



Holley Accessory Drive System

Part Number 20-138

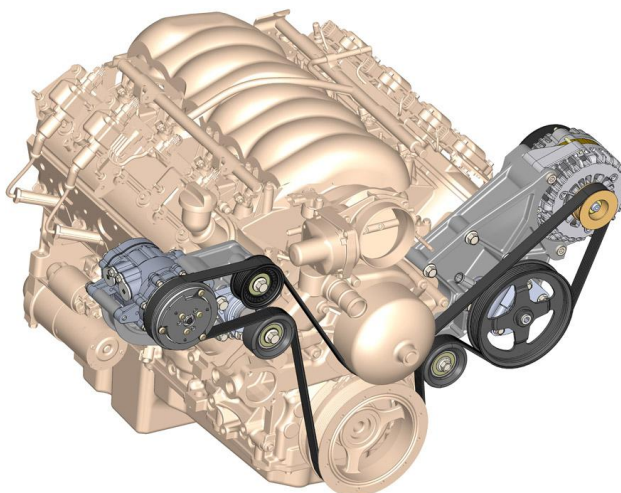
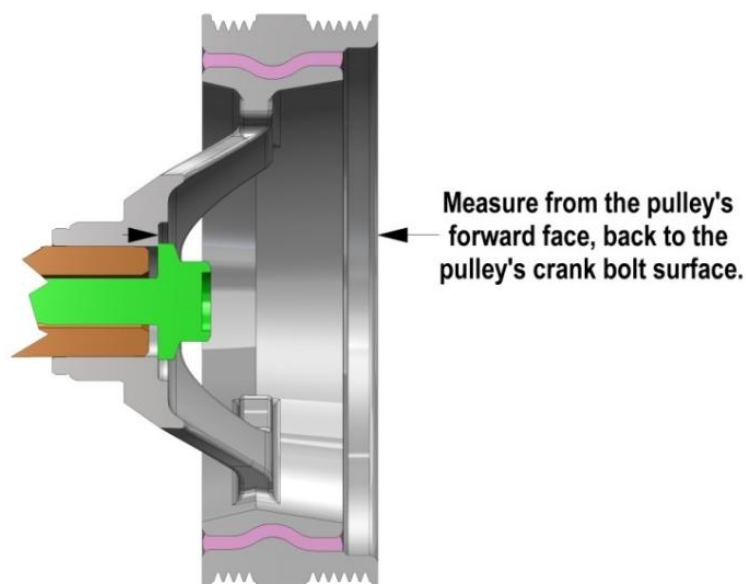


Table of Contents

Introduction:	2
Crank Pulley Belt Alignment Determination:	3
Overview of Parts Required (but NOT included with 20-138 accessory drive system):	3
Water Pump Determination:.....	4
Parts List:.....	7
Assembly Instructions	9
Driver's Side Bracket Installation:	9
Power Steering Pump Installation:	10
Idler Pulley Installation (position options):	11
P/S Pulley & Alternator Installation:	12
Passenger's Side Bracket Installation:.....	13
Idler & Tensioner Installation:	14
A/C Compressor Installation:.....	15
Belt Routing:	16
Power Steering Pump Reservoir Options:	17
Warranty Information	18

Crank Pulley Belt Alignment Determination:



See the below chart for reference dimensions.

Overview of Parts Required (but NOT included with 20-138 accessory drive system):

Components with specific belt alignments

Belt Alignment Group	LS Application (Alignment Specific)	Holley Installation Kit (Alignment Specific)	Crank Pulley (Reference Dimension)		Water Pump (Alignment Specific)
					GM #
Standard	Corvette / CTS-V / G8	21-1	1.5"	37 MM	19256263, 89018052, or 12604630
Middle	F-body / GTO	21-2	2.25"	55 MM	19256263
Long	Camaro ('10-UP) / Truck (all)	21-3	3"	75 MM	19207665 or any truck WP

Water Pump Determination:

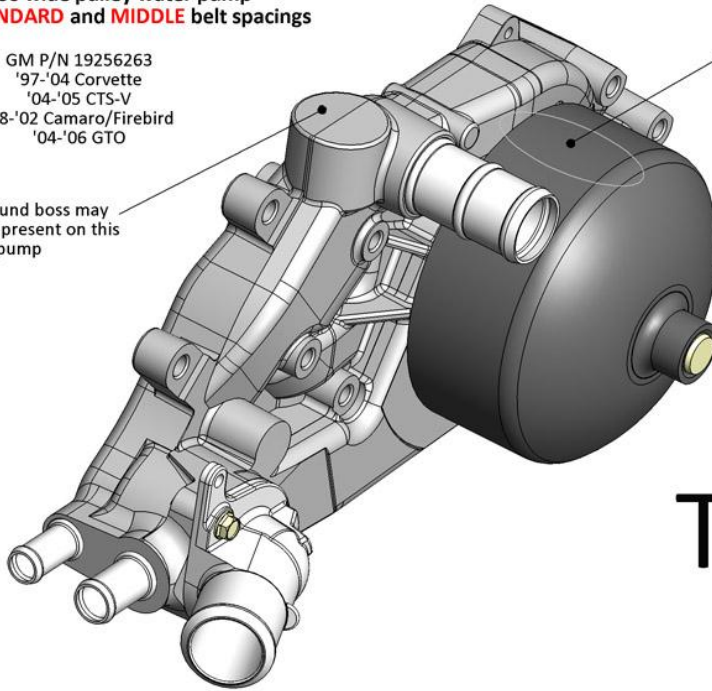
To determine which water pump type you have, refer to the following illustrations:

LS1/LS2/LS6 wide pulley water pump
Works with **STANDARD** and **MIDDLE** belt spacings

GM P/N 19256263
'97-'04 Corvette
'04-'05 CTS-V
'98-'02 Camaro/Firebird
'04-'06 GTO

This round boss may
not be present on this
water pump

Identifying feature:
Wide pulley allowing
for both standard and
middle belt spacings

