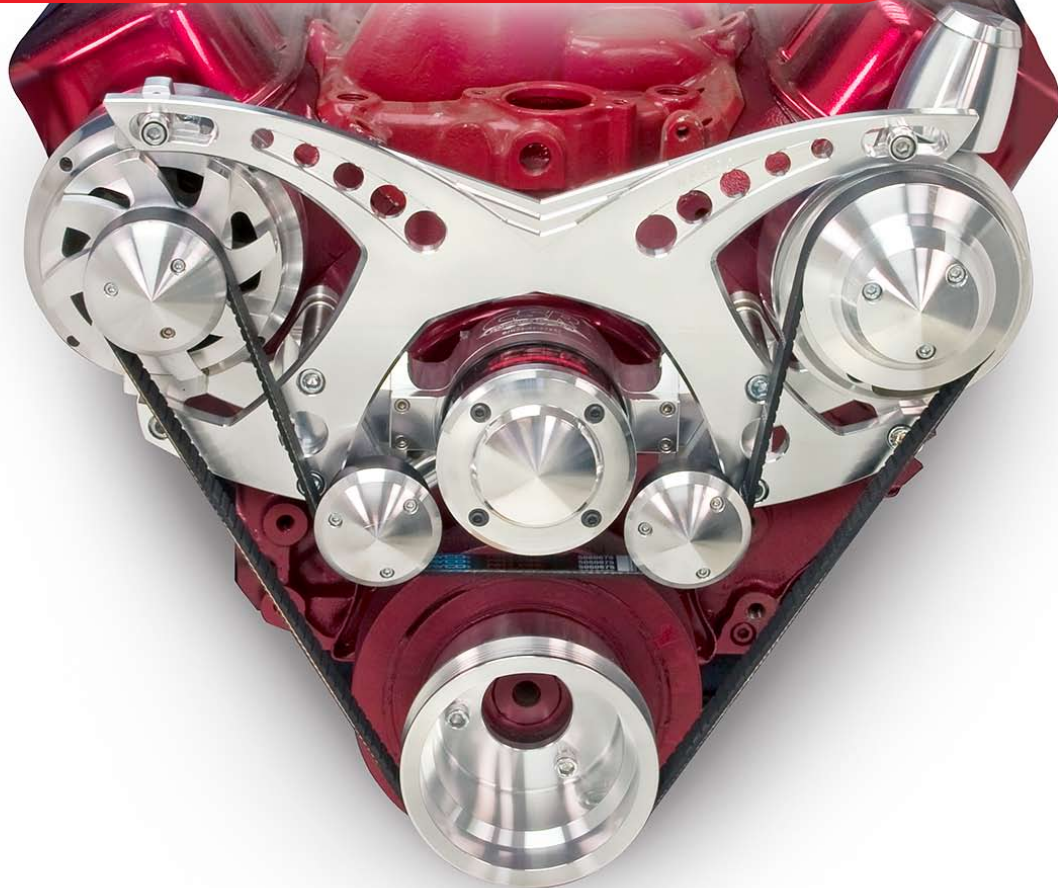


Revolver



Highly Styled, Low Cost Serpentine Drive

Installation Instructions

Chevy Small Block Electric Water Pump Bracket Kit

#22100 (Billet Alternator & Power Steering Pump)

#22105 (Chrome Alternator & Power Steering Pump)



Parts List

Main Front Bracket P/N 22101

- 1 - 21071-A..... Main Front Bracket Body
- 2 - S146 $\frac{5}{16}$ " x 1" Lg SHCS
- 4 - S250 $\frac{3}{8}$ " x $1\frac{1}{4}$ " Lg SHCS
- 4 - S316 $\frac{3}{8}$ " x $\frac{3}{4}$ " Lg Button Head Bolt
- 4 - S336 $\frac{3}{8}$ " x 2" Lg Threaded Stud
- 1 - S551 8M x 25mm Lg Metric SHCS For Chrome Alt
- 4 - S784 $\frac{5}{8}$ " OD x 3" Lg Threaded Spacer
- 2 - MM100..... Bolt Bushing

Alternator Rear Support P/N 21072

- 1 - 21072-A..... Alternator Rear Support Body
- 1 - TP3-1.775..... Tube Spacer 1.775" Lg
- 1 - S280 $\frac{3}{8}$ " x $5\frac{1}{2}$ " Lg SHCS
- 1 - S450 $\frac{5}{8}$ " x $1\frac{1}{8}$ " Lg Set Screw
- 1 - S622 $\frac{3}{8}$ " Lock Nut
- 1 - S675 Water Pump Gasket

