

# STEERING GEAR

14

GROUP PART NAME and DESCRIPTION	PART NUMBER	MODELS	P E R C A R
<b>14.100 - STEERING GEAR</b>			
Gear (incl. Column and Shaft)(Housing with Needle Bearings).....	214416	# 545	1
Gear (incl. Column and Shaft).....	215810	542 ## 545	1
Bolt, 7/16"-20 x 4 3/4" Hx. Hd.....	GM-187317	542 545	3
Flatwasher, 15/32" I.D. x 15/16" O.D. x 1/8".....	201471	542 545	3
Locknut, 7/16"-20 Hx.....	GM-442830	542 545	3
<b>14.102 - STEERING GEAR HOUSING</b>			
Housing (incl. Shaft Needle Bearings and Upper Bearing Cup).....	214417	# 545	1
Housing (incl. Bearings and Upper Bearing Cup).....	215811	542 ## 545	1
Needle Bearing.....	214418	542 545	2
Spacer, Needle Bearing.....	215038	542 545	1
Seal, Housing.....	215812	542 ## 545	1
<b>14.104 - STEERING GEAR HOUSING END COVER</b>			
Cover (incl. Grease Tube).....	201193	542 545	1
Bolt, 5/16"-18 x 9/16" Hx. Hd.....	202758	542 545	4
<b>14.106 - STEERING COLUMN JACKET</b>			
NOTE: For Hydra-Matic Parts see Hydra-Matic Parts List			
Jacket (incl. Bearing)(Prime).....	213262	# 545	1
Weatherseal (Front)(thru Dash).....	208661	# 545	1
Weatherseal (Rear)(thru Dash).....	208372	# 545	1
Fastener.....	205063	# 545	4
Weatherseal.....	215813	542 ## 545	1
Plate, Weatherseal.....	215814	542 ## 545	1
Screw, No. 10-12 x 1 1/2" Ov. Hd. Cr. Rec. Tap.....	GM-162487	542 ## 545	4
<b>14.108 - STEERING COLUMN JACKET BEARING</b>			
NOTE: For Hydra-Matic Parts see Hydra-Matic Parts List			
Bearing.....	208373	# 545	1
Spacer.....	208374	# 545	1
Spring.....	212794	# 545	1
Bearing.....	215815	542 ## 545	1
Cup, Bearing.....	215816	542 ## 545	1
Washer, Bearing.....	215817	542 ## 545	1
Snap Ring, Bearing.....	215818	542 ## 545	1
Pin, Bearing.....	215819	542 ## 545	1
<b>14.110 - STEERING GEAR COLUMN AND WORM</b>			
Column and Worm.....	208376	# 545	1

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GROUP PART NAME and DESCRIPTION	PART NUMBER	MODELS	PEAR
<b>14.110 - STEERING GEAR COLUMN AND WORM (CONT'D.)</b>			
Column and Worm.....	215820	542 ## 545	1
Shim, .002.....	201190	542 545	*
Shim, .005.....	201191	542 545	*
Shim, .010.....	201192	542 545	*
<b>14.112 - STEERING GEAR WORM THRUST BEARING CUP</b>			
Cup, Upper.....	201188	542 545	1
Cup, Lower.....	201189	542 545	1
<b>14.114 - STEERING GEAR WORM THRUST BEARING ROLLER AND CAGE</b>			
Roller and Cage.....	201187	542 545	2
<b>14.116 - STEERING GEAR SHAFT AND ROLLER</b>			
Shaft and Roller (with Needle Bearings).....	214419	542 545	1
Seal.....	214414	542 545	1
Screw, Adjusting, 1/2"-20.....	201198	542 545	1
Locknut, 1/2"-20 Hx.....	201200	542 545	1
Lockplate.....	201199	542 545	1
Thrustwasher.....	202760	542 545	1
<b>14.118 - STEERING GEAR SHAFT COVER</b>			
Cover.....	207761	542 545	1
Bolt, 5/16"-18 x 9/16" Hx. Hd.....	202758	542 545	4
Plug, Oil.....	201204	542 545	1
Gasket.....	201203	542 545	1
<b>14.119 - STEERING GEAR FLEXIBLE COUPLING</b>			
Flange.....	215821	542 ## 545	2
Bolt, 5/16"-24 x 1 3/8" Hx. Hd.....	GM-106282	542 ## 545	2
Locknut, 5/16"-24 Hx.....	GM-443320	542 ## 545	2
Insulator and Bushing.....	215822	542 ## 545	1
Bolt, 5/16"-24 x 1 3/4" Hx. Hd.....	GM-123798	542 ## 545	6
Locknut, 5/16"-24 Hx.....	GM-443320	542 ## 545	6
Cable (incl. Terminals) Coupling Ground.....	215919	542 ## 545	1
<b>14.120 - STEERING GEAR SUPPORT (AT INSTRUMENT BOARD)</b>			
Clamp, Lower (Prime).....	213574	# 545	1
Bolt, 5/16"-18 x 1 1/8" Hx. Hd.....	GM-122022	# 545	2
Lockwasher, 5/16" Ext. Tooth.....	GM-138485	# 545	2
Shim (around Jacket).....	213575	# 545	1
Support Assembly (Steering Column to Dash).....	213576	# 545	1
Anti-Squeak.....	201806	# 545	4
Flatwasher, 3/8" Sm.....	GM-120394	# 545	4