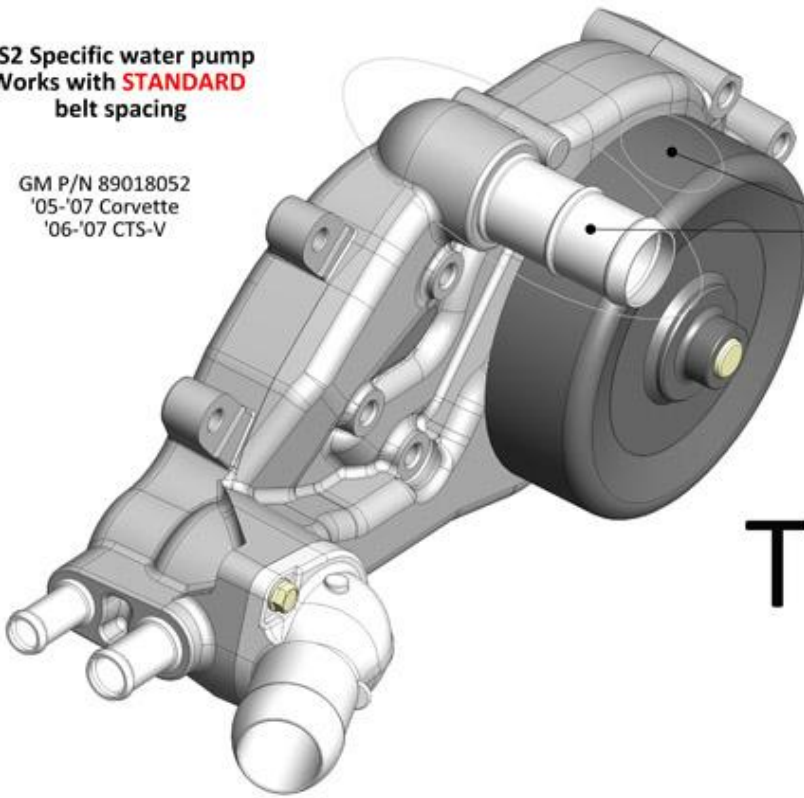


TYPE
1

LS2 Specific water pump
Works with **STANDARD**
belt spacing

GM P/N 89018052
'05-'07 Corvette
'06-'07 CTS-V

Identifying features:
Narrow pulley and
passenger's side outlet



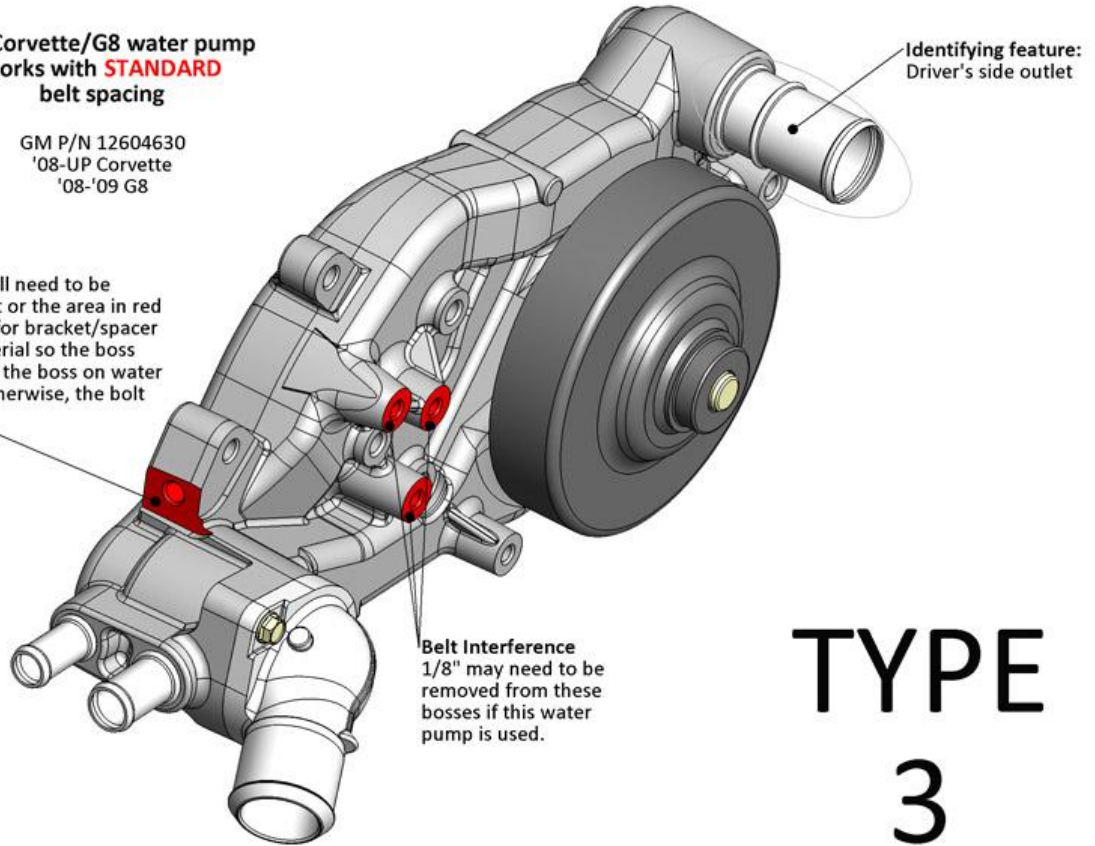
TYPE
2

LS3 Corvette/G8 water pump
Works with **STANDARD**
belt spacing

GM P/N 12604630
'08-UP Corvette
'08-'09 G8

Bracket Bolt Access

Either the water pump will need to be installed after the bracket or the area in red will need to be removed for bracket/spacer access. Remove the material so the boss shape is similar to that of the boss on water pump TYPE 1, 2, or 5. Otherwise, the bolt will not pass by the boss.

