



Revised 2-27-08



Highly Styled, Low Cost Serpentine Drive

Installation Instructions

*Ford Small Block 289-302-351 Windsor
Kit #30420 (with Power Steering)
and #30410 (without Power Steering)*



Included Parts List

Main Front Bracket PN 30411

- 1 - 30411-A.....Face Plate Body
- 2 - TP3-1.100....Tube Spacers
- 2 - MM-100Bolt Adjustment Sleeves
- 4 - S144 $\frac{5}{16}$ - 18 x $\frac{7}{8}$ " SHCS
- 2 - S150 $\frac{5}{16}$ - 18 x $1\frac{1}{2}$ " SHCS
- 1 - S155 $\frac{5}{16}$ - 18 x 2" SHCS
- 2 - S174 $\frac{5}{16}$ - 18 x $5\frac{1}{2}$ " SHCS
- 3 - S209 $\frac{5}{16}$ - 18 x $3\frac{1}{2}$ " STUD
- 2 - S551M8 - 1.25 x 25mm SHCS
- 2 - S553M8 - 1.25 x 35mm SHCS
- 2 - S616 $\frac{5}{16}$ " Lock Washer
- 5 - S660 $\frac{5}{16}$ " Flat Washer
- 3 - S769Threaded Stainless Spacer

Alternator Rear Support PN 30412

- 1 - 30024-A.....Alt Rear Support Body
- 1 - S248 $\frac{3}{8}$ - 16 x 1" SHCS
- 1 - S278 $\frac{3}{8}$ - 16 x 5" SHCS
- 1 - S344 $\frac{7}{16}$ - 14 x 1" SHCS
- 1 - S450 $\frac{5}{8}$ - 18 x $1\frac{1}{8}$ " Set Screw
- 1 - S672 $\frac{7}{16}$ " Flat Washer SAE

A/C Rear Support PN 30413

- 1 - 30413-A.....A/C Rear Support Body
- 1 - S150 $\frac{5}{16}$ - 18 x $1\frac{1}{2}$ " SHCS
- 1 - S312 $\frac{3}{8}$ - 16 x 1" Hex Head Bolt
- 1 - S385 $\frac{7}{16}$ - 14 x 1" Hex Head Bolt
- 1 - S672 $\frac{7}{16}$ " Flat Washer SAE

Power Steering Bracket PN 30414 (for kit # 30420)

- 1 - 30414-A.....Front Power Steering Bracket Body
- 1 - 30414-B.....Rear Power Steering Bracket Body
- 1 - 30019-C.....Timing Pointer
- 2 - S160 $\frac{5}{16}$ x $2\frac{3}{4}$ " SHCS
- 2 - S550M8 - 1.25 x 20mm SHCS

Pulleys Kits PN 2280-206

- 1 - 2281-A.....Crank Pulley Body
- 1 - 2282-A.....Water Pump Pulley Body
- 1 - 221.....Alt Fan
- 1 - 206-A.....Alt Pulley Body
- 1 - 306-A.....Alt Pulley Cap Body
- 1 - 322-A.....Water Pump Pulley Cap Body
- 1 - 394-A.....A/C Pulley Cover Body
- 3 - S028 $\frac{8}{32}$ x 1" SHCS
- 3 - S520M6 - 1.0 x 16mm Button Head Bolts
- 4 - S186 $\frac{5}{16}$ - 24 x $\frac{7}{8}$ " SHCS
- 4 - S248 $\frac{3}{8}$ - 16 x 1" SHCS
- 1 - S685 $1\frac{1}{16}$ " Alt Lock Washer
- 1 - 618-A.....Power Steering Pulley (for kit # 30420)
- 1 - 302-A.....Power Steering Pulley Cap (for kit # 30420)
- 3 - S022 $\frac{8}{32}$ x $3\frac{3}{8}$ " SHCS (for kit # 30420)

