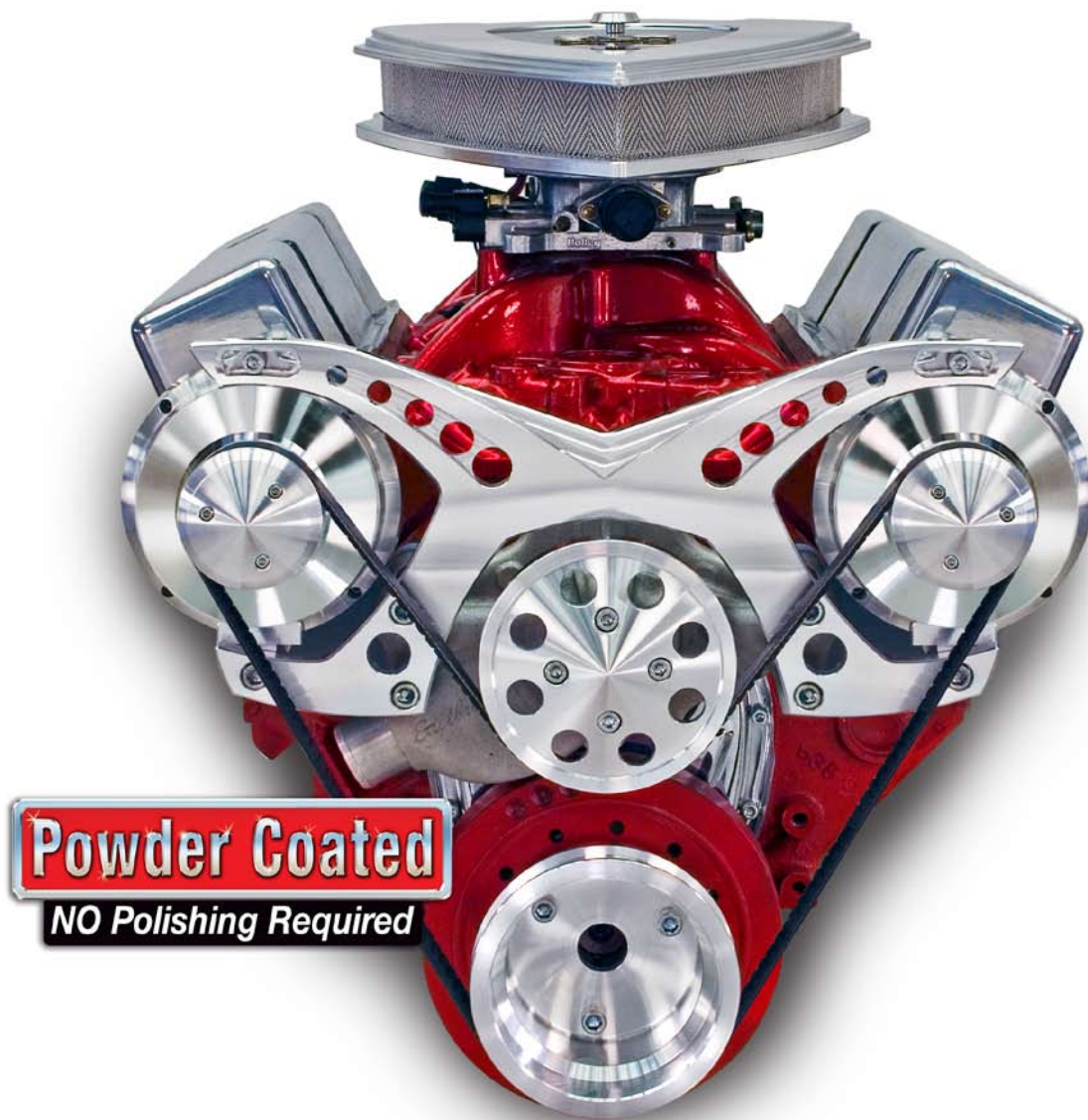




Highly Styled, Low Cost Serpentine Drive

Installation Instructions

Chevy Small Block Twin Alternator

Kit #21075 and #21080



Included Parts List

Main Front Bracket Kit P/N 21071

1-21071-A	Main Front Bracket Body
2-S148.....	$\frac{5}{16}$ -18x1 $\frac{1}{2}$ " SHCS
2-S553.....	M8-1.25x35mm
1-S150.....	$\frac{5}{16}$ -18x1 $\frac{1}{2}$ " SHCS
4-S248.....	$\frac{3}{8}$ -16x1" SHCS
3-S339.....	$\frac{3}{8}$ x 3"lg Stud Threaded
1-S340.....	$\frac{3}{8}$ x 4"lg Stud Threaded
4-S675.....	Paper Water Pump Gasket
1-S770.....	1.900" Lg Threaded Spacer Stainless
3-S775.....	2.800" Lg Threaded Spacer Stainless
2-MM100	Bolt Cover Adjustment Bushing