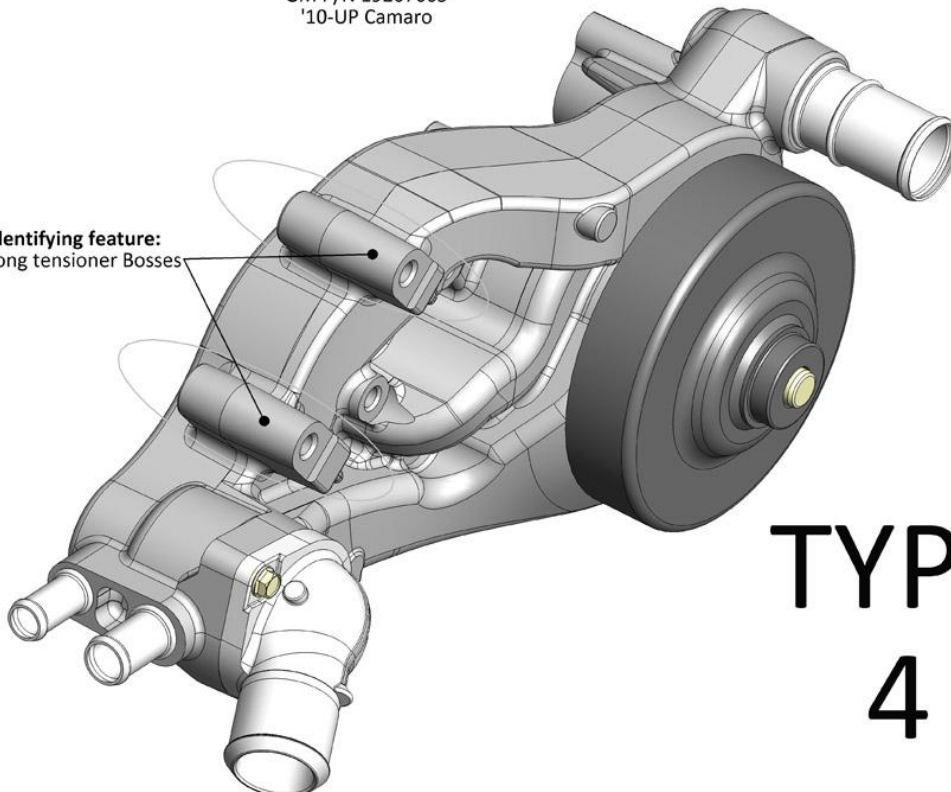


TYPE
3

LS3/L99 Camaro water pump
Works with **LONG** belt spacing

GM P/N 19207665
'10-UP Camaro

Identifying feature:
Long tensioner Bosses

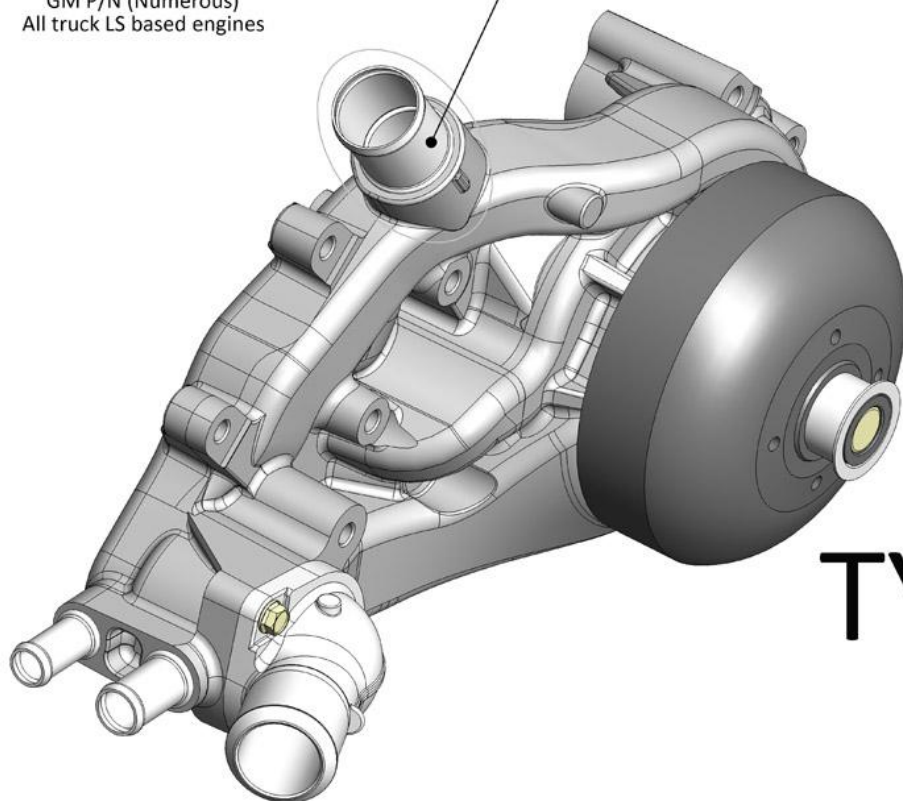


TYPE
4

TRUCK water pump
Works with **LONG** belt spacing

GM P/N (Numerous)
All truck LS based engines

Identifying feature:
Upward pointing
inlet


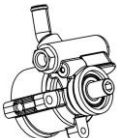
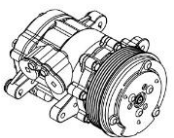







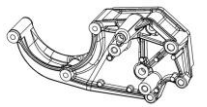




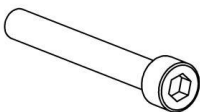
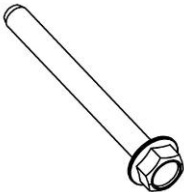


TYPE
5

Parts List:

This accessory drive system requires application specific installation kit part # 21-1, 21-2, or 21-3

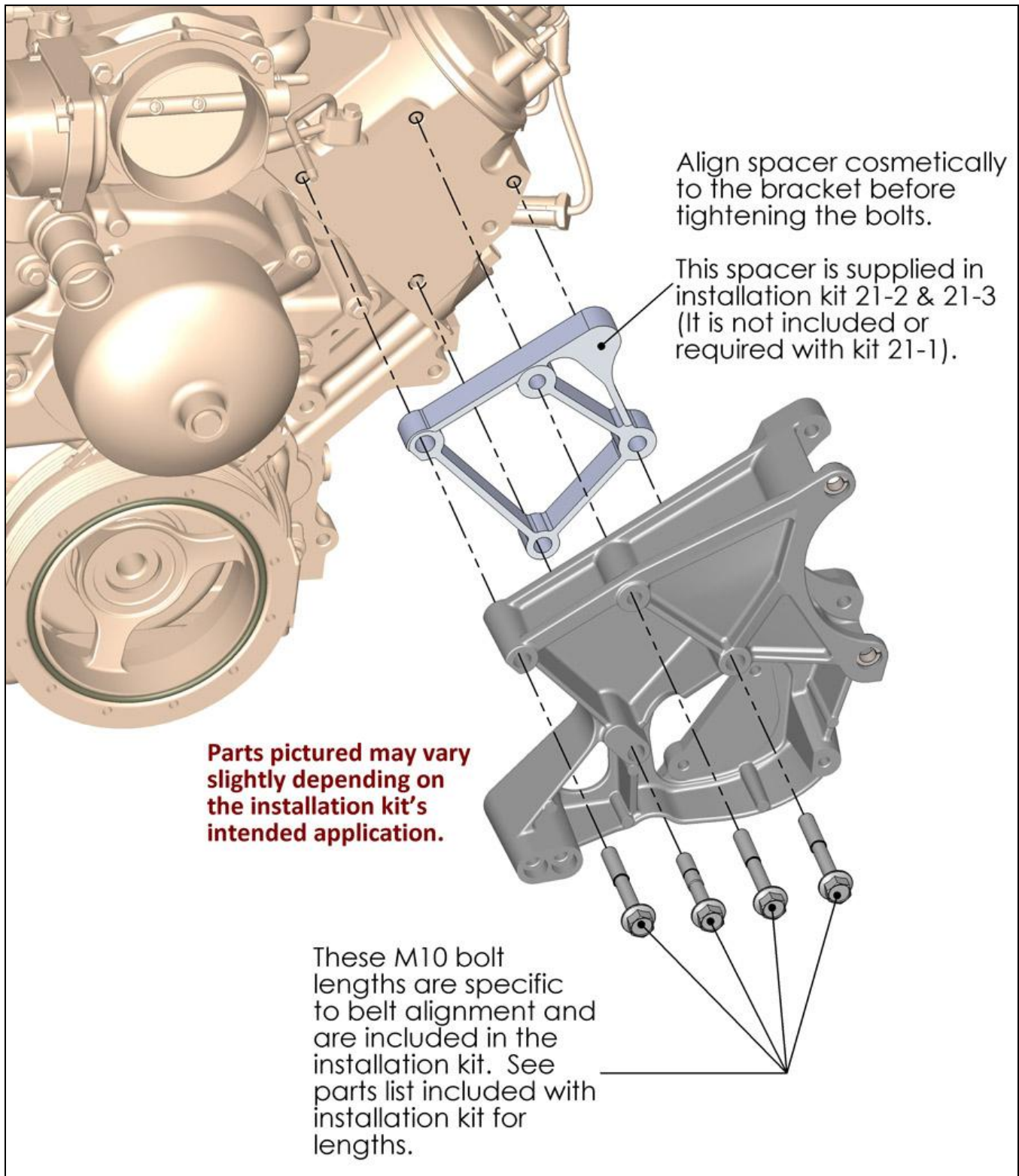
Parts included with 20-138 accessory drive system (see list supplied with installation kit for additional parts):

PICTURE	QTY	DESCRIPTION	APPLICATION
	1	Alternator (P/N 197-301)	Driver's Side Bracket
	1	P/S Pump (P/N 198-100)	Driver's Side Bracket
	1	SD7 A/C Compressor (P/N 199-102)	Passenger's Side Bracket
	1	Belt Tensioner with Bolt (P/N 97-151)	Passenger's Side Bracket
	2	Smooth Idler Pulley (P/N 97-150)	Driver's & Passenger's Side Brackets
	1	Ribbed Idler Pulley, 68mm	Passenger's Side Bracket
	1	Pigtail (P/N 197-400)	Alternator
	1	Ribbed Pulley (P/N 97-152)	P/S Pump
	1	Belt, 6 Rib Serpentine	Driver's & Passenger's Side Brackets
	1	Driver's Side Bracket Assembly	Alternator & Power Steering Pump
	1	Passenger's Side Bracket Assembly	A/C Compressor & Tensioner

