



Highly Styled, Low Cost Serpentine Drive

Installation Instructions

Chevy Big Block

#21200 (without Power Steering)

#21250 (with Remote Power Steering)

#21255 (with Saginaw Power Steering)



Parts List

Main Front Bracket Kit P/N 21201

- 1 - 21201-A.....Main Front bracket body
- 4 - S248 $\frac{3}{8}$ - 16 x 1" SHCS
- 1 - S276 $\frac{3}{8}$ - 16 x 4 $\frac{1}{2}$ " SHCS
- 4 - S339 $\frac{3}{8}$ - 16 x 3" Threaded Stud
- 1 - S550M8 - 1.25 x 20mm SHCS
- 2 - S553M8 - 1.25 x 35mm SHCS
- 4 - S7853.000" Threaded Spacer Stainless
- 2 - MM100.....Alum Bolt Cap

Alt Rear Support Bracket P/N 21202

- 1 - 21202-A.....Alt Support Bracket Body
- 1 - S277 $\frac{3}{8}$ - 16 x 4 $\frac{3}{4}$ " SHCS
- 1 - S452 $\frac{5}{8}$ " Threaded Bushing
- 2 - S741O-Rings 1 $\frac{5}{8}$ " OD x 1 $\frac{3}{8}$ " ID x $\frac{1}{8}$ " Thick
- 1 - A3-1.250.....Alum Spacer 1 $\frac{1}{4}$ " Lg

A/C Rear Support Bracket P/N 21203

- 1 - 21203-A.....A/C Support Bracket Body
- 1 - S150 $\frac{5}{16}$ - 18 x 1 $\frac{1}{2}$ " SHCS
- 2 - S741O-Rings 1 $\frac{5}{8}$ " OD x 1 $\frac{3}{8}$ " ID x $\frac{1}{8}$ " Thick
- 1 - TP3-.300..... $\frac{3}{8}$ " ID x .300 Lg Spacer

Power Steering Bracket P/N 21204

- 1 - 21204-A.....Power Steering Bracket Body
- 2 - S260 $\frac{3}{8}$ - 18 x 2 $\frac{1}{4}$ " SHCS
- 2 - S356 $\frac{7}{16}$ - 14 x 2 $\frac{1}{4}$ " SHCS
- 2 - S556M8 - 1.25 x 40mm SHCS

Belt Tensioner Tool P/N 21205

- 1 - MM101.....Right Hand Rod End
- 1 - MM102.....Left Hand Rod End
- 1 - MM105.....13" Threaded Rod

Chevy BB Pulley Kit P/N 7660-206

- 1 - 7666-A.....Crank Pulley body
- 1 - 6302-A.....Water pump Pulley Body
- 1 - 206-A.....Alternator Pulley Body
- 1 - 306-A.....Alternator Pulley Cap Body
- 1 - 221.....Alternator Fan
- 1 - 394-A.....A/C Cover Body
- 3 - S028 $\frac{8}{32}$ x 1" SHCS
- 3 - S520 M6 - 1.0 x 16mm Button Head Bolts
- 4 - S186 $\frac{5}{16}$ - 24 x $\frac{7}{8}$ " SHCS
- 3 - S248 $\frac{3}{8}$ - 16 x 1" SHCS
- 1 - S6851 $\frac{1}{16}$ " Lock Washer
- 1 - S716Water Pump Bushing
 $\frac{3}{4}$ " OD x $\frac{5}{8}$ " ID x $\frac{3}{16}$ " Long

- 1 - 618-A.....P/S Pulley (Press Fit)

(For Kit # 21250)

- 1 - 302-A.....P/S Pulley Nose Cover

(For Kit # 21250)

- 3 - S022 $\frac{8}{32}$ x $\frac{3}{8}$ " SHCS

(For Kit # 21250)

Accessories

- 1 - P125BB Chevy Alum Water Pump Rev.
Rotation
- 1 - P412Sanden A/C Compressor (chrome)
- 1 - P417A/C Line Kit
- 1 - P572Alum Alternator (chrome)
- 1 - P315Remote P/S Pump
(For Kit # 21250)

Use (1) 21205 P/S Bracket if using Saginaw P/S Pump

Required Tools and Materials

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

$\frac{9}{16}$ " Combo Wrench
 $\frac{11}{16}$ " Combo Wrench
 $\frac{3}{4}$ " Combo Wrench
Socket Wrench & Extension
10mm 12pt. socket
12mm 12pt. socket

Serpentine Belt

65" for Kits Without Power Steering
67 $\frac{1}{2}$ " for Kits With Remote Power Steering
69" for Kits With Saginaw Power Steering

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 the (4) $\frac{3}{8}$ x 3" mounting studs (S339) into the four water pump mounting holes $\frac{1}{2}$ " inch deep into block.