Belt Tensioner Tool

- 1 - MM101.....RH Aluminum Rod End
- 1 - MM102.....LH Aluminum Rod End
- 1 - MM105.....Threaded Rod Aluminum 13" Long

Timing Pointer Bracket PN 30417 (for Kit 30410)

- 1 - 30019-A.....Pointer Bracket Body
- 2 - TP3-.650.....Spacer Tube
- 2 - S144 $\frac{5}{16}$ - 18 x $\frac{7}{8}$ " SHCS
- 2 - S158 $\frac{5}{16}$ - 18 x $2\frac{1}{2}$ " SHCS
- 1 - S616 $\frac{5}{16}$ x 18 Nylon Lock Nut

Accessories

- 1 - P412Sanden A/C Compressor (chrome)
- 1 - P500Ford Water Pump with Front Cover
- 1 - P417A/C Line Kit
- 1 - P572Alternator Chrome Alum
- 1 - P315Remote Power Steering Pump (for kit # 30420)

Required Tools and Materials

- RTV Silicone
- Loc-Tite® Thread Locker
- 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
- 1994 to 1995 SVO Timing cover Gasket Set

Serpentine Belt

- Dayco #5060595 59 $\frac{1}{2}$ " 6 Rib Belt, for Kits With Power Steering
- Dayco #5060575 57 $\frac{1}{2}$ " 6 Rib Belt, for Kits Without 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. Assemble Water Pump to Timing Cover along with proper gaskets and a thin coat of RTV silicone sealant. Use the appropriate fasteners in locations A, B, and C, shown in the water pump drawing.

1.