	1	Power Steering Pump Plate Bracket	Front Support of Power Steering Pump
	1	Step Spacer	Driver's Side Idler Pulley
	1	Socket Head Cap Bolt, M10 x 1.5 x 30	Spacer to Passenger's Side Head
	2	Socket Head Cap Bolt, M10 x 1.5 x 80	Alternator Bolts
	2	Flange Head Bolt, M8 x 1.25 x 20	Power Steering Pump Bolts
	2	Flange Head Bolt, M8 x 1.25 x 80	Power Steering Pump Bolts
	3	Flange Head Bolt, M8 x 1.25 x 35	Passenger's Side Bracket to Spacer
	2	Flange Head Bolt, M10 x 1.5 x 35	Tensioner Assembly to Passenger's Side Bracket
	1	Flange Head Bolt, M10 x 1.5 x 35	Idler Pulley to Passenger's Side Bracket
	1	Flange Head Bolt, M10 x 1.5 x 45	Idler Pulley to Driver's Side Bracket
	2	Flange Head Bolt, M8 x 1.25 x 95	A/C Compressor Bolts
	2	M8 Thin Spacer	Bracket to Front A/C Compressor Ears

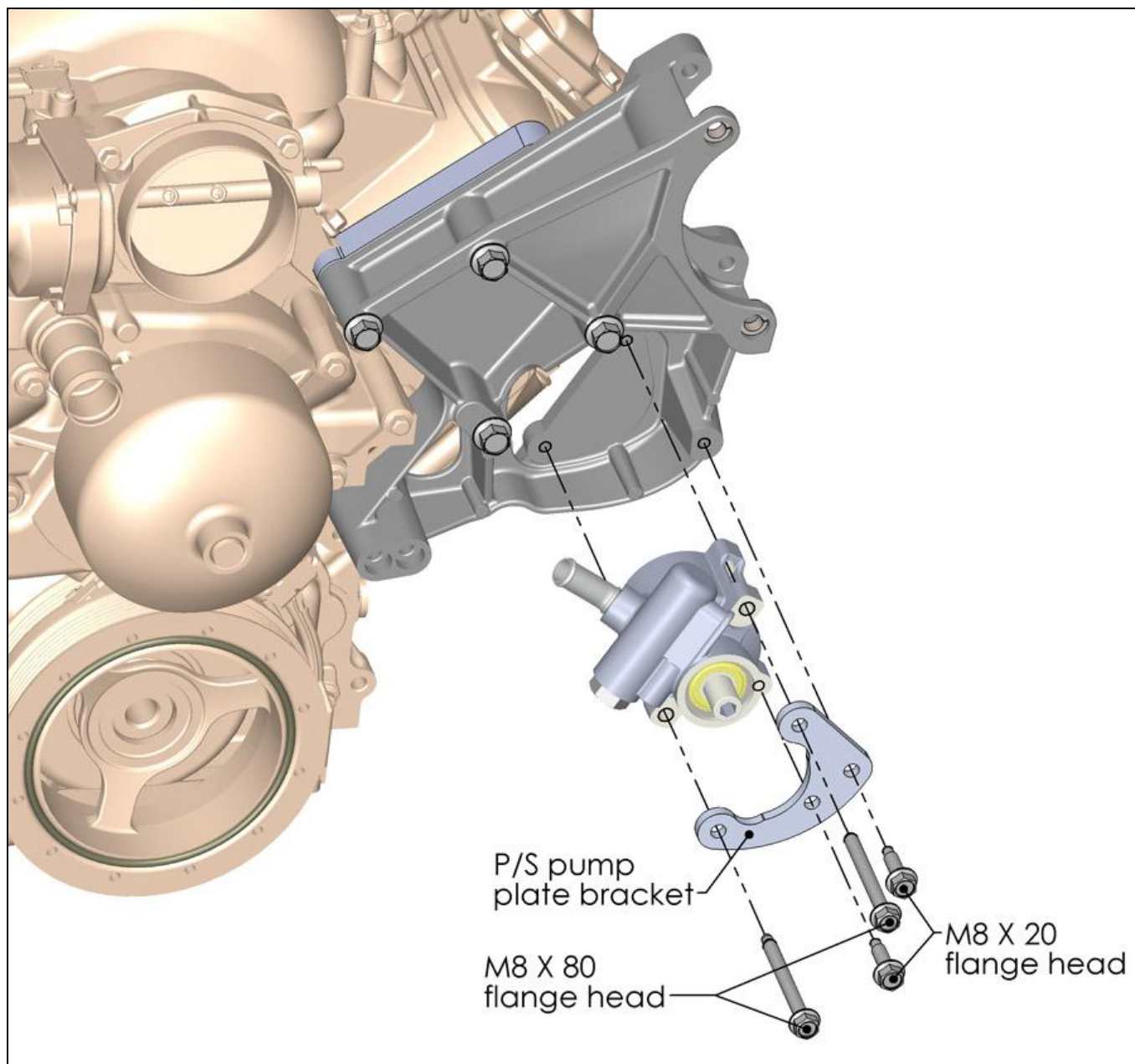
Assembly Instructions

Driver's Side Bracket Installation:



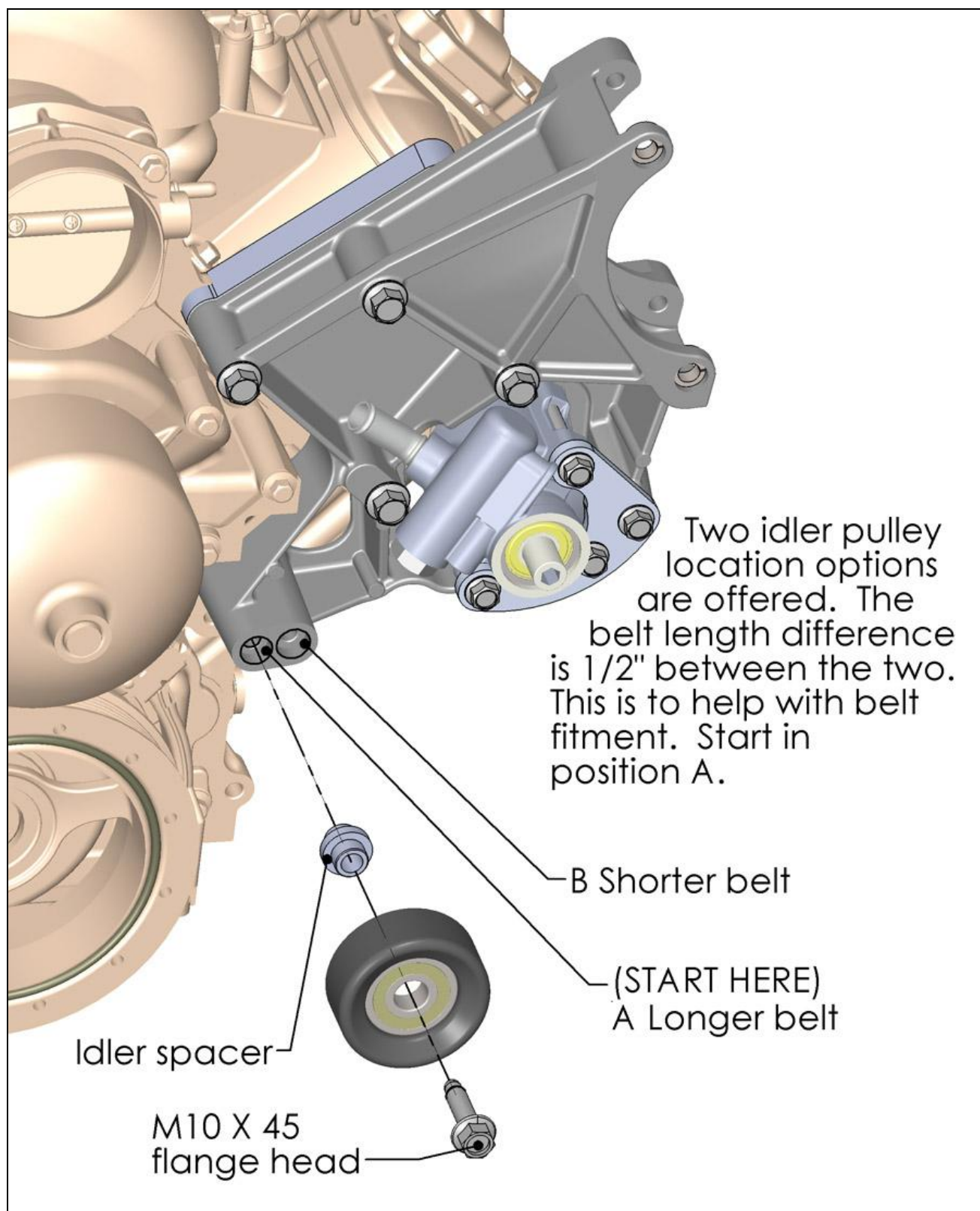
NOTE: Torque M8 bolts to 18 ft./lbs. and M10 bolts to 36 ft./lbs.