Power Steering Rear Support P/N 21073

- 1 - 21073-A..... Power Steering Rear Support Body
- 1 - S276 $\frac{3}{8}$ " x $4\frac{1}{2}$ " Lg SHCS
- 1 - S675 Water Pump Gasket
- 1 - TP3-.700..... Tube Spacer .700" Lg For Billet P/S
- 1 - TP3-.750..... Tube Spacer .750" Lg For Chrome P/S
- 1 - TP3-2.900..... Tube Spacer 2.900" Lg

Power Steering Adaptor P/N 21074

- 1 - 21074-A..... Power Steering Adaptor Body
- 2 - S244 $\frac{3}{8}$ " x $\frac{3}{4}$ " Lg SHCS
- 1 - S312 $\frac{3}{8}$ " x 1" Lg Hex Hd Bolt

Idler Bracket P/N 21077

- 2 - 21077-A..... Idler Bracket Body
- 2 - 740-A Idler Pulley Body
- 2 - 302-A Idler Pulley Cap
- 6 - S022 $\frac{8}{32}$ x $\frac{3}{8}$ " SHCS
- 2 - S324 $\frac{3}{8}$ " x $2\frac{1}{4}$ " Hex Head Bolt
- 2 - S666 $\frac{3}{8}$ " Flat Washer
- 2 - AC3-.550 Alum Spacer .950" OD x .550" Lg

Pulleys P/N 21078-206

- 1 - 6306-A..... Crank Shaft Pulley
- 1 - 206-A Alternator Pulley
- 1 - 221-A Alternator Fan
- 1 - 306-A Alternator Cap
- 1 - 360-A Power Steering Pulley Cap
- 1 - 345-A Water Pump Cover
- 1 - 629-A Power Steering Pulley
- 3 - S028 $\frac{8}{32}$ x 1" Lg SHCS
- 4 - S047 $1\frac{9}{24}$ x 3" Lg SHCS
- 3 - S106 $\frac{1}{4}$ " x $1\frac{1}{4}$ " Lg SHCS
- 3 - S292 $\frac{3}{8}$ " x 1" Lg Fine Thread SHCS
- 1 - S685 $1\frac{1}{16}$ " Lock Washer

Belt Adjustment Tool P/N 21106

- 1 - MM101 RH Rod End
- 1 - MM102 LH Rod End
- 1 - MM103 12" Lg Threaded Hex Rod

Accessories

- 1 - P901 CSR Electric SB Chevy Water Pump
- 1 - P908 Water Hose Adaptor
- 1 - 9600 Billet Alternator
(IN KIT #22100 ONLY)
- 1 - 9650 Billet Power Steering
(IN KIT #22100 ONLY)
- 1 - P304 Saganaw Chrome Power Steering
(IN KIT #22105 ONLY)
- 1 - P555 Alternator Chrome
(IN KIT #22105 ONLY)

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
 $1\frac{1}{16}$ " Combo Wrench
 $\frac{3}{4}$ " Combo Wrench
Socket Wrench & Extension
10mm 12pt. socket
12mm 12pt. socket

64" Serpentine Belt

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

Photo-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 2" mounting studs (S336) into the four water pump mounting holes $\frac{1}{2}$ " inch deep into block as shown.

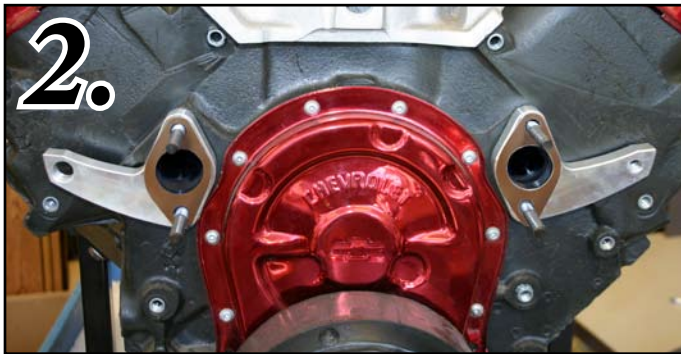


Photo-2 Replace the four $\frac{3}{4}$ " SHCS in the electric Water Pump with the (4) provided $\frac{3}{8}$ x $\frac{3}{4}$ " (S316) Button Head Bolts.