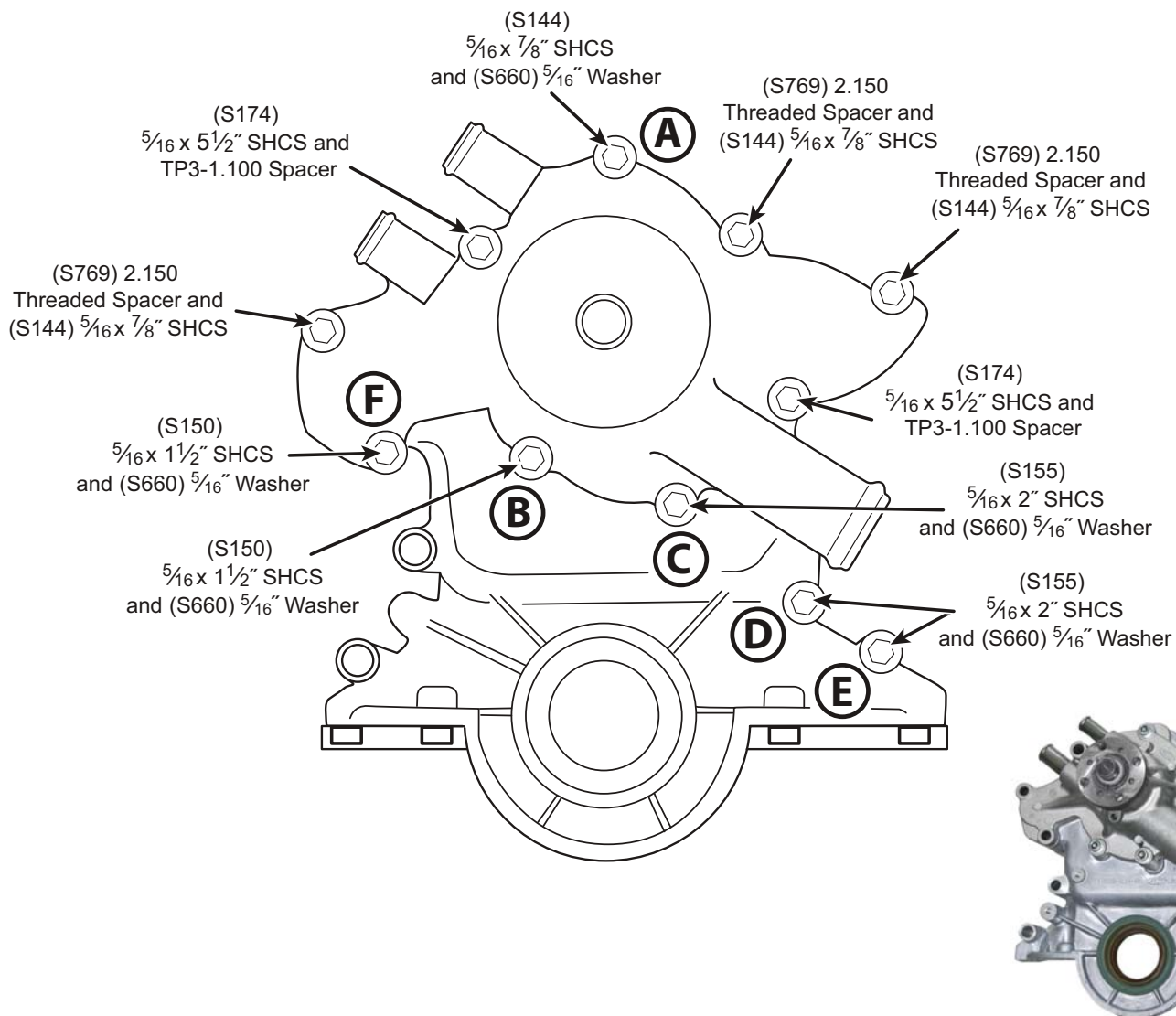


Fig-2: Ensure that the gasket sealing face on the engine block, oil pan and timing cover are clean, flat and free of old gasket material. Install Three (S209) $\frac{5}{16}$ x 3 $\frac{1}{2}$ " studs into block at the locations shown.

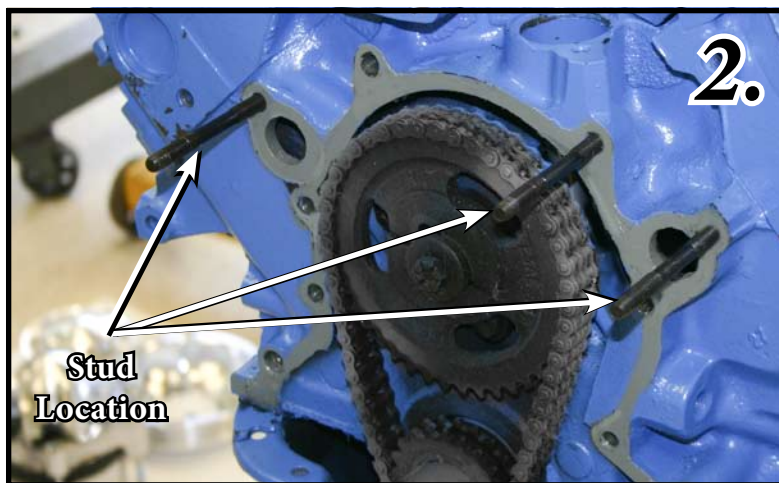


Fig-3: Apply a thin coat of RTV silicone sealant to a new timing cover gasket and oil pan to timing cover gaskets. Install timing cover and (P500) water pump to block. Secure using the Three Threaded Stainless Spacer (S769) as shown in **Fig-3**. Add water pump and timing cover bolts in locations D, E, and F, (See Fig 1 for proper placement and bolt sizes.) Do not forget to reinstall the four factory bolts through the oil pan and into timing cover.