\*As Required

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GROUP PART NAME and DESCRIPTION	PART NUMBER	MODELS	P E R C E N T
<b>14.120 - STEERING GEAR SUPPORT (AT INSTRUMENT BOARD) (CONT'D.)</b>			
Lockwasher, 3/8" Med. .... [ to ] .....	GM-120382	# 545	4
Nut, 3/8"-16 Hx. .... [ Dash ] .....	GM-120377	# 545	4
Support, Steering Column to Side Panel.....	213577	# 545	1
Bolt, 5/16"-18 x 1 1/8" Hx. Hd.....	GM-122022	# 545	1
Lockwasher, 5/16" Ext. Tooth.....	GM-138485	# 545	1
Flatwasher, 5/16" Sm.....	GM-120393	# 545	1
Nut, 5/16"-18 Hx.....	GM-120376	# 545	1
Insulator, Ignition Switch (on Steering Column).....	213806	# 545	1
<b>14.122 - STEERING GEAR JACKET COVER</b>			
Cover, Upper (Prime).....	208383	# 545	1
Cover, Lower (Prime).....	213578	# 545	1
Screw, No. 10-12 x 3/8" Rd. Hd. Cr. Rec. Tap. (Upper to Lower Cover).....	GM-161644	# 545	7
Screw, Washerhead (Lower Cover to Lower Bracket)....	205680	# 545	2
Screw, No. 8-15 x 3/8" Rd. Hd. Cr. Rec. (Lower Cover to Upper Bracket).....	GM-161628	# 545	3
Filler, Cover to Instrument Board.....	208385	# 545	1
Bracket (with Stud).....	209782	# 545	1
Clamp (less Stud).....	209785	# 545	1
Lockwasher, No. 10 Ext. Tooth.....	GM-138479	# 545	2
Nut, No. 10-32 Hx.....	GM-120614	# 545	2
Collar, Jacket to Cover Support, Upper.....	208388	# 545	1
Screw, No. 10-24 x 7/8" Rd. Hd. Sl.....	GM-155128	# 545	1
Lockwasher, No. 10 Ext. Tooth.....	GM-138479	# 545	1
Nut, No. 10-24 Hx.....	GM-120361	# 545	1
Support, Cover to Collar.....	208387	# 545	1
Screw, No. 8-15 x 3/8" Rd. Hd. Cr. Rec. Tap.....	GM-161627	# 545	3
Cover, Upper.....	215823	542 ## 545	1
Screw, No. 10-24 x 7/16" Ov. Hd. Cr. Rec. [ Upper to Lockwasher, No. 10 Ext. Tooth..... [ Lwr. Cover ]	GM-156956	542 ## 545	2
Emblem, Upper Cover.....	215824	542 ## 545	1
Retainer, Emblem.....	215825	542 ## 545	1
Screw, No. 8-32 x 1/4" Rd. Hd. Cr. Rec. Tap.....	GM-164012	542 ## 545	2
Cover, Lower.....	215826	542 ## 545	1
Bolt, 5/16"-18 x 3/4" Ov. Hd. Cr. Rec. [ to Lockwasher, 5/16" Int. Ext. Tooth..... [ Housing ]	GM-157523	542 ## 545	1
Nut, 5/16"-18 Hx.....	GM-120376	542 ## 545	1
Bolt, 5/16"-18 x 5/8" Hx. Hd..... [ Lower Lockwasher, 5/16" Ext. Tooth..... [ Cover ]	GM-120228	542 ## 545	2
Flatwasher, 5/16" Sm..... [ to Cowl Nut, 5/16"-18 Hx..... [ Bracket ]	GM-138485	542 ## 545	2
Bolt, 5/16"-18 x 5/8" Hx. Hd..... [ Lower Cover Bolt, 5/16"-18 x 1/2" Hx. Hd..... [ to Lower Lockwasher, 5/16" Ext. Tooth..... [ Instrument Nut, 5/16"-18 Hx..... [ Board ]	GM-120393	542 ## 545	3
Bracket, Lower Cover to Cowl.....	GM-120376	542 ## 545	1
	GM-120228	542 ## 545	1
	GM-120834	542 ## 545	1
	GM-138485	542 ## 545	2
	GM-120376	542 ## 545	1
	215827	542 ## 545	1