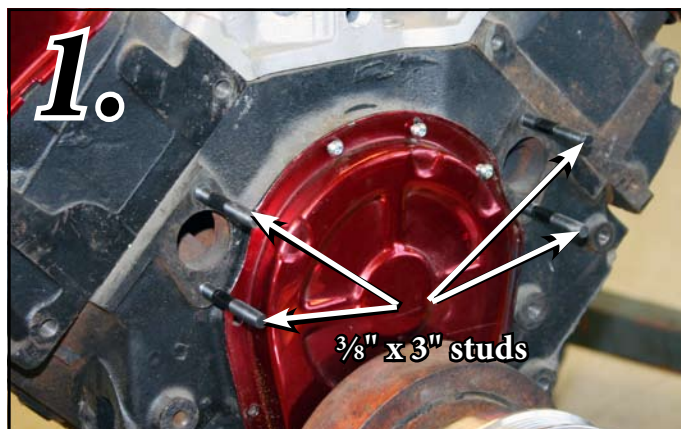


Fig 2. Make sure the (4) $1\frac{5}{16}$ " O-rings (S741) are seated in their grooves in the Rear A/C Support Bracket (21202-A) and Rear Alternator Support Bracket (21203-A). Install the brackets over studs to the face of the block as shown.

NOTE: These brackets have O-rings on both the back (block side) and front (water pump side). Also use a small amount of gasket sealer on both the front and rear sealing surfaces to ensure a water tight seal.

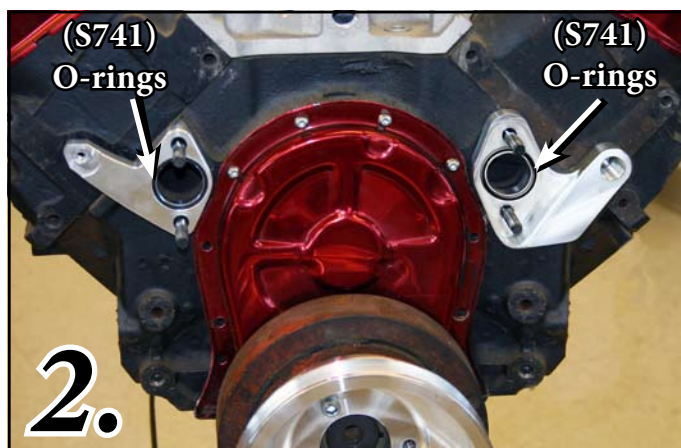


Fig 3. Being sure the four (S741) O-rings remain seated install the Water Pump (P125) over the studs and secure with (4) 3" threaded spacers (S785) as shown and tighten.

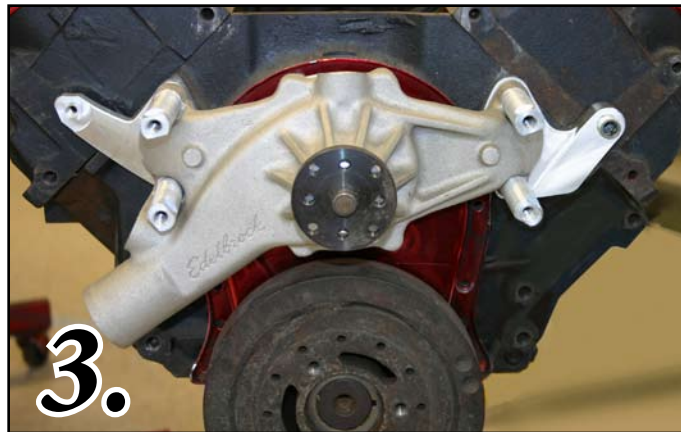


Fig 4. Install Main Front bracket (21201-A) to the threaded studs using (4) $\frac{3}{8}$ -16 x 1" socket caps. (S248)

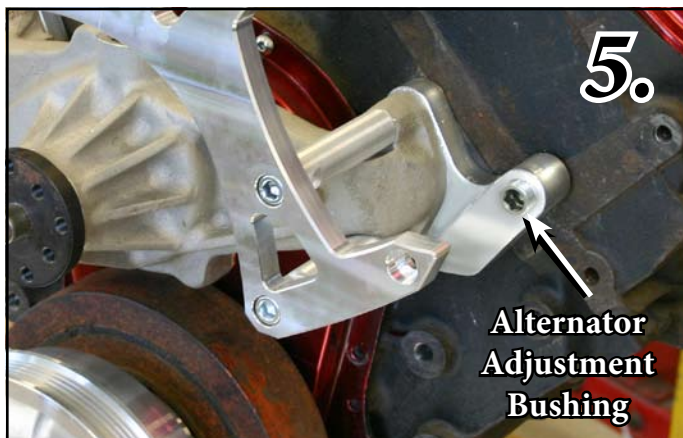


Fig 5. Install $\frac{5}{8}$ "-18 Threaded Alternator Adjustment Bushing (S452) into Rear Alternator Support Bracket as shown.