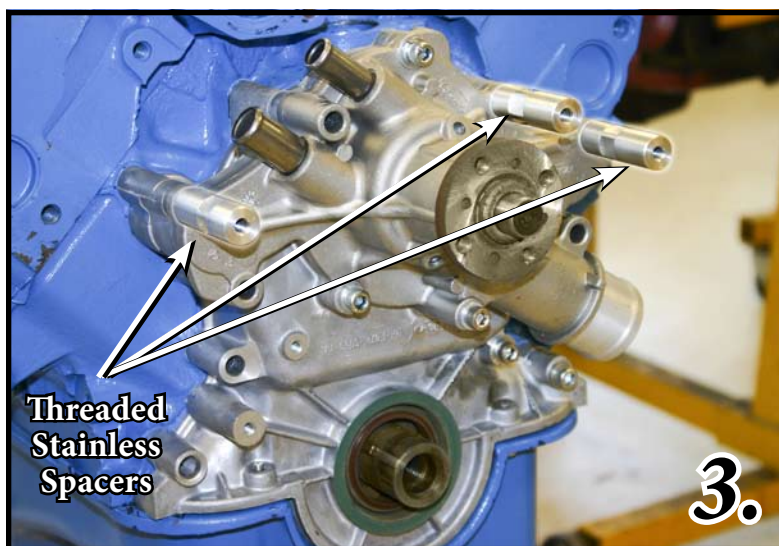


Fig-4: Mount the A/C unit Rear support Bracket (30413-A) to the lower passenger side head using a (S385) $\frac{7}{16}$ or (S312) $\frac{3}{8}$ x 1" Hex Head Bolt depending on tapped hole in head. Include a (S672) SAE Flat washer (Leave loose at this time) .

Mount the Alternator Rear Support (30024-A) to the Drivers side head use a (S344) $\frac{7}{16}$ or (S248) $\frac{3}{8}$ x 1" SHCS depending on tapped hole in head Note position and leave loose at this time.

Install Threaded Bushing (S450) into rear Alternator bracket as shown.

Install the Rear Power Steering Bracket (30414-B) and timing mark. Mount the Timing Pointer (30019-C) over the Rear Power Steering Bracket and install with Two (S160) $\frac{5}{16}$ x 2 $\frac{3}{4}$ " SHCS Screws (leave loose at this time). **NOTE: For kits without Power steering use Two (TP3-.650) Spacers in place of the Rear Power Steering Bracket to support the timing pointer.**

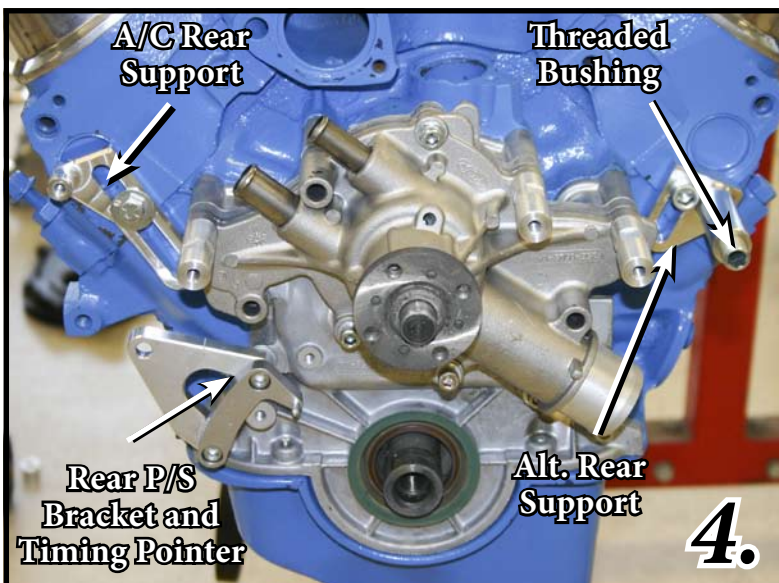


Fig-5: Secure the Front Main Bracket (30411-A) using Two (S174) $\frac{5}{16}$ x $5\frac{1}{2}$ " SHCS along with Two (TP3-1.100) Spacers Between the Main bracket and the water pump. Install Three (S144) $\frac{5}{16}$ -18 x $\frac{7}{8}$ " SHCS through the Front Main Bracket and into the Three Threaded Stainless Spacer (S769).

