



**ALT./VACUUM PUMP MOUNT BILLET ALUMINUM,
FOR SBC WITH AN ELECTRIC WATER PUMP
PART NUMBERS 63817, 63818 and, 63819**

Note: This kit is designed to mount a 93MM Nipondenso Alternator and a Moroso 22642 Vacuum Pump to a Small Block Chevrolet using an electric water pump. This kit must use a 40 tooth vacuum pump pulley (Moroso #23540), a 22 tooth Crankshaft pulley (Moroso #23534), and a 720MM radius tooth belt (Moroso #97149). Call Moroso's tech line for other drive ratio options.

Parts List

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| (1) ALT./VACUUM PUMP MOUNT, | (4) STANDOFFS |
| (1) ALTERNATOR TURNBUCKLE | (1) 3/8IN. ROD END & JAM NUT, LEFT |
| (4) 3/8IN.X 5-1/4 SHCS | (1) 3/8IN. ROD END & JAM NUT, RIGHT |
| (4) 3/8IN.X 5-1/2IN. SHCS | (1) 3/8IN.X 1-1/4IN SHCS |
| (2) 3/8IN.X 1-3/4IN. SHCS | (1) 8MM X 1.25 X 30MM HHCS |
| (1) WASHER 5/16IN. FLAT | (3) 3/8 WASHER |
| (3) 3/8 NYLON LOCK NUT | (1) 1/4IN.X 3/4IN. SHCS |
| (1) ALUMINUM SPACER | |

1. Place the vacuum pump, minus the pulley, through the backside of the mounting plate and tighten the clamp bolt hand-tight. The inlet for the pump should face upward (at the 11:00 o'clock position). The outlet should face downward, (7:00 o'clock position).
2. Insert the 3/8" SHCS through the front of the Mounting Plate and through each of the Aluminum Stand-offs. Use the longer 5 1/2 " bolts if you have a motor plate.
3. Fasten the assembly to the motor through the water pump mounting holes as shown in the illustration using gaskets or RTV silicone where applicable.
4. Place the crank pulley on the mandrel and put the belt on the pulley.
5. Loosen the adjusting bolt on the vacuum pump clamp and rotate the pump counter-clockwise to bring the centerline of the pump shaft closer to the crankshaft centerline.
6. While holding the vacuum pump pulley, put the belt on and fasten the pulley to the vacuum pump using the three bolts supplied with the pulley.
7. Rotate the pump to achieve proper tension on the belt and tighten the clamping bolt.

**For Technical Assistance, Call Moroso's Tech Line at
(203) 458-0542, 458-0546 8:30am – 5:00pm Eastern Time**

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- 8 At this time, check for proper belt alignment. Adjustments can be made by swapping spacers on the your drive mandrel. Minor adjustments are made by adjusting the position of the pump in the clamp.
9. With the belt engaged, remove the pulley bolts one at a time, add a drop of thread locking compound to each and refasten.
10. Attach the large lug of the alternator to the top mounting hole on the plate using the 3/8 X 1-1/4IN. Bolt and Nylock Nut provided.
11. Fasten one end of the Rod End/Turnbuckle Assembly to the lower mounting hole in the Mounting Plate using the 3/8IN. X 1-3/4IN. Bolt, Aluminum Spacer, and Nylock Nut.
12. The kit provides both a 8MM and a 3/8IN. fastener for the lower lug on the alternator. We recommend drilling and tapping the lug for a 3/8IN. fastener for increased strength. Make certain to mask off any openings in the alternator when doing so.

