pump to get the pulley lined up.
- There are a few different variables to determine the belt length, there are different power steering pump pulleys and alternator sizes, you will need to figure out what length belt works best for your specific installation.

1. Remove the P-pump pulley using an appropriate puller
2. Remove the 2 bolts that attach the reservoir can to the back of the P-pump body, these often have a threaded stud on them
3. Insert 3 M10 x 20 bolts with lock washers in the 4401-03 bracket, these bolts thread into the front of the head and must be inserted in the bracket before the pump is installed
4. Attach the P-pump to the 4401-03 bracket using the M10x30 bolt with lock washer and .488" spacer and the M10 flat head socket screw with .733" spacer. Tighten to 40 ft-lbs
5. Install the P-pump and 4401-03 bracket assembly to the engine head and block and tighten the M10 x 20 bolts behind the pump. They are difficult to access; you will need to tighten each of the bolts with an open end wrench a few turns at a time. Install the M10 x 25 bolt to the side of the block with a lock washer and flat washer under the bolt head. Some engines may have a tapped hole in the front of the block under the pump, a bolt is not included in this kit for that, but install a bolt there if your engine is tapped for that bolt. Tighten to 40 ft-lbs
6. Install the 4409-01 bracket to the front of the P-pump using the M10x35 bolts and .627" spacers in the holes closest to the water pump, use the M10 x 25 bolts and .267" spacers in the holes furthest from the water pump, use a lock washer under the bolt heads. Tighten to 40 ft-lbs
7. Install your TC or CBR pump to the back of the 4409-01 bracket using the M8 x 20 and 90 bolts. If you are using a TC pump, use the .267 spacers between the back of the 4409-01 bracket and the front of the TC pump, omit these spacers on a CBR pump and bolt the CBR pump directly to the back of the 4409-01 bracket.
8. Install the 4409-02 bracket between the CBR/TC pump and head using the M10x120 bolts with lock washers. The 2.275" spacers go between the 4409-01 and 4409-02 brackets on a CBR,

2.542 spacers on a TC pump. The 1.340 spacers go between the 4409-02 bracket and head on a CBR pump, 1.073 on a TC.

9. Tighten all the M10 bolts to 40 ft lbs, M8 bolts to 15 ft-lbs
10. Remove the stock bolt and spacer from the stock idler pulley. Install the pulley to the 4409-01 bracket using the supplied 1/2" flange bolt, 4400-04 spacer and 1/2 flange nut. Torque to 70 ft-lbs
11. Install the pump pulley using an appropriate power steering pulley install tool, do not use a hammer to install the pulley, you will damage the pump.





17 USE THESE ON TC PUMP ONLY



TITLE:
**DUAL P/S PUMP BRKT
 CBR/TC AND P-PUMP**

SIZE	DWG. NO.
A	4409

SCALE: 1:1	WEIGHT:	SHEET 1 OF 2
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ITEM NO.	PART NUMBER	DESCRIPTION	4409-TC/QTY.
1	4409-01	FRONT BRACKET	1
2	4409-02	MID BRACKET	1
3	4401-03	REAR BRACKET	1
5	120	M10 X 120 BOLT	2
6	35	M10 X 35 BOLT	2
7	25	M10 X 25 BOLT	3
8	30	M10 X 30 BOLT	1
9	20	M10 X 20 BOLT	3
10	IDLER BOLT	1/2" FLANGE BOLT	1
11	IDLER	STOCK TRUCK IDLER	1
12	35	M10 X 35 FLAT HEAD BOLT	1
13	92018A540	1/2" UNC FLANGE LOCK NUT	1
14	4400-2542	2.542" SPACER (TC ONLY)	2
15	4400-1073	1.073" SPACER (TC ONLY)	2
17	4400-0267	.267" SPACER **DO NOT USE THE 3 WITH A CBR PUMP**	5
18	4400-0627	.627" SPACER	2
19	4400-0733	.733" SPACER	1
20	4400-0488	.488" SPACER	1
21	4400-04	IDLER SPACER	1
22	90	M8 X 90 BOLT	2
23	25	M8 X 25 BOLT	1
24	FLAT WASHER	M8 FLAT WASHER	2
25	LOCK NUT	M8 NYLOCK NUT	2
26	4400-2275	2.275" SPACER (CBR ONLY)	2
27	4400-1340	1.340" SPACER (CBR ONLY)	2



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SCALE: 1:1 WEIGHT: SHEET 2 OF 2