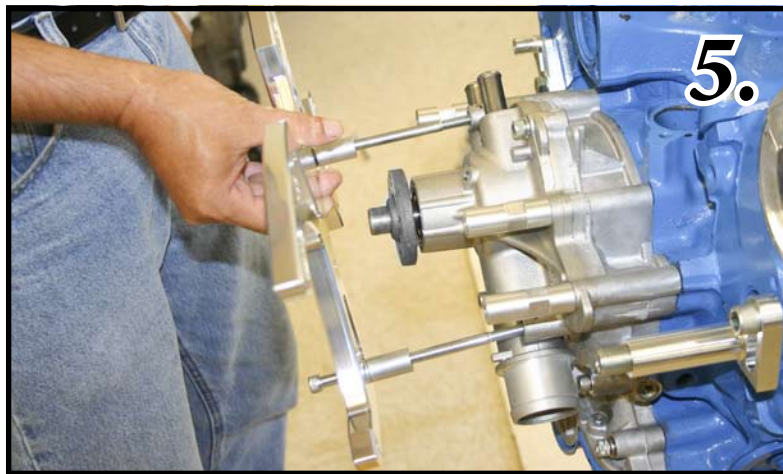


Fig-6: Install (P572) Alternator, Line up (30412-A) Rear Alternator support with front main bracket installation hole. Use a (S278) $\frac{3}{8}$ x 5" SHCS, adjust Threaded Bushing (S450) to take up any slack between Alternator Lower Mount and brackets. Leave loose at this time but tighten rear alternator support bracket to block. In the top alternator hole use a (MM100) bushing and a (S553) M8 x 35mm SHCS (leave loose).

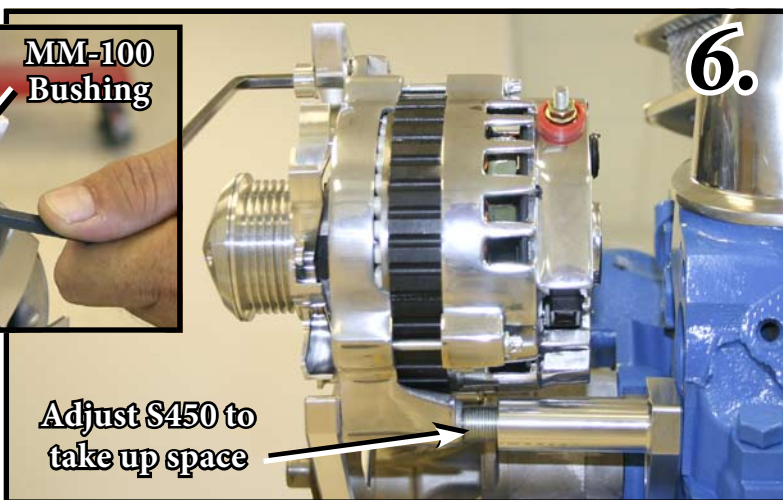
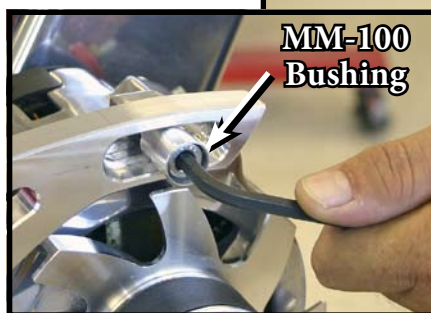


Fig-7: Place the compressor clutch cover (394-A) onto the compressor clutch and align. Thread the three (S520) M6 - 1.0 x 16mm button head bolt through the cover and into the clutch and tighten. **Caution - Do not over-tighten!** Install (P412) A/C unit. Through the front main bracket install (S551) One M8 x 25 mm SHCS into the compressor lower mounting ear and One (S553) M8 x 35 mm into the upper mounting ear along with One (MM100) bushing, (leave both loose at this time).