Power Steering Pump Installation:



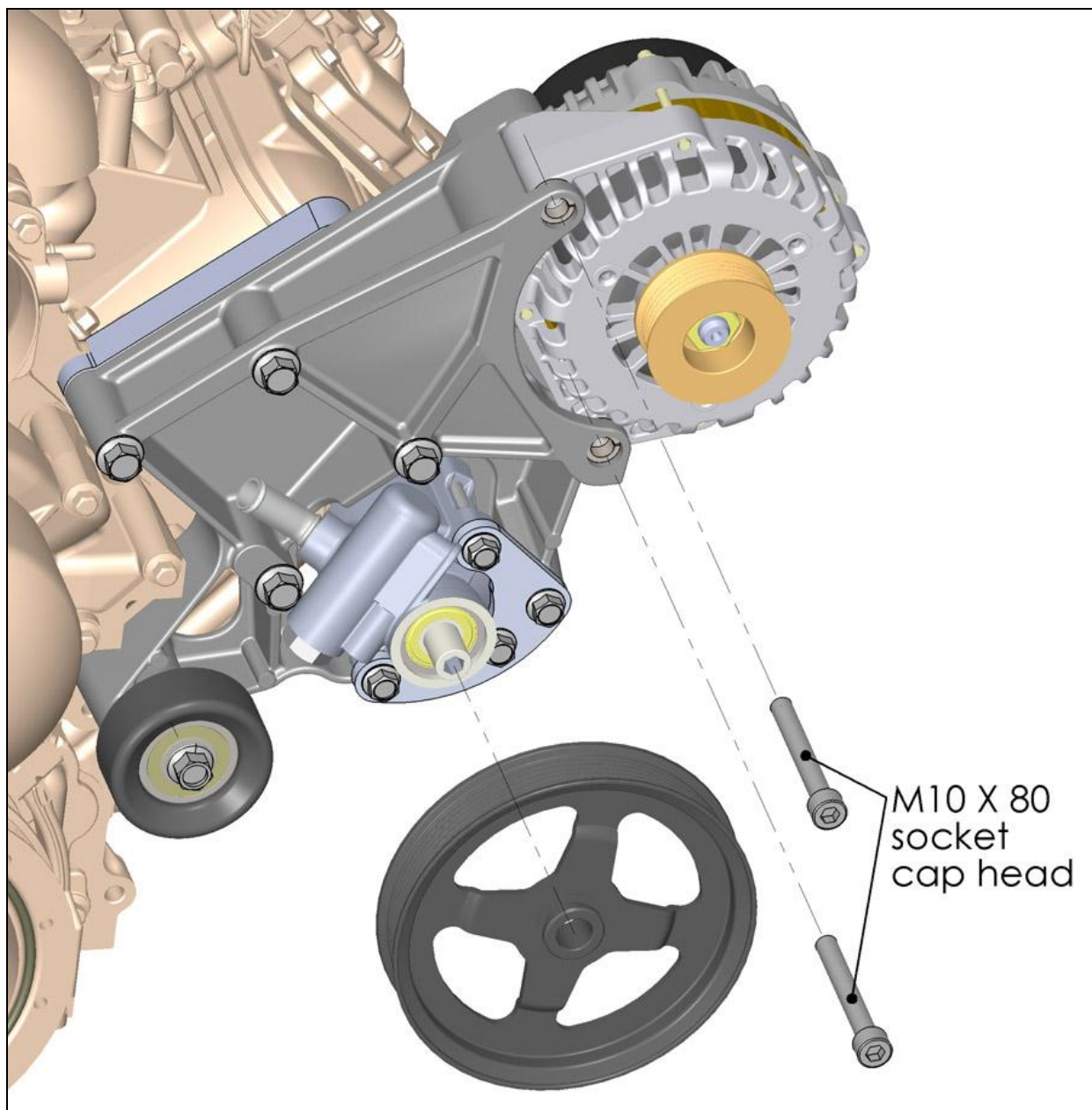
NOTE: Torque M8 bolts to 18 ft./lbs. and M10 bolts to 36 ft./lbs.

Idler Pulley Installation (position options):



NOTE: Torque M8 bolts to 18 ft./lbs. and M10 bolts to 36 ft./lbs.

P/S Pulley & Alternator Installation:



NOTE: Torque M8 bolts to 18 ft./lbs. and M10 bolts to 36 ft./lbs.

The P/S pulley must be installed using an installation tool that can be rented at most auto parts stores. Incorrect installation of this pulley may damage the P/S pump internals. When installed, the pulley bore face should be flush with the end of the pump shaft.

Helpful hint: Open faced pulley part 97-152 (included) can be installed onto pump before bracket assembly as bolts can be accessed through pulley windows.

Helpful hint: When wiring the alternator, install the included 197-400 plug into the alternator. Next connect the yellow wire to switched voltage that is “on” when the key is in the run position. If the vehicle has a “charge indicator light” the yellow wire can be connected to that circuit.