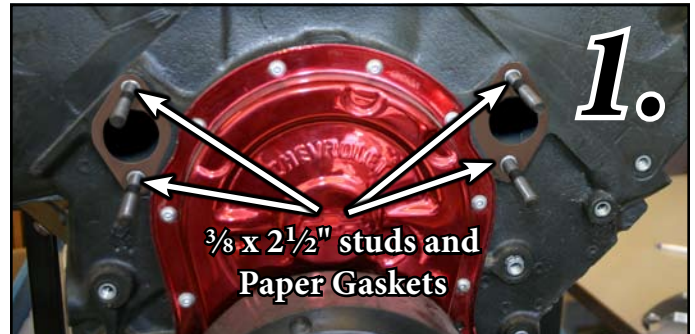
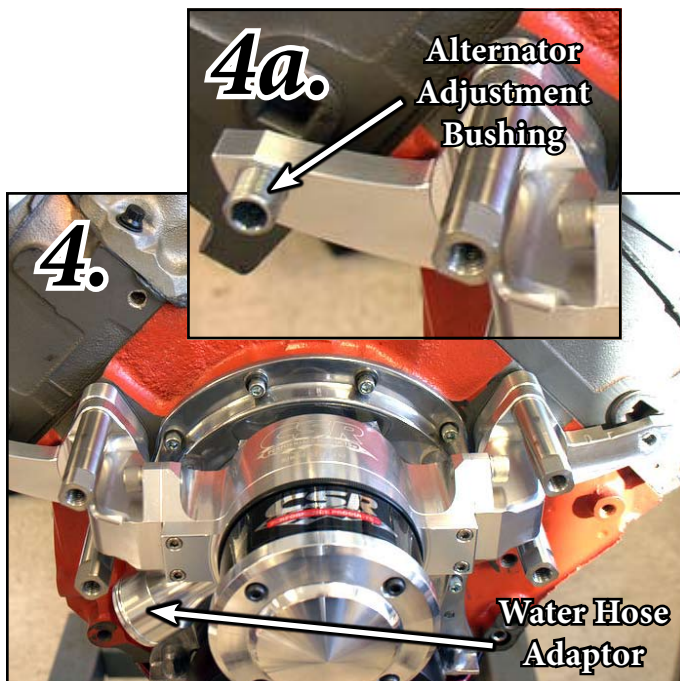


Photo-2 Install (2) Paper Gasket (S675) over the studs and the on the passenger side install the Alternator Rear Support Bracket (21072-A). On the drivers side install the Power Steering Rear Support Bracket (21073-A). Install the second set of Paper Gaskets over the studs that are included with water pump.

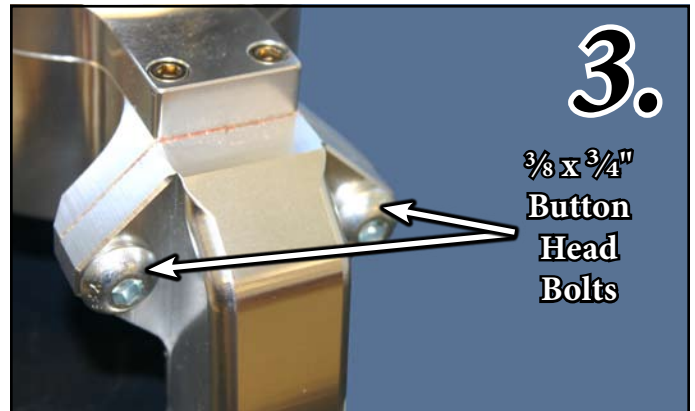


Photo-4 Slide the Electric Water Pump (P901) over the studs and secure with the (4) $\frac{5}{8}$ O.D. x 3" Stainless Steel Threaded Spacers (S784) as shown. Install the Water Pump Cap (345-A) using the (4) 10-24 x 3" SHCS (S047)

Photo-4a Install the $\frac{5}{8}$ x $1\frac{1}{8}$ " Set Screw (S450) into the Rear Alternator Support. Install the Water Hose Adaptor (P908).

Photo-5 Install on the left and right side of the water pump the (2) Idler Brackets (21077-A) between the Main Front Bracket (21071-A) and the Stainless Steel Spacers. Make sure the tapped holes are facing the center of the water pump and the pockets of the Idler Brackets are facing toward the block. Now install Main Front Bracket over the idler brackets using the (4) 3/8 x 1 1/4" SHCS (S250). Tighten at this time.

Install the (2) Idlers (740) into the Idler Brackets using two 3/8 x 2 1/4" Hex Head Bolts (S324), and (2) 3/8" washers (666). and (2) .550" Steel Spacers (AC3-.550) Between the Idlers and the Idler Brackets.



Photo-6 Install the power steering Adapter Ring (21074-A) to the Power Steering Pump (9650 or P304) using (2) 3/8 x 3/4" SHCS (S244) and (1) 3/8 x 1" Hex Bolt (S312) as shown.