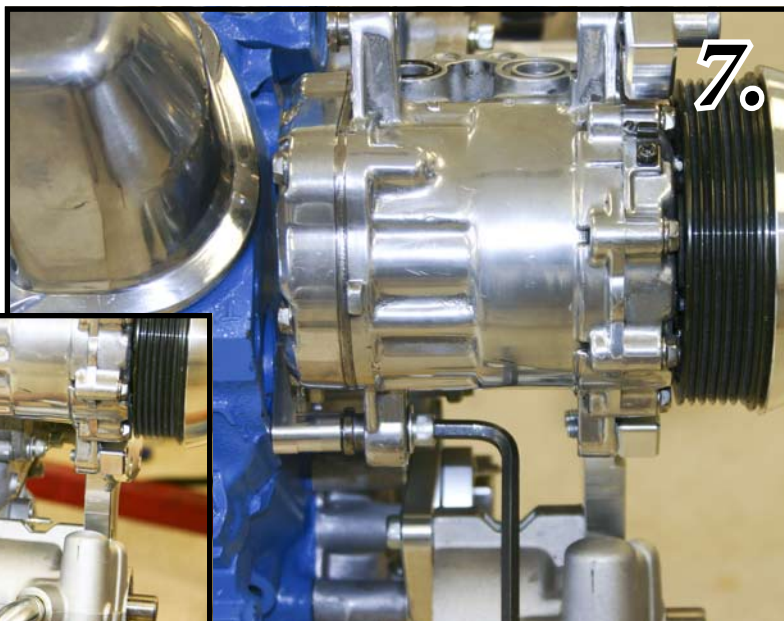


Fig-7a: Secure the compressors rear mounting ear to the (30413-A) A/C Rear Lower Support using One (S150) $\frac{5}{16}$ x $1\frac{1}{2}$ " SHCS, leave loose. Tighten rear A/C support bracket to the block at this time with a $\frac{1}{16}$ " wrench.

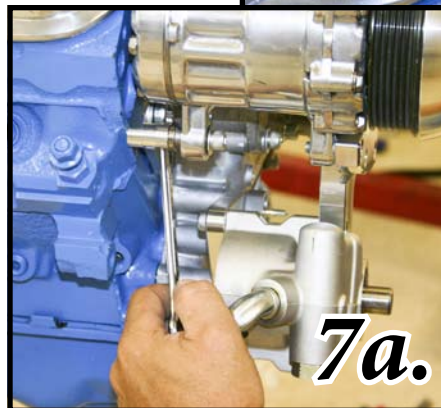


Fig-8: Apply Loc-Tite to the threads of Three (S550) M8 x 20 mm SHCS, Mount the Power Steering Pump (P315) to the Front power steering bracket (30414-A).

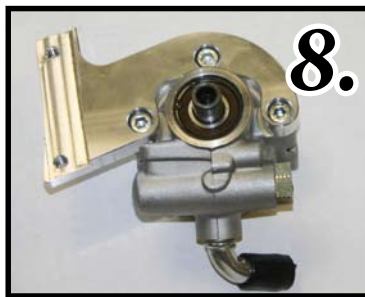


Fig-9: Install the power steering bracket and pump assembly to the Main Front Bracket (30411-A) with Two (S144) $\frac{5}{16}$ -18 x $\frac{7}{8}$ " SHCS. Also secure pump to (30414-B) Rear Power Steering Bracket using One (S550) M8 x 20 mm SHCS. Tighten all front and rear support and timing pointer bolts. For kits without Power steering use Two (S616) $\frac{5}{16}$ " nuts along with the (S144) $\frac{5}{16}$ -18 x $\frac{7}{8}$ " SHCS to fill the holes.