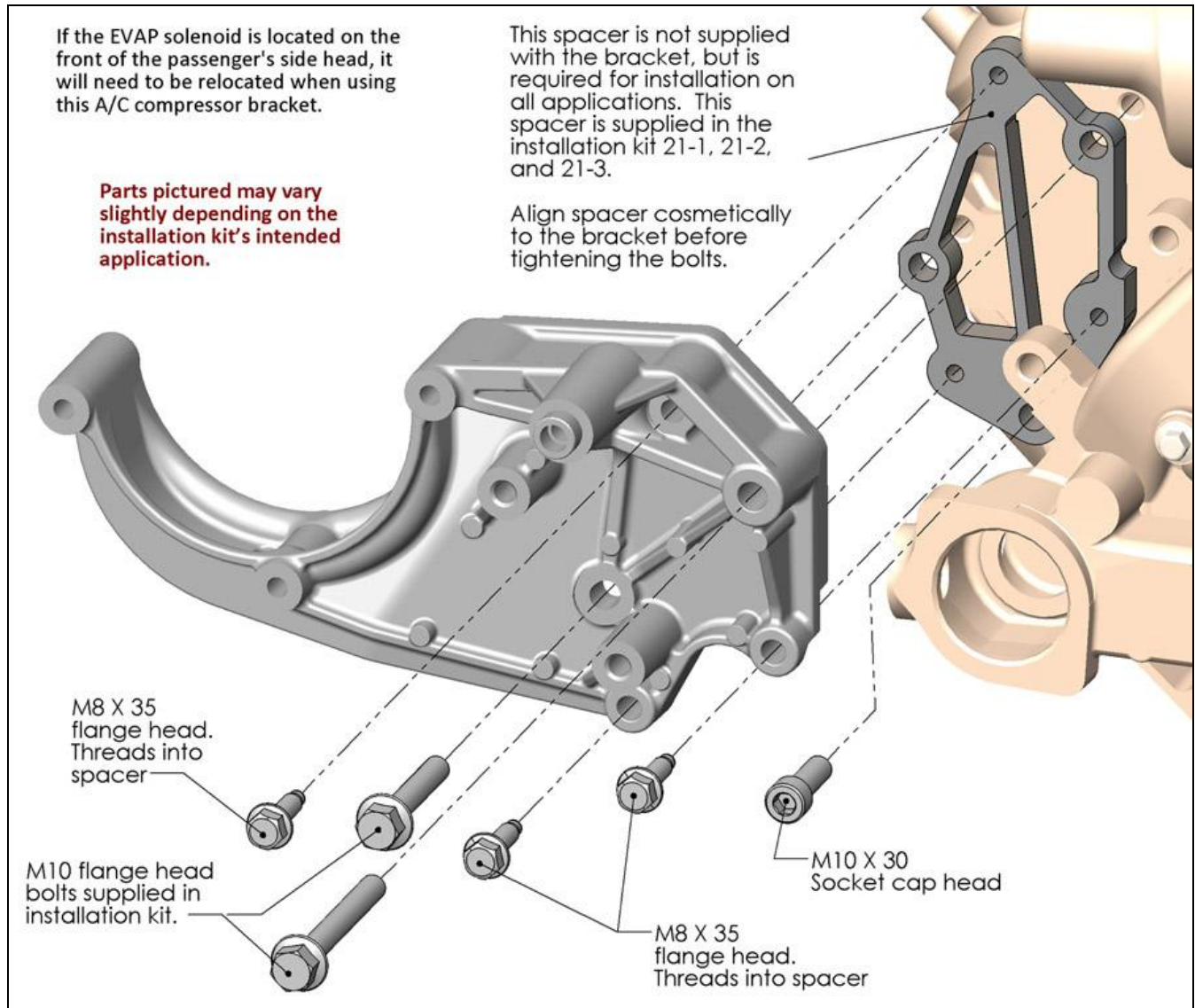
Passenger's Side Bracket Installation:

If the EVAP solenoid is located on the front of the passenger's side head, it will need to be relocated when using this A/C compressor bracket.

Parts pictured may vary slightly depending on the installation kit's intended application.

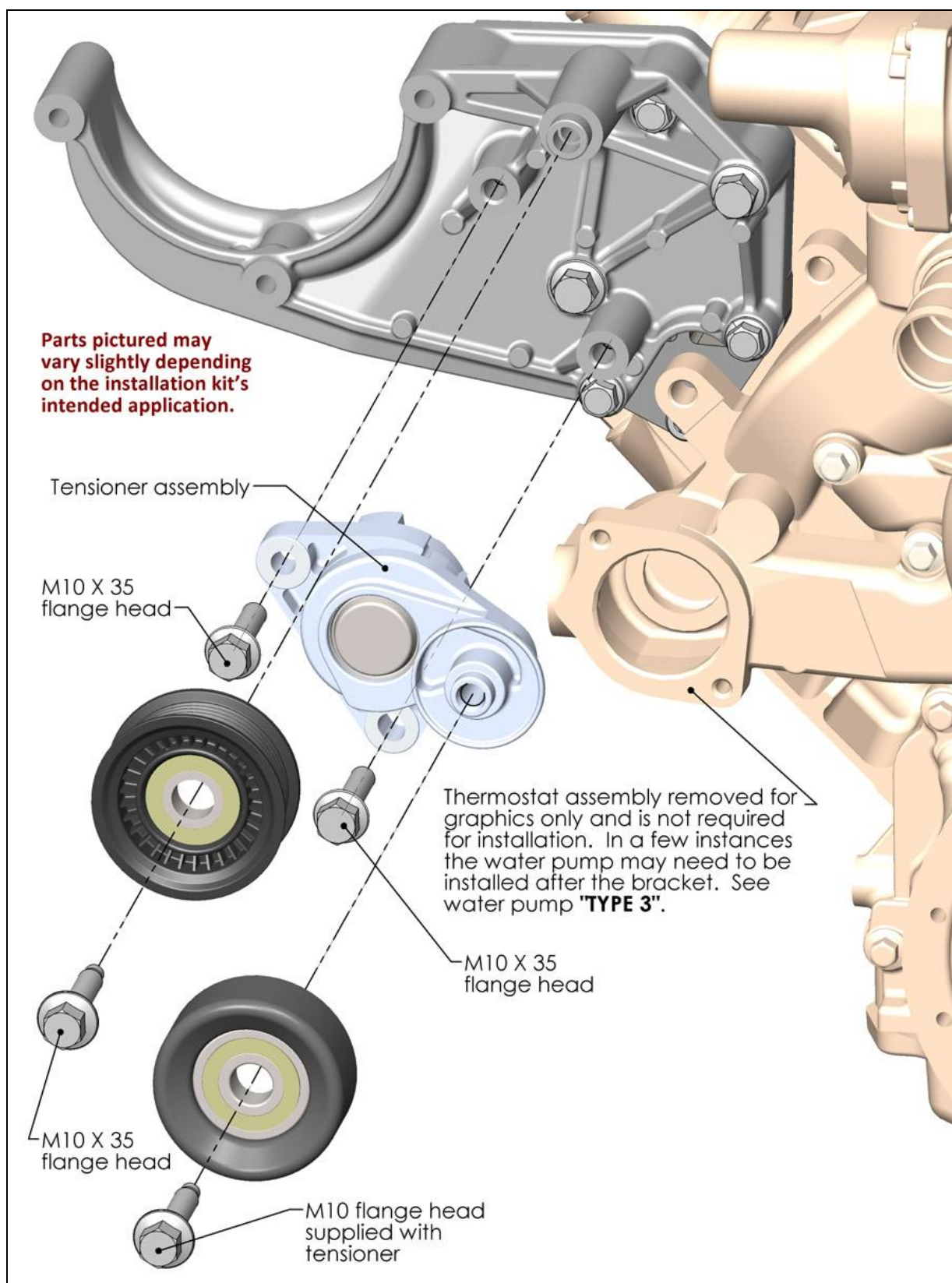
This spacer is not supplied with the bracket, but is required for installation on all applications. This spacer is supplied in the installation kit 21-1, 21-2, and 21-3.

Align spacer cosmetically to the bracket before tightening the bolts.