Alternator Rear Support P/N 21072

1-21072-A Alternator Rear Support Body
1-S280..... $\frac{3}{8}$ "-16 x 5 $\frac{1}{2}$ " SHCS
1-S450..... $\frac{5}{8}$ " Set Screw
1-S622..... $\frac{3}{8}$ " Lock Nut
1-TP3-1.775 $\frac{3}{8}$ " Id x 1.775" Lg Spacer

Dual Alt Rear Support P/N 21076

1-21073-ADual Alt Rear Support Brk Body
1-S276..... $\frac{3}{8}$ "-16 x 4 $\frac{1}{2}$ " SHCS
1-TP3-1.890 $\frac{3}{8}$ " Id x 1.890" Lg Spacer

Power Steering Bracket P/N 21104

For Kit #21075 Only

1-21104-A Power Steering Front Brk Body
1-21104-B Power Steering Rear Brk Body
2-S260 $\frac{3}{8}$ -16x 2 $\frac{1}{4}$ " SHCS
2-S551 8mm-1.25 x 25mm SHCS

Belt Tensioner Tool P/N 21106

1-MM101RH Rod End
1-MM102LH Rod End
1-MM103Threaded Adjustment Rod 12"
Long

Pulley Kit P/N 6304-206

1-6306-A Crank Pulley Body
1-6307-A Water Pump Pulley Body
2-206-A Alternator Pulley Body
2-222-A Alternator Fan Body
2-306-A Alternator Pulley Cap
6-S028..... $\frac{8}{32}$ x 1" SHCS
4-S186..... $\frac{5}{16}$ -24 x $\frac{7}{8}$ " SHCS
3-S292..... $\frac{3}{8}$ -24 x 1" SHCS
2-S685..... $\frac{11}{16}$ " Alt Lock Washer

1-619-A Power Steering Pulley Body For
Kit #21075 Only

1-302-A Power Steering Nose Cover For
Kit #21075 Only

3-S022..... $\frac{8}{32} \times \frac{3}{8}$ " SHCS
For Kit #21075 Only

Accessories

1-P112 Water Pump
 Alum Rev Rotation
 2-P573 Alternator Chrome Single Wire
 1-P315 Power Steering Pump
For Kit #21075 Only

Required Tools and Materials

RTV Silicone
Loc-Tite® Thread Locker
Anti-seize Compound
Gasket Scraper, Steel Wool or Sandpaper to clean gasket surfaces
3/16" Allen Head Driver
5/16" Allen Head Driver
1/4" Allen Head Driver
6mm Allen Head Driver
5/8" Combo Wrench

9/16" Combo Wrench
 11/16" Combo Wrench
 3/4" Combo Wrench
 Socket Wrench & Extension
 10mm 12pt. socket
 12mm 12pt. socket

Serpentine Belt

56" Belt without Power Steering
57.5" Belt with Power Steering



Tech Support 1-888-729-9070

Preparing to Install

- Disconnect the battery to prevent accidental engagement of starter motor.
- Drain coolant from system
- If your A/C is intact and charged it must be evacuated. This is best done by a professional garage with proper recycling equipment
- Remove the existing alternator, air conditioning compressor and associated brackets.
- Remove all pulleys and water pump.
- Remove all traces of old gasket and sealer with gasket scraper and steel wool pad.
- Clean threads in block by chasing with appropriate thread chasers.

Installing the Kit



FIG 1. Ensure the sealing face of the coolant outlets are clean, flat and free of old gasket material. Apply a small amount of RTV silicone to one end of each mounting stud to prevent coolant seepage. Install mounting studs into the four water pump mounting holes **placing the longer (S340) $\frac{3}{8}$ " x 4"** stud in the lower passenger side hole. Place the other three (S339) $\frac{3}{8}$ " x 3" studs in the remaining holes. **When fully installed the $\frac{3}{8}$ " x 4"** stud should be $3\frac{5}{16}$ " from the face of the block. The other three studs should be $2\frac{3}{8}$ " from face of block. Fig-1

FIG 2. Install the Rear Support Brackets (21172-A) on the passenger side and Rear Support (21172-A) on drivers side. Use the (4) provided Paper Gaskets (S675) and a small amount of silicon sealant installed on the front and rear of both brackets to ensure a water tight seal.



FIG 3. Slide the Water Pump (P112) Over the Studs and secure with the (3) $\frac{3}{8}$ x 2.800" Stainless Spacers (S775) two to the upper water pump studs and one to the lower drivers side water pump stud. Install (1) $\frac{3}{8}$ x 1.900" Stainless spacer (S770) on to the lower passenger side water pump stud. Use a sealer if nessessary.

FIG 4. Mount the Main Face Plate (21071-A) to the (4) studs with (4) $\frac{3}{8}$ x 1" SHCS (S248)
Note: leave the studs loose to aid in proper alignment.

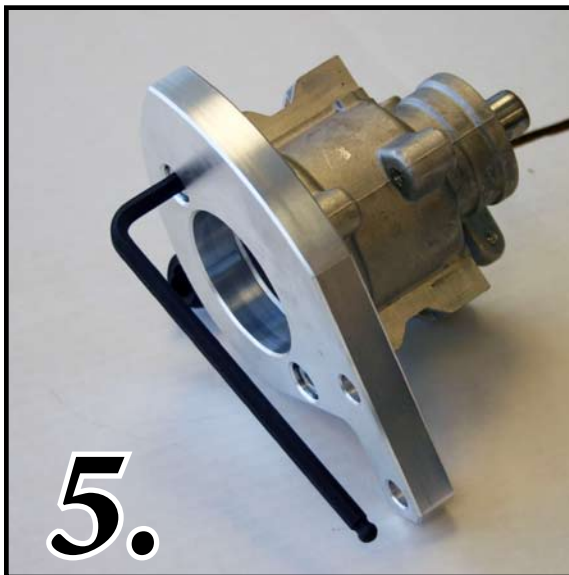
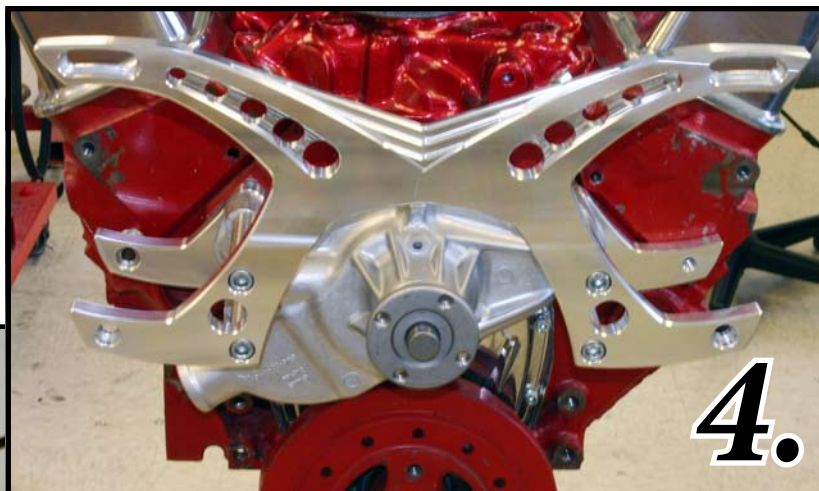


FIG 5. For kit #21075 with Remote Power Steering apply Loc-Tite to the threads of the two (S551) M8-1.25 x 25mm socket head caps screws and attach the Remote Power Steering Pump (P315) to Power Steering Bracket (21104-A).

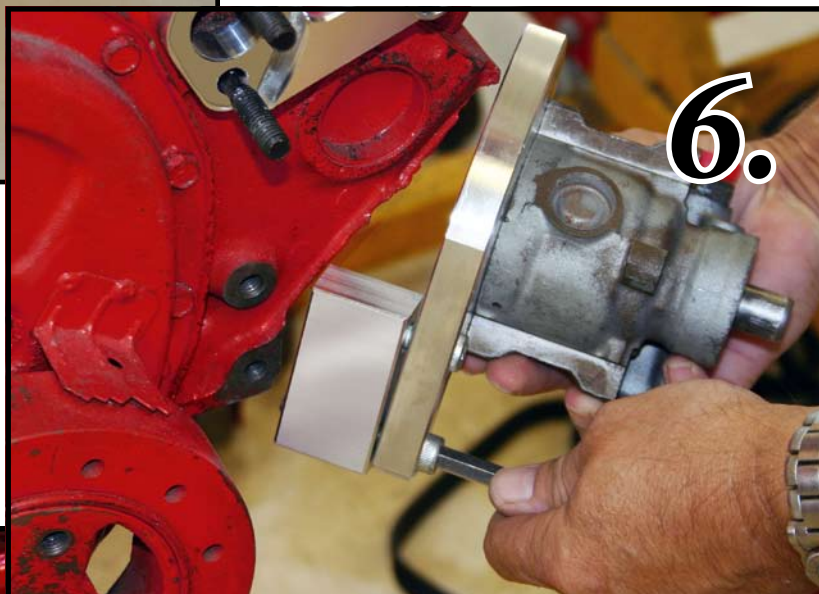


FIG 6. Apply loc-tite to the threads of the two (S260) $\frac{3}{8}$ x $2\frac{1}{4}$ " Socket cap screws. Install the Power Steering Bracket and Pump assembly to the lower right holes of the engine block. Use the provided spacer (21104-B) between the engine block and the Power Steering bracket as shown. Install the Power Steering Pulley (619-A).



FIG 7. Install (S450) threaded bushing into Alternator Rear Support Bracket (21072-A) (as shown Fig 7a). Install the passenger side Alternators (P573) using (1) $\frac{3}{8}$ x $5\frac{1}{2}$ " SHCS (S280) and a TP3-1.775 Spacer Between the rear of the Alt and the (S450) Set Screw. Turn the S450 set screw to take up any slack between the lower alternator support and the spacer. Secure with a $\frac{3}{8}$ " Lock Nut. (S622). The drivers side Alternator uses a $\frac{3}{8}$ -16 x $4\frac{1}{2}$ " SHCS with (TP3-1.890) Spacer. Install between Rear Support and Alternator. Thread into Rear Support (21073-A). (snug only at this time).

FIG 8. Install alternator fans (222-A) and Pulleys (206-A) using lock washers (S685) and nut that comes with the alternators. Tighten alternator pulley nuts (impact to 90 ft, pounds). Install Crank Pulley (6306-A) using three 3/8-24 x 1" SHCS (S292). Install Water Pump Pulley (6307-A) with four 5/16-24 x 7/8" SHCS (S186). Install alternator pulley covers (306-A) with three 8-32x1" SHCS.

Install Power Steering Nose Cover (302-A) with three 8/32-32 x 3/8" SHCS. Kit #21075 Only.

With the Alternators units tilted inward Install the belt 56" (non-power steering) or 57.5" (power steering).

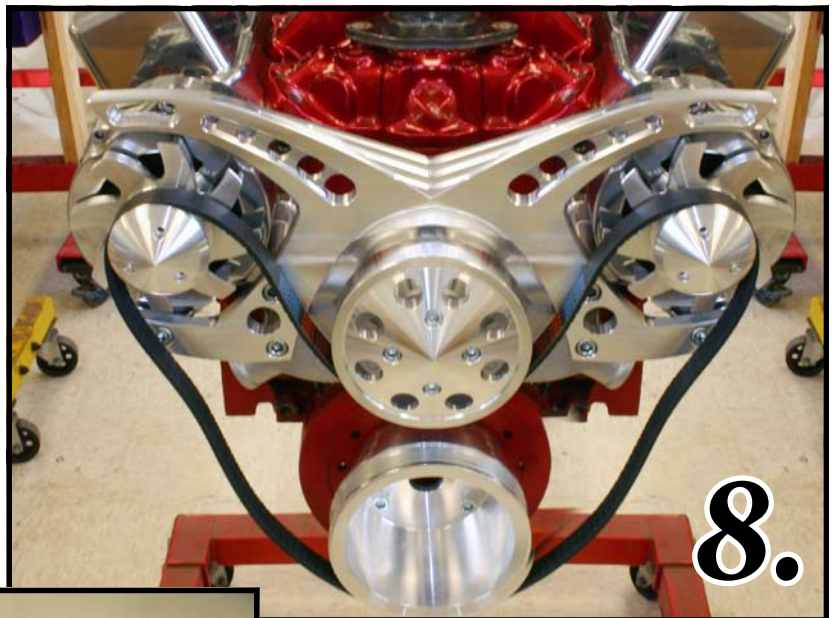


FIG 9. In both upper alternator adjustment slots install the provided MM100 Adjustment Bushings and the 5/16 x 1 1/4" SHCS (S148), leave loose. For Billet Chrome Alternators use M8-1.25 x 35mm (S553)

FIG 10. Slip the supplied March Adjustment tool over the two (MM100) Adjustment bushings. Use a wrench to turn the adjustment tool outward to tighten the serpentine belt to 100 ft. lbs. Use the holes in the adjustment tool to tighten both 8mm socket head cap screws when correct belt tension has been achieved. Remove the adjustment tool and keep for future use.

TIP: Your Serpentine belt is tight when it can't be moved by more than 1/2 inch at it's longest span between pulleys. The belt should not be able to be twisted by more than half a turn.



Final Assembly

Check and tighten all bracket bolts and alternator and power steering lower mounting bolts, turn engine over once by hand to check for any belt rubbing and proper belt alignment. Run engine three minutes and check belt tension again.

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100% credit issued on manufacturer defects

20% return fee on all reshelvable product

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Purchased Directly Through _____ Invoice# _____

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Reason _____

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