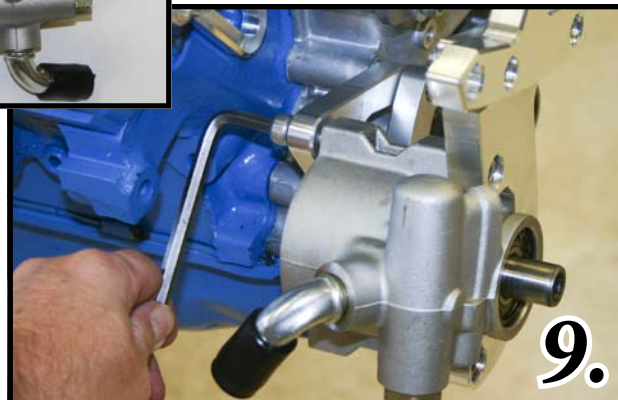


Fig-10: Reinstall balancer to Proper position and Apply Loc-Tite to the threads and reinstall bolt. Apply Loc-Tite to the threads of the four (S248) $\frac{3}{8}$ "-16 x 1" SHCS. Place the crank pulley (2281-A) on damper and align holes. Thread the four bolts through pulley and into damper, tighten firmly (50 ft/lbs.)

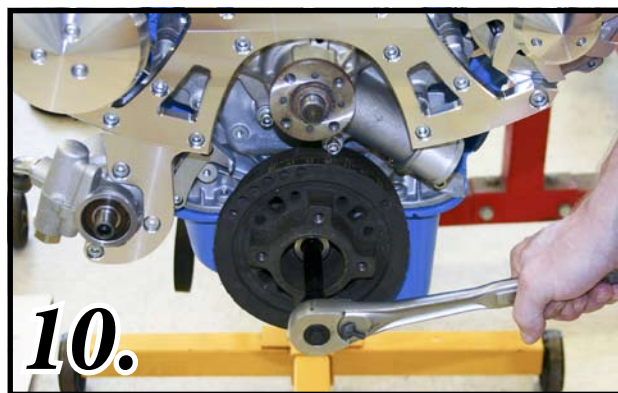


Fig-11: Apply Loc-Tite to the threads of the four (S186) $\frac{5}{16}$ -24 x $\frac{7}{8}$ " SHCS. Place the water pump pulley (2282-A) and (322-A) Water Pump Cap to the water pump and thread the cap screws through pulley and into water pump pulley flange, tighten firmly (28 ft/lbs.) Install (221) Alternator Fan, (S685) Lock Washer and (206-A) Alternator Pulley.



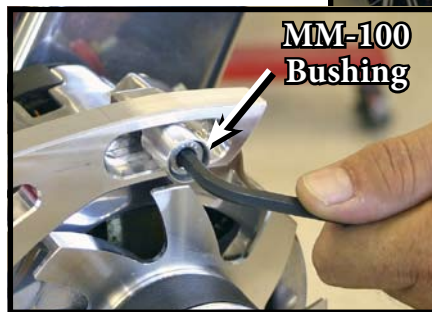
Fig-12: Press (618-A) Power Steering Pulley on with a install tool or bolt and washer as shown. When properly installed pulley should be flush with top of shaft as shown and aligned with crank pulley.



Fig-13: Install Dayco #5060595 59½" (#5060575 57½" without power steering) 6 Rib Belt by removing the top A/C Bolt and (MM100) bushing and allowing it to swing inward past the slot. Install belt as shown pull back A/C unit reinstall (MM100) bushings and M8 SHCS.



Fig-14: Slip the supplied (30416) March Adjustment Tool over the two (MM100) bushings at the Alternator and A/C sides. 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.