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GROUP PART NAME and DESCRIPTION	PART NUMBER	MODELS	P E C E S
<b>14.122 - STEERING GEAR JACKET COVER (CONT'D.)</b>			
Bolt, 5/16"-18 x 1/2" Hx. Hd.....	GM-120834	542 ## 545	2
Lockwasher, 5/16" Ext. Tooth.....	GM-138485	542 ## 545	2
Flatwasher, 5/16" Sm.....	GM-120393	542 ## 545	2
Housing (incl. Tubing Extension)(Prime).....	215828	542 ## 545	1
Bolt, 5/16"-18 x 2" Hx. Hd.....	GM-122065	542 ## 545	2
Lockwasher, 5/16" Int. Ext. Tooth...	GM-178532	542 ## 545	6
Nut, 5/16"-18 Hx.....	GM-120376	542 ## 545	6
Bracket, Housing to Dash.....	215829	542 ## 545	1
"U" Bolt, Housing to Dash Bracket.....	215830	542 ## 545	1
Lockwasher, 5/16" Med.....	GM-120214	542 ## 545	2
Nut, 5/16"-18 Hx.....	GM-120376	542 ## 545	2
Shield, Dust.....	215831	542 ## 545	1
Clamp Wire, Dust Shield.....	215832	542 ## 545	1
<b>14.126 - STEERING WHEEL</b>			
Steering Wheel (Plastic)(Starlight Pearl).....	209786	# 545	1
Steering Wheel (Persian Gray).....	215833	542 ## 545	1
Steering Wheel (Blue Comet).....	215834	542 ## 545	1
Steering Wheel (Signal Green).....	215835	542 ## 545	1
Steering Wheel (Copper Dust).....	215836	542 ## 545	1
Steering Wheel (Black).....	215837	542 ## 545	1
Nut, 5/8"-18 Hx.....	201206	542 545	1
<b>14.200 - STEERING GEAR LEVER ARM (PITMAN)</b>			
Arm (with Ball Connection to Drag Link)(less Power Steering).....	212386	542 545	1
Arm (with Power Steering).....	214477	542 545	1
Stop Bolt, 5/16"-18 x 1" Hx. Hd.....	GM-122017	542 545	1
Jam Nut, 5/16"-18.....	GM-124824	542 545	1
Nut, 1/2"-20 Hx. Sl.....	GM-102647	542 545	1
Cotter Pin, 3/32" Dia.....	GM-103374	542 545	1
Lockwasher, 7/8".....	201216	542 545	1
Nut, 7/8"-14 Hx.....	201217	542 545	1
Plate, Pitman Arm Stop, 2" x 2" x 3/32"	216186	542 545	1
Stop, Pitman Arm (on Frame).....	216187	542 545	1
Bolt, 5/16"-24 x 7/8" Hx. Hd.....	GM-120213	542 545	1
Lockwasher, 5/16" Ext. Tooth.....	GM-138485	542 545	1
Nut, 5/16"-24 Hx.....	GM-121917	542 545	1
Bolt, Adjusting.....	GM-120668	542 545	1
Locknut, 3/8"-24 Hx.....	GM-124925	542 545	1
<b>14.202 - STEERING DRAG LINK</b>			
Link (less Oiler)(with Ball Connection to Pitman Arm).....	212387	542 545	1
Nut, 1/2"-20 Hx. Sl.....	GM-102647	542 545	1
Cotter Pin, 3/32" Dia.....	GM-103380	542 545	1
Clamp.....	201221	542 545	1
Bolt, 5/16"-24 x 1 1/4" Hx. Hd.....	201222	542 545	1