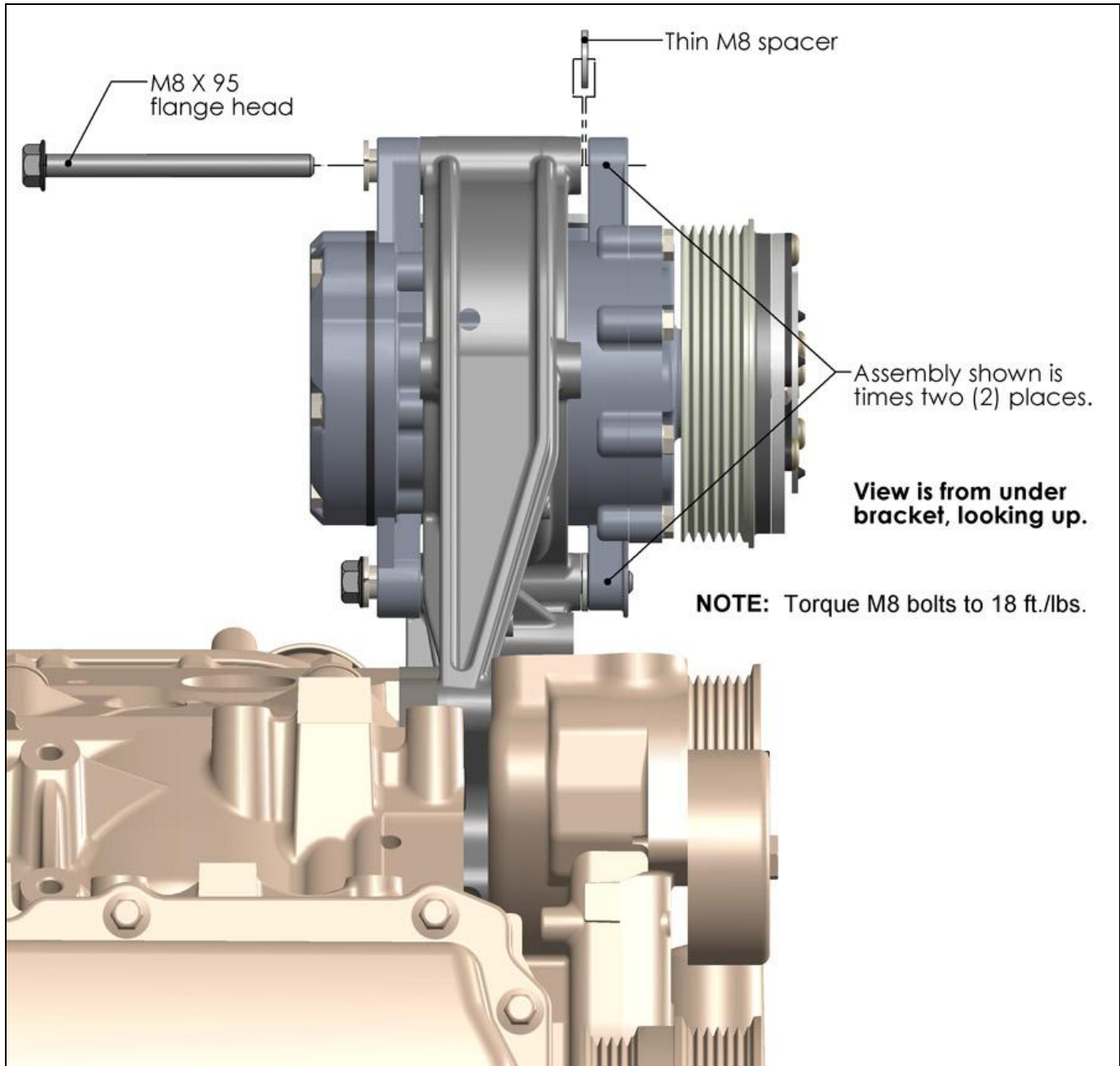
NOTE: Torque M8 bolts to 18 ft./lbs. and M10 bolts to 36 ft./lbs.

Idler & Tensioner Installation:

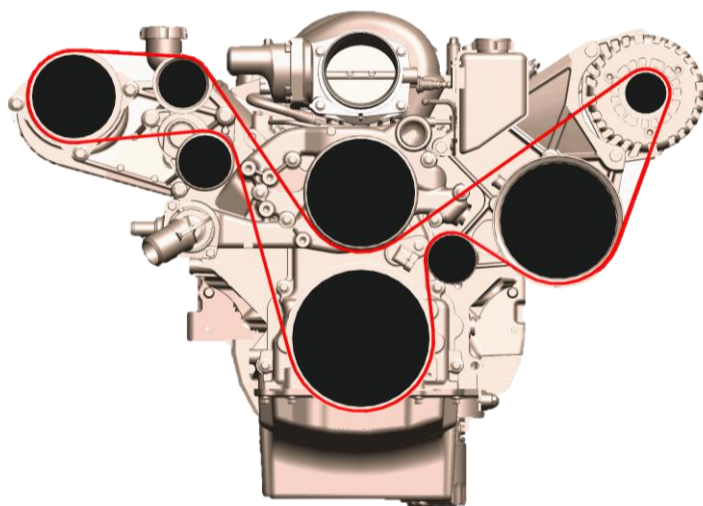


NOTE: Torque M8 bolts to 18 ft./lbs. and M10 bolts to 36 ft./lbs.

A/C Compressor Installation:

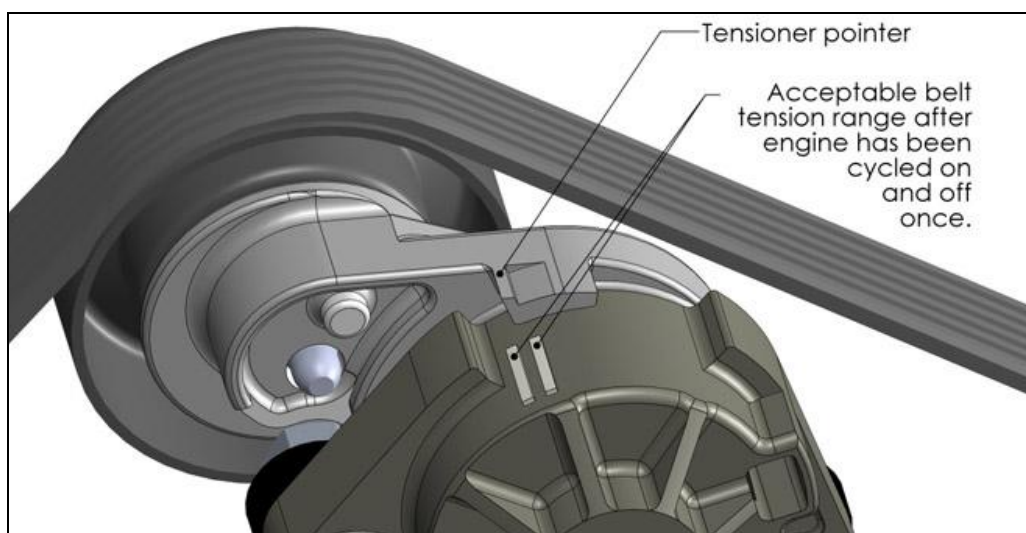


Belt Routing:



HELPFUL HINT: When installing the belt, route around all the pulleys except the water pump pulley. While fully rotating the tensioner arm, slip the belt on the smooth water pump pulley last.

Use serpentine belt supplied if using ALL Holley accessories and supplemental parts.