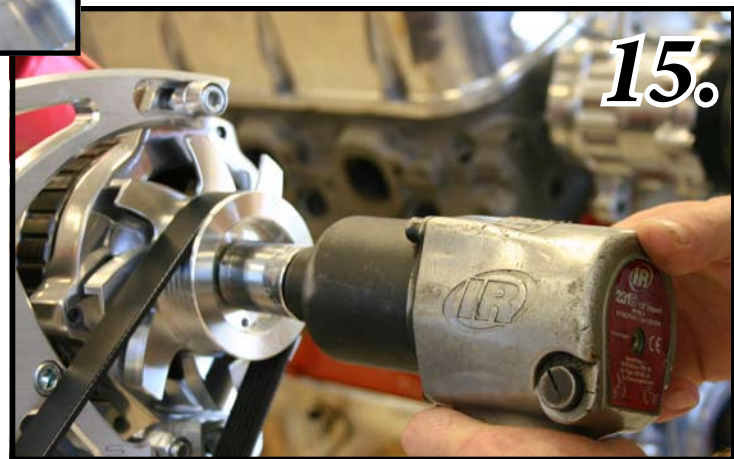
TIP: Fig-14a: Your Serpentine belt is tight when it can't be moved by more than 1/2 inch at it's longest span between pulleys. The belt should not be able to be twisted by more than half a turn.



Fig-15 Tighten alternator pulley nut (impact to 90 ft, pounds). 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.

Install (306-A) Alternator Pulley Cover with three (S028) ⅝ x 1" SHCS.

Install (302-A) Power Steering Pulley Cover with three (S022) ⅝ x ⅜" SHCS.



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.*

MARCH PERFORMANCE, INC. • 16160 PERFORMANCE WAY • NAPLES, FLORIDA 34110
LIMITED WARRANTY

March Performance warrants to the original retail purchaser that for a period of ninety (90) days from the date of purchase, March Performance will repair or replace, at their option, any Product, which is found to be defective in material or workmanship.

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.

This Limited Warranty does not cover or apply to any damage or loss sustained to the engine or any other parts which may have been caused by the defective Product and does not cover or apply to any personal injury, labor charges or any other incidental costs for damages caused by the defective Product. THIS IS THE ONLY EXPRESS WARRANTY GIVEN WITH RESPECT TO YOUR PRODUCT. ALL OTHER EXPRESS WARRANTIES, GUARANTEES, OR STATEMENTS REGARDING THE PRODUCT, WHETHER WRITTEN OR VERBAL, ARE HEREBY DEEMED NULL AND VOID AND OF NO EFFECT.

Normal wear and tear and damage to the Product not caused by March Performance are also excluded from this Warranty.

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EXCEPT TO THE EXTENT PROHIBITED BY APPLICABLE LAW, ANY IMPLIED WARRANTY WHETHER OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR WARRANTY, SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY WILL LAST SO THAT THE PRECEDING LIMITATION MAY NOT APPLY TO YOU.

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REPAIR OR REPLACEMENT AS PROVIDED IN THIS WARRANTY IS YOUR EXCLUSIVE REMEDY. MARCH PERFORMANCE SHALL NOT BE LIABLE FOR ANY INCIDENTAL OR CONSEQUENTIAL DAMAGE FOR BREACH OF ANY EXPRESS OR IMPLIED WARRANTY ON THE PRODUCT. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OF CONSEQUENTIAL DAMAGES SO THE PROCEEDING LIMITATIO OR EXCLUSIONS MAY NOT APPLY TO YOU. YOU HAVE NO RECOURSE OR REMEDY FOR DAMAGE OR DEFECT CAUSED BY MISUSE, ABUSE OR NEGLIGENCE.

THIS WARRANTY GIVES YOU SPECIFIC RIGHTS AND YOU MAY ALSO HAVE OTHER RIGHTS, WHICH MAY VARY FROM STATE TO STATE.

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:
MARCH PERFORMANCE
16160 PERFORMANCE WAY
NAPLES, FL 34110
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 _____

**** MOUNTED PRODUCTS ARE NONREFUNDABLE ****