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GROUP PART NAME and DESCRIPTION	PART NUMBER	MODELS	PEAR
<b>14.202 - STEERING DRAG LINK (CONT'D.)</b>			
Lockwasher, 5/16" Hy.....	GM-120638	542 545	1
Nut, 5/16"-24 Hx. Lt.....	GM-121917	542 545	1
Oiler (Straight) 1/4"-28 Taper.....	GM-110347	542 545	2
<b>14.204 - STEERING DRAG LINK STUD COVER</b>			
Cover.....	201219	542 545	1
Shield (Steering Gear End).....	201520	542 545	1
Cover (Steering Gear End).....	201519	542 545	1
<b>14.206 - STEERING DRAG LINK END AND SOCKET</b>			
Socket.....	202077	542 545	1
Bearing.....	201226	542 545	2
Spring.....	201225	542 545	2
Seat.....	201223	542 545	1
Bumper.....	201224	542 545	2
Plug.....	202078	542 545	1
Cotter Pin, 3/32" Dia..	GM-103380	542 545	1
Clamp.....	201221	542 545	1
Bolt, 5/16"-24 x 1 1/4" Hx. Hd.....	201222	542 545	1
Lockwasher, 5/16" Hy.....	GM-120638	542 545	1
Nut, 5/16"-24 Hx. Lt.....	GM-121917	542 545	1
Oiler, 1/4"-28, 90°.....	GM-191350	542 545	1
Oiler (Straight) 1/4"-28 Taper.....	GM-110347	542 545	1
<b>14.212 - STEERING IDLER LEVER</b>			
Lever.....	207223	542 545	1
Bolt, 1/2"-20 x 3 1/4" Hx. Hd.....	GM-112731	542 545	1
Lock.....	207226	542 545	1
Bearing, Upper.....	207225	542 545	1
Bearing, Lower.....	207224	542 545	1
Oiler (Straight) 1/4"-28 Taper.....	GM-110347	542 545	1
<b>14.216 - STEERING TIE ROD</b>			
Tie Rod (incl. Seals and Nuts).....	201235	542 545	2
Tie Rod End (R.H.Thd.).....	201236	542 545	2
Tie Rod End (L.H.Thd.).....	201237	542 545	2
Nut, 1/2"-20 Hx. Sl.....	GM-102647	542 545	4
Cotter Pin, 3/32" Dia.....	GM-103380	542 545	4
Cover.....	201219	542 545	4
Tie Rod, Right.....	214478	542 545	1
Tie Rod, Left.....	214479	542 545	1
Tie Rod End (R.H.Thd.) (Part of 214479) ..	201236	542 545	1
Nut, 1/2"-20 Hx. Sl... [Tie Rod End to Steering] ..	GM-102647	542 545	2
Cotter Pin, 3/32" Dia. [Knuckle Arm] ..	GM-103380	542 545	2
Cover.....	201219	542 545	2