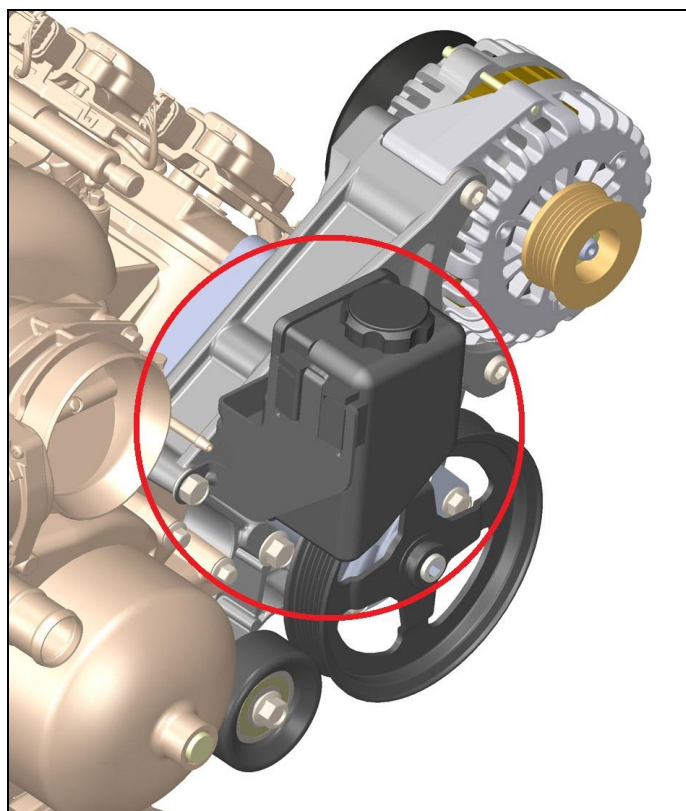
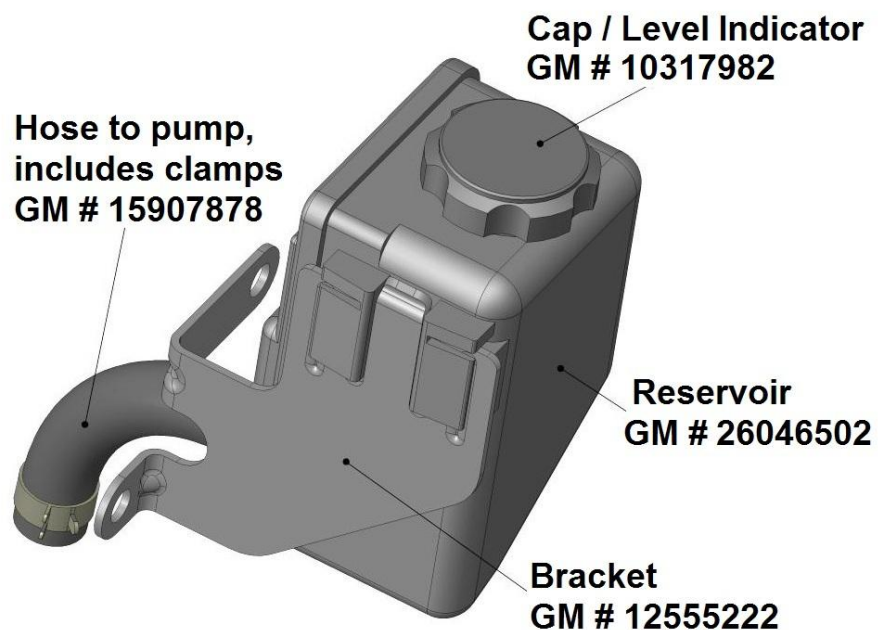
NOTE: If you are NOT using all the Holley accessories supplied, or have changed the original crank or any accessory's pulleys, you will have to measure to find the correct belt length.

To acquire this measurement, perform the following:

After all brackets and accessories are installed, route masking tape or string around the belt path. Leave the tensioner in the un-sprung position for this measurement. Mark or cut the tape/string to length and remove from the pulleys. Subtract 1 1/8" (28 mm) from the measured length to compensate for the un-sprung tensioner position. You will need to convert belt length to millimeters if measured in inches (inches X 25.4 = mm). Go to any auto parts store and ask for a 6PK0000 belt with the "0000" being the length in millimeters. For example, if you measured 2493 mm and then subtracted 28 mm, you would get 2465 mm, and the part number would be 6PK2465. Remember, if you miss on size, the driver's side idler can be moved to decrease the required belt length by 1/2".

Power Steering Pump Reservoir Options:

The Holley driver's side bracket works with reservoirs found on '97-up Corvettes. Other remote reservoirs can be custom fitted with this bracket as well. All the below reservoir parts are included in **Holley kit # 198-200**.



Warranty Information:

Holley Performance Products Limited Warranty

All Holley Performance Products Limited Warranties are extended to the original consumer only. This Limited Warranty is not assignable or otherwise transferable. There are no warranties that extend beyond those stated herein. Holley Performance Products offers no other warranties expressed or implied beyond this Limited Warranty.

In the event of an alleged defect in material or workmanship, Holley Performance Products' responsibility is strictly limited to repair or replace the defective product. Holley has no other obligation expressed or implied. Final warranty determination will be in the sole discretion of Holley Performance Products. Holley shall not be responsible for; (a) actual or alleged labor, transportation, or other incidental charges; or (b) actual or alleged consequential or other damages incurred by use of any product of Holley Performance Products.

To initiate the warranty process, the consumer must return the alleged defective product to the place of purchase with a dated receipt and completed applicable warranty claim tag. Warranty claims will be rejected if the date of purchase cannot be established by the consumer. Do not send products directly to Holley Performance Products. Holley Performance Products assumes no responsibility for products sent directly to Holley Performance Products.

This Limited Warranty sets forth specific legal rights. The consumer may have other rights as a result of variations in state laws or provincial laws. This Limited Warranty supersedes all prior warranty statements.

HOLLEY/FLOWTECH/HOOKER/NOS/WEIAND – NEW PRODUCT

Holley Performance Products warrants its new Holley, Flowtech, Hooker, NOS, and Weiand products to be free from defects in material and workmanship for a period of 90 days from date of purchase.

Holley Performance Products Limited Warranty specifically does not apply to products, which have been (a) modified or altered in any way; (b) subjected to adverse conditions, such as misuse, neglect, accident, improper installation or adjustment, dirt or other contaminants, water, corrosion, or faulty repair; or (c) used in other than those applications recommended by Holley Performance Products. Holley Performance Products also does not warrant, and disclaims all liability for products used in racing activities and/or applications other than those specifically recommended in the current brand catalog.

Holley limits the warranty on Metallic Ceramic Coatings to be free from defects in material and workmanship for a period of 90 days from the date of purchase. This limited coating warranty does not apply to any products which have been subjected to adverse conditions, such as high heat encountered during engine break-in or if used during any racing activity.

MARINE PRODUCTS

Holley Performance Products warrants its new marine products to be free from defects in material and workmanship for a period of 90 days from date of purchase. For the safety and protection of persons and property, all United States Coast Guard and other marine product safety installation and use requirements and recommendations must be carefully studied and applied. The above recommendations include, but are not limited to the recommendation that the installation, adjustment, and repair of Holley carburetors or other marine products must be performed only by a trained mechanic having adequate marine fuel system experience, and in strict compliance with the applicable Holley installation, maintenance, and other instructions. Failure to follow such requirements and recommendations will void this Holley Marine Limited Warranty, and Holley disclaims any responsibility and/or liability for accidents resulting from such failure.

Holley Performance Products Limited Warranty specifically does not apply to products, which have been (a) modified or altered in any way; (b) subjected to adverse conditions, such as misuse, neglect, accident, improper installation or adjustment, dirt or other contaminants, water, corrosion, or faulty repair; or (c) used in other than those applications recommended by Holley Performance Products. Holley Performance Products also does not warrant, and disclaims all liability for products used in racing activities and/or applications other than those specifically recommended in the current brand catalog.

Holley® Performance Products, Inc.
1801 Russellville Road
Bowling Green, KY 42101

Technical Support: 1-866-464-6553
Phone: 1-270-781-9741
Fax: 1-270-781-9772
www.holley.com

© 2011 Holley Performance Products, Inc. All rights reserved.

199R10640

Date: 7-23-13