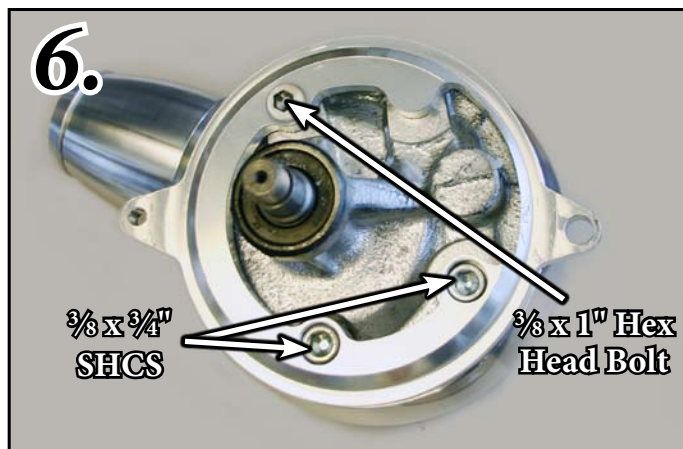


Photo 7 Install the Power Steering Pump and Adapter Ring Unit to the Main Bracket using a 3/8 x 4 1/2" SHCS (S276) in the bottom mount with (1) (TP3-.750) Spacer and (1) (TP3-2.900) Spacer between the rear support and the lower clearance hole of the power steering relocation bracket. **NOTE: For kits with March Billet Pump use (1) (TP3-.700) Spacer and (1) (TP3-2.900) Spacer.**



Photo 8 Install the Alternator (9600 or P555) using a 3/8 x 5 1/2" SHCS (S280) and a 3/8" lock nut (S622). Place (1) Billet Spacer Bushing (TP3-1.730) between the Alternator and the Adjust Set Screw (S450). Adjust S450 to take up any space between the lower alternator support and the spacer. (snug only at this time).

(NOTE: If using the billet Alt. Unit use a 5/16 x 1 1/4" SHCS (S146) in place of the metric bolt 8M x 25mm SHCS (S551).)



Photo 9 In the upper Alternator and Power Steering slots use the two (MM100) Alum. Bolt bushings and the (2) 5/16 x 1" SHCS (S146) (snug only at this time)



Photo 10 Apply Loc-Tite to the threads of the (3) $\frac{3}{8}$ -24 x 1" SHCS (S292). Place the crank pulley (6306-A) on damper and align holes. Thread the (3) screws through pulley and into damper, tighten firmly (50 ft/lbs.)



Photo 11 Install alternator fan (221-A) and pulley (206-A) over the alternator shaft. Use the lockwasher (S685) and then tighten pulley nut (impact to 90 ft, pounds). Install Alt Cap (306-A) with (3) $\frac{8}{32}$ x 1" SHCS (S028).

Photo 12 Slip on the Power Steering Pulley (629-A) and tighten with Locknut. Install the Power Steering Pulley Cap (360-A) with (3) $\frac{1}{4}$ x $1\frac{1}{4}$ " SHCS (S106). Push the Alternator and A/C inward to their fullest position and Install a 64" belt, running the belt under the Water Pump and under the idlers.



Photo 13 Slip the supplied March Adjustment tool (21106) 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 8M socket head cap screws when correct belt tension has been achieved. Remove the adjustment tool and keep for future use. Install the Idler Caps (302-A) using (3) $\frac{8}{32}$ x $\frac{3}{8}$ " SHCS (S022).

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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Exclusions from Warranty Coverage

March Performance does not warrant any Product that is damaged from abuse, misuse or misapplication or not used for its intended purposes.

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Your Responsibilities:

1. Use and install the Product only for its intended purpose.
2. To avail yourself of this Limited Warranty, return the Product with a copy of the paid receipt, postage paid to:

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3. When returning the Product, you must follow the directions set forth on the Warranty/Return Form on the reverse side of this Limited Warranty. If you no longer have the Warranty/Return Form, one may be obtained by contacting March Performance during normal business hours at: (888) 729-9070.

4. Shipping and/or transportation costs returning the Product to March Performance and any damage caused during shipping are your responsibility. March Performance will pay for shipping and/or transportation costs incurred in returning the Product to you.

LIMITED WARRANTY WARRANTY/RETURNS FORM

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

NO CREDIT WILL BE ISSUED ON RETURNED PRODUCT BEYOND REPAIR

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.

RGA# _____ CT# _____ Issued by: _____ Date _____

Purchaser's Name _____ Phone _____

Address _____

Purchased Directly Through _____ Invoice# _____

Product ID _____ Invoice Date _____

Reason _____

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