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GROUP PART NAME and DESCRIPTION	PART NUMBER	MODELS		P E R C A R
<b>14.216 - STEERING TIE ROD (CONT'D.)</b>				
Tie Rod Socket (Part of 214478).....	214480	542	545	1
Bearing.....	201226	542	545	4
Spring.....	201225	542	545	2
Bumper.....	201224	542	545	2
Plug.....	214481	542	545	2
Cotter Pin, 1/8" Dia.....	GM-103388	542	545	2
Cover.....	201519	542	545	2
Shield.....	201520	542	545	2
Adjusting Link.....	208393	542	545	2
Clamp.....	201221	542	545	4
Bolt, 5/16"-24 x 1 1/4" Hx. Hd.....	201222	542	545	4
Lockwasher, 5/16" Hx.....	GM-120638	542	545	4
Nut, 5/16"-24 Hx.....	GM-121917	542	545	4
Oiler (Straight) 1/4"-28 Taper.....	GM-110347	542	545	4
Repair Kit (less Power Steering).....	205783	542	545	2
Consists of:				
1 - 201236 Tie Rod End (R.F.Thd.)				
1 - 201237 Tie Rod End (L.H.Thd.)				
2 - GM-103374 Cotter Pin				
2 - 201222 Bolt				
2 - GM-120638 Lockwasher				
2 - GM-121917 Nut				
<b>14.300 - POWER STEERING PUMP UNIT</b>				
Pump Unit (incl. Pump and Reservoir).....	215225	542	545	1
Bracket, Pump Unit Mounting.....	214482	542	545	1
Bolt, 3/8"-24 x 1 1/2" Hx. Hd.....	GM-120677	542	545	2
Lockwasher, 3/8" Ext. Tooth.....	GM-138489	542	545	2
Flatwasher, 3/8" Sm.....	GM-120394	542	545	1
Nut, 3/8"-24 Hx.....	GM-121932	542	545	2
Bolt, 3/8"-16 x 2 1/4" Hx. Hd.....	GM-122188	542	545	1
Bolt, 3/8"-16 x 1 1/8" Hx. Hd.....	GM-122138	542	545	2
Lockwasher, 3/8" Med.....	GM-120382	542	545	2
<b>14.305 - POWER STEERING PUMP</b>				
Pump.....	215896	542	545	1
Body and Bushings.....	214432	542	545	1
Bolt with L/W, Body to Cover.....	214433	542	545	5
Seal ("O" Ring) Body to Cover.....	215051	542	545	1
Gasket, Body to Cover.....	214434	542	545	1
Cover (incl. Bushings and Dowels).....	214442	542	545	1
Pipe, Pump Inlet Stand (to Reservoir).....	214435	542	545	1
Seal ("O" Ring) Stand Pipe to Reservoir.....	214455	542	545	2
<b>14.310 - POWER STEERING PUMP SHAFT AND ROTORS</b>				
Shaft.....	214436	542	545	1
Bearing, Shaft.....	214437	542	545	1

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GROUP PART NAME and DESCRIPTION	PART NUMBER	MODELS	P E A R
<b>14.310 - POWER STEERING PUMP SHAFT AND ROTORS (CONT'D.)</b>			
Snap Ring, Bearing.....	214438	542 545	1
Oil Seal, Shaft.....	214439	542 545	1
Rotors.....	214440	542 545	1
Drive Pin, Inner Rotor.....	214441	542 545	1
<b>14.315 - POWER STEERING PUMP RELIEF AND FLOW CONTROL VALVE UNIT</b>			
Valve Unit.....	214443	542 545	1
Spring, Relief Valve (Reservoir with Filler Cap and Gauge).....	215897	542 545	1
Lock Ring, Relief Valve.....	214445	542 545	1
Spring, Flow Control Valve.....	214446	542 545	1
Restrictor, Flow Control.....	214447	542 545	1
<b>14.320 - POWER STEERING PUMP RESERVOIR</b>			
Reservoir.....	215898	542 545	1
Plate, Reservoir Reinforcing.....	215899	542 545	1
Bolt with L/W.....	214453	542 545	2
Seal ("O" Ring).....	214454	542 545	2
Stud, Reservoir Mounting.....	215900	542 545	1
<b>14.325 - POWER STEERING PUMP RESERVOIR FILTER ELEMENT</b>			
Element, Filter.....	215901	542 545	1
Cover, Relief Valve.....	215902	542 545	1
Spring, Element.....	215903	542 545	1
<b>14.330 - POWER STEERING PUMP RESERVOIR COVER</b>			
Cover.....	215904	542 545	1
Screw.....	215905	542 545	1
Gasket, Screw.....	215906	542 545	1
Washer.....	215907	542 545	1
Speednut.....	215908	542 545	1
Gasket, Cover.....	215909	542 545	1
Filler Cap and Gauge.....	215910	542 545	1
<b>14.335 - POWER STEERING PUMP PULLEYS</b>			
Pulley, Pump.....	214464	542 545	1
Key.....	214465	542 545	1
Flatwasher.....	214466	542 545	1
Bolt, 5/16"-18 x 1" Hx. Hd.....	GM-122017	542 545	1
Lockwasher, 5/16" Ext. Tooth.....	GM-138485	542 545	1
Pulley, Idler (on Water Pump)(5.654 Dia.).....	207430	# 545	1
Pulley, Idler (on Water Pump)(6.902 Dia.).....	215911	542 ## 545	1
Spacer.....	214484	542 545	1
Bolt, 5/16"-18 x 1 1/4" Hx. Hd.....	GM-122027	542 545	4
Lockwasher, 5/16" Ext. Tooth.....	GM-138485	542 545	4

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GROUP PART NAME and DESCRIPTION	PART NUMBER	MODELS	P E R C A R
<b>14.335 - POWER STEERING PUMP PULLEYS (CONT'D.)</b>			
Pulley, Pump Drive (on Crankshaft)(5.404" Dia.).....	214485	# 545	1
Pulley, Pump Drive (on Crankshaft)(6.554 Dia.).....	215912	542 ## 545	1
Bolt, 7/16"-20 x 3/4" Hx. Hd. .... to .....	GM-100037	542 545	2
Lockwasher, 7/16" Med..... Crankshaft .....	GM-120383	542 545	2
NOTE: Pump Drive Pulley with Supercharger see Group 1.330.			
<b>14.340 - POWER STEERING PUMP DRIVE BELT</b>			
Belt (44" Long).....	214486	# 545	1
Belt (46 1/2" Long).....	215913	542 ## 545	1
<b>14.345 - POWER STEERING PUMP TO POWER LINK HOSE</b>			
Hose, Oil Pressure.....	214487	542 545	1
Connector, Pump to Oil Pressure Hose.....	214448	542 545	1
Seal ("O" Ring) Connector to Pump.....	214449	542 545	1
Connector, Power Link to Oil Pressure Hose.....	GM-125859	542 545	1
Hose, Oil Return.....	214489	542 545	1
Connector, Pump to Oil Return Hose.....	214450	542 545	1
Gasket, Connector to Pump.....	214451	542 545	1
Connector, Power Link to Oil Return Hose.....	GM-442323	542 545	1
<b>14.350 - POWER STEERING POWER LINK</b>			
Power Link.....	215669	542 545	1
Insulator.....	214492	542 545	2
Retainer, Inner..... to .....	214493	542 545	2
Retainer, Outer..... Frame .....	214494	542 545	2
Nut, 1/2"-20 Hx. Th. Sl..... Bracket .....	GM-125366	542 545	1
Cotter Pin, 3/32" Dia.....	GM-103374	542 545	1
<b>14.355 - POWER STEERING POWER LINK PISTON AND ROD</b>			
Piston and Rod (with Guide)(215669 Link).....	215670	542 545	1
<b>14.360 - POWER LINK PISTON ROD GUIDE</b>			
NOTE: Guide not serviced separately, part of Piston Rod.			
Retainer, Rod Guide "T" Seal (215669 Link).....	215671	542 545	1
Rod Guide and Plug Seals Kit (215669 Link).....	215672	542 545	1
Consists of:			
1 - Wiping Ring			
1 - Retainer, Seal			
1 - "T" Seal			
4 - Washer			
1 - "O" Ring			



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14.365 - POWER LINK PISTON ROD PLUG			
Plug.....	215041	542 545	1
14.370 - POWER LINK PITMAN ARMS TUD AND WASHER KIT			
Stud and Washer Kit.....	215673	542 545	1
Consists of:			
1 - Stud (incl. Washer and Oiler)			
2 - Cushion			
2 - Washer, Inner			
2 - Washer, Outer			
2 - Shoe			
1 - Nut and Washer			
1 - Retaining Ring			
14.375 - POWER STEERING POWER LINK TO FRAME BRACKET			
Bracket.....	214495	542 545	1
Bolt, 3/8"-2 1/4 x 1" Hx. Hd.....	GM-120647	542 545	4
Washer.....	212389	542 545	4
Locknut, 3/8"-2 1/4 Hx.....	GM-442828	542 545	4
<b>NOTES</b>			