Fig 6. Install the Alternator (P572) using a $\frac{3}{8}$ x $4\frac{3}{4}$ " SHCS (S277) and the billet spacer bushing (A3-1.250). Adjust Bushing (S452) to take up any space between the lower alternator support and the spacer. (snug only at this time). Tighten lightly at this time.



Fig 7. Install A/C unit (P412) Using a M8 x 20mm SHCS (S550) in the lower front hole and a $\frac{5}{16}$ x $1\frac{1}{2}$ " (S150) SHCS in the rear lower Hole. Use a $\frac{3}{8}$ " I.D. x .300 long spacer (TP3-.300) between the rear A/C bracket and the rear ear of the A/C unit As Shown.

For kit #21250 with remote Power Steering

Fig 8. Install the power Steering Pump (P315). To the Power Steering Bracket (21204-A) With (2) M8 x 40 mm SHCS (S556) Bolts are installed from the Rear of the bracket and into the pump. Install Power Steering Bracket (21204-A) to the lower two holes of the block with (2) $\frac{7}{16}$ x $2\frac{1}{4}$ " (S324) or $\frac{3}{8}$ X $2\frac{1}{4}$ " (S260) SHCS Depending on Tapped holes of the block.



For kit #21255 with Saginaw Power Steering

Fig 9. Mount the front bracket (21205-A) to the front of the Power Steering pump with (2) $\frac{3}{8}$ x $\frac{3}{4}$ " Hex Head (S312). Mount the rear plate (21205-B) to the rear of the Power Steering pump with a $\frac{3}{8}$ x $\frac{3}{4}$ " Hex Head (S312). Use spacer (TP3-.150) between the rear plate and the Power Steering pump.



Fig 11. Swing up A/C and Alt. units and let them swing inward at this time do not install the upper bolts into the Alt. and A/C units at this time.



Fig 13. Apply Loc-Tite to the threads of the four (S186) $\frac{5}{16}$ "-24 x $\frac{7}{8}$ " SHCS. Place the water pump pulley (6302-A) to the water pump and thread the cap screws through pulley and into water pump pulley flange, tighten firmly (28 ft/lbs.)

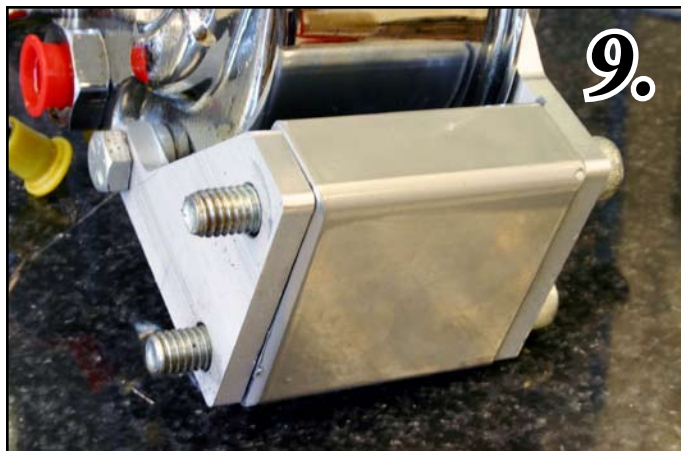


Fig 10. Use the (20115-C) Spacer between the two brackets. Install the unit to the lower right (drivers side) engine block tapped holes with (2) $\frac{7}{16}$ x $3\frac{1}{2}$ " SHCS. Then install the Power Steering pulley.



Fig 12. Install water pump adapter bushing (S716) over the shaft as shown onto the locating boss.



Fig 14. Install power steering pulley. (618-A) Mount pulley in-line with crank pulley. Press on with a $\frac{1}{16}$ " wrench and install tool. When properly installed, pulley should be flush with top of shaft as shown. **Fig 14a.**

