NOTE! Adding power steering to an IH Farmall M or Super M should only be attempted by accomplished mechanics with good hydraulic skills!

1. Wait until tractor cools to room temperature, then remove muffler, air cleaner cap, hood and grill.
2. Clean steering shafts and steering gear box to prevent dirt from entering steering housing. Clean around gauge locations as both the oil pressure gauge and water temperature gauge must be removed from the instrument panel. Drain radiator and upper steering gear housing and remove gauges.
3. Loosen set screws on lower rear steering bearing spacer and allow to slide down the shaft approximately 12". Remove u-joint bolt from the lower half and slide entire shaft towards the rear of the tractor. Remove steering worm bearing retainer nut from steering housing and allow the lower shaft to screw out of the steering housing, then pull shaft out of the tractor. Remove instrument panel and steering shaft center bearing and governor control rod from fuel tank support.
4. Test new IHS 675 bracket to mounting holes in fuel tank support, some variations of fuel tank supports will require drilling the mounting holes 1/16" larger for clearance. Remove bracket and mount steering torque generator to the bracket and the port block to the torque generator, then remount assembly to the fuel tank support. Install oil pressure and water temperature gauges into bracket and reconnect the governor control rod.
5. If using original u-joint, install woodruff key into torque generator and slide upper steering shaft down on to the torque generator shaft, install bolt and adjust position of u-joint so bolt clears housing, tighten bolt in final location. If original u-joint needs to be replaced, use ABC 166 and cut off the original u-joint and drill hole in shaft for roll pin. Install roll pins in shaft and torque generator.
6. Install ABC 166 or ABC 380 joint on lower end of torque generator, test fit lower shaft, measure and cut shaft at proper length, drill hole in shaft for roll pin, clean and deburr shaft, install through steering housing and tighten worm gear bearing retainer, refill steering gear box with correct grade oil. Refill radiator.
7. Connect port block to either remote power steering pump (ABC 1233, ABC 1417, IHS 1418) or priority flow valve (IHS 740 for use on tractors with live hydraulics) with custom hydraulic lines.
8. Check for leaks and proper operation, then reinstall, hood, grill, muffler, and air cleaner cap.