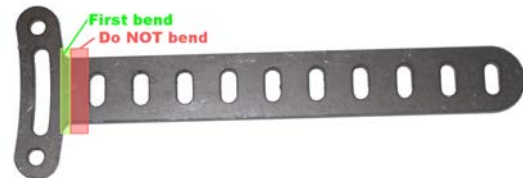


Steering Ring Mounting Bracket – Angle Bending

1. Remove the steering wheel from the vehicle.
2. Place the steering wheel face down on a flat surface.
3. Place the steering ring face down over the steering wheel.
4. Use blocks to raise and level the steering wheel, ensuring that:
 - there is at least 1/4"-1/8" separation between the steering wheel and steering ring
 - the steering ring is centered in relation to the steering wheel column



5. Determine the most appropriate bracket configuration.
NOTE: If using a 10" Steering Ring, the first bend must be in the area identified. Failure to do so may result in erratic performance and WILL result in equipment damage.



- Opposing 90° bends – easy to bend and requires the least overall bend accuracy



- Single angle bend – requires only one bend, but the one bend needs to be more accurate than opposing 90° bends



- One 90° bend and an angled bend – requires more bend accuracy than opposing 90° bends, but looks more professional, and is less obtrusive for human drivers



6. Based on selected bracket configuration, measure the distance and angle between the desired mount points on the steering wheel and the closest corresponding point on the Steering Ring's internal ring.
7. Use a bending brake machine to bend identified angles. If a bending brake is not available, score the bend location and clamp the steering ring mounting end up to the score mark (the top of the 'T') in a vice. Place a piece of steel plate over the remainder of the bracket, then use a mallet or hammer to hammer the bottom of the steel plate (to ensure the bend does NOT occur further up the bracket extension). Hammer the bracket to the desired angle.
NOTE: If the bracket is bent too far, place the bracket on a flat, solid surface, with the angle, and hammer down on the angle to straighten it back to the desired angle.
8. Any bracket extension that will extend past the steering wheel may be cut off, rounded, and sanded.
9. Install the steering ring and steering ring brackets per existing installation manuals, procedures, and guidance.

