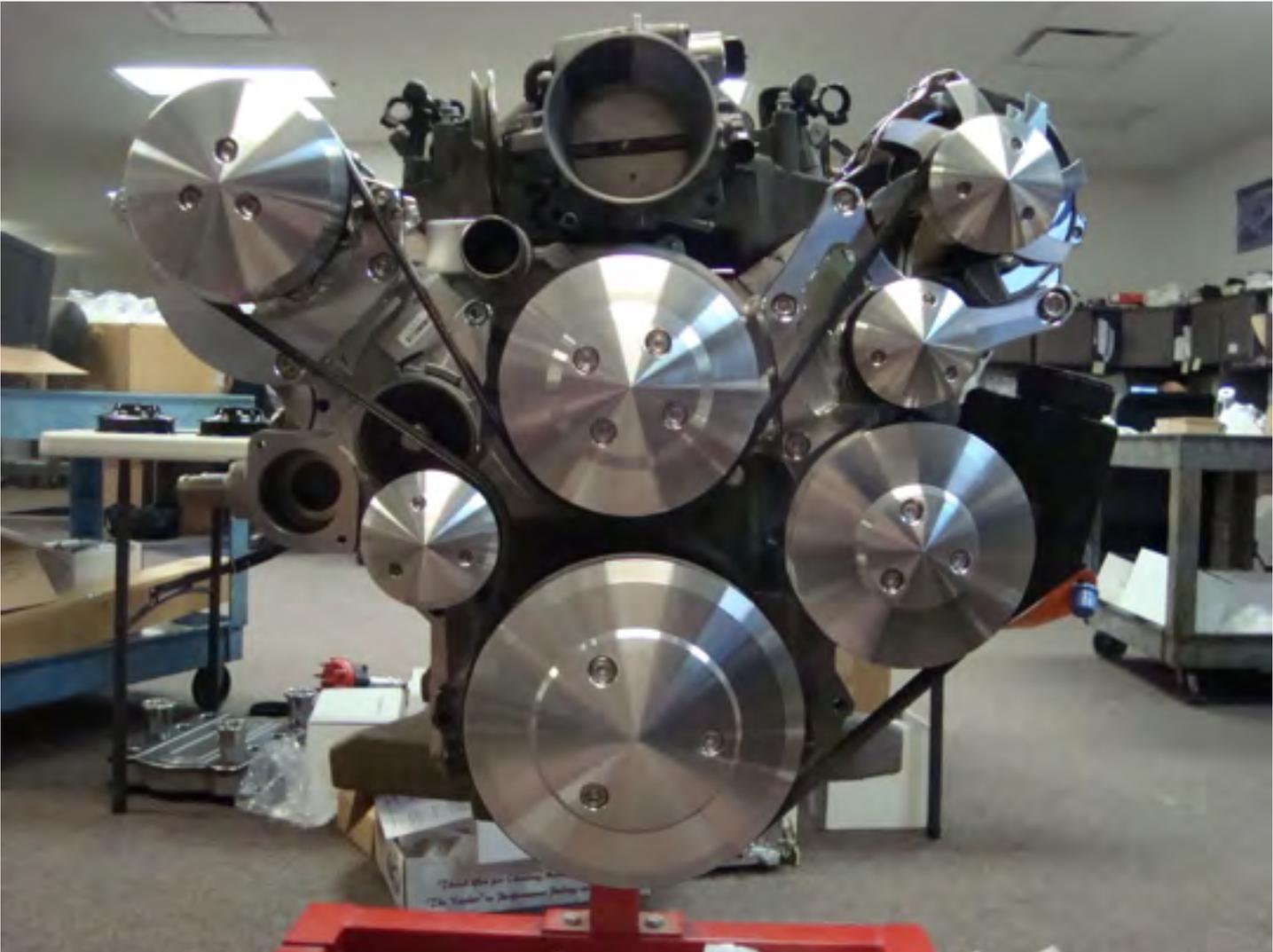


# **MARCH**



***LS Pro Track Serpentine Kit  
Kit # 20030 Alternator & Air Conditioning  
Kit # 20035 Alternator, Air Conditioning & Power Steering  
Kit #20090-08 ALT & AC  
Kit #20095-08 ALT, AC and PS***

**20021 Alternator Bracket**

1-20021-A	Main Alternator Bracket
1-740-A	Idler Pulley
1-302-A	Idler Cap
3-S022	8-32" x 3/8" SHCS
1-S321	3/8" x 1-3/4" Hex Bolt
3-S547	M8 x 1.25 x 140mm SHCS
1-S551	M8 x 1.25 x 25mm SHCS
1-S568	M10 x 1.5 x 140mm SHCS
1-S666	3/8" Washer
3-TP3-2.150	Tube Spacer 2.150"
1-TP7-2.560	Tube Spacer 2.560"

**20022 Power Steering Bracket (20035 only)**

1-20022-A	Main Mounting Bracket
1-20019-A	Rear Support Bracket
2-S550	M8-1.25 x 20mm SCHS
3-TP3-1.580	Tube Spacer 1.580