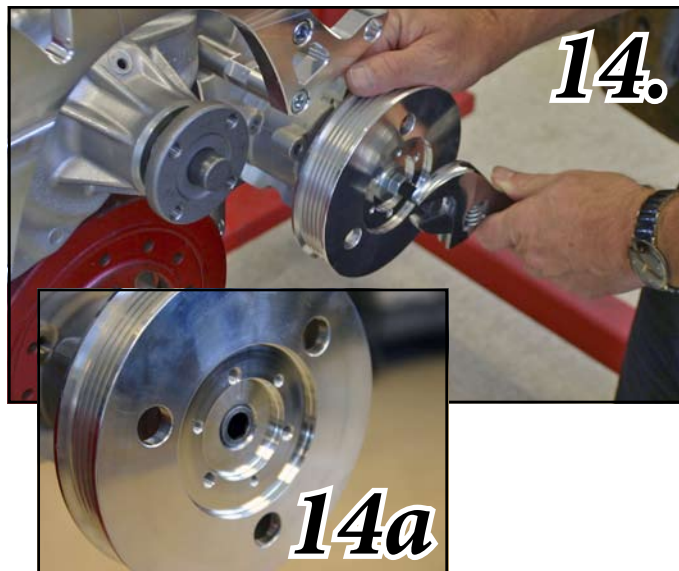


Fig 15. Install (S553) M8 x 1.25 x 35 mm bolt into (MM100) bushings as shown. Install one each into Alternator, and A/C units in adjustment slots, leave loose at this time.

Fig 16. Apply Loc-Tite to the threads of the three (S248) $\frac{3}{8}$ "-16 x 1" SHCS. Place the crank pulley (7666-A) on damper and align holes. Thread the (3) screws through pulley and into damper, tighten firmly (50 ft/lbs.)



Fig 17. Install alternator fan (221) and pulley (206-A) and tighten pulley nut (impact to 90 ft, pounds). Install Alt Cap (306-A) with (3) 8-32 x 1" SHCS (S028). Place the compressor clutch cover (394-A) onto the compressor clutch and align. Thread the three (3) S520 M6 - 1.0 x 16mm Button Head Bolts. through the cover and into the clutch and tighten. **Caution - Do not over-tighten!**

Fig 18. Push the Alternator and A/C inward to their fullest position and Install a (Dayco 5060650) 65" belt for non-power steering kits, (Dayco 5060675) 67½" belt for Remote Power steering kits or (Dayco 5060690) 69" belt for Saginaw Power steering kits.

Slip the supplied March Adjustment tool over the two (MM100) 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 M8 socket head cap screws when correct belt tension has been achieved. Remove the adjustment tool and keep for future use.

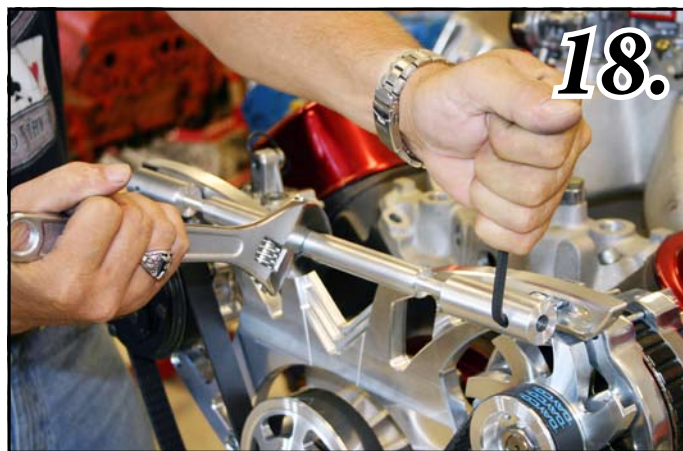


Fig 18a. TIP: Serpentine belt is tight when it can't be moved by more than ½ inch at it's longest span between pulleys. The belt should not be able to be twisted by more than half a turn.

Check and tighten all bracket bolts and alternator and A/C 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.

Final Assembly

If you are going to be installing your air conditioning hoses and charging the system at this time, remove the cover plate on top of the compressor body. Install the (P417) A/C adapter lines, hoses and connect clutch wire and charge system.

Important: If you are NOT installing hoses and charging the system at this time, leave cover plate on compressor. Do not connect the clutch wire or apply power to clutch wire without the hoses connected and the system charged – *Serious damage will occur to compressor.*

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No product mounted is considered for credit unless it is a manufacturer defect.

All products returned for any reason must reference an authorization number (RGA). The RGA number is obtained by calling place of purchase during normal business hours. **Any product returned without the RGA# written on the return package next to the return shipping label will be refused.**

All returns must ship via UPS and be properly packaged in the original carton. Return freight charges are the responsibility of the customer unless the product was shipped in error.

March product returned after (1) year from date of purchase will not be accepted unless it is found to be a manufacturer defect. **The customer must include a written statement describing the alleged product defect.** The complete Limited Warranty is set forth on the reverse side.

100% credit issued on manufacturer defects

20% return fee on all reshelvable product

70% return fee on all repairable product

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March Performance thoroughly inspects all returns. It is the sole discretion of March Performance in determining the condition of all returned merchandise. To receive replacements at no charge the original product must first be received and inspected by March Performance for determination. Immediate replacements may be purchased and later credited upon inspection determination.

Please Complete the Information below, detach and include with returned product.

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Purchaser's Name _____ Phone _____

Address _____

Purchased Directly Through _____ Invoice# _____

Product ID _____ Invoice Date _____

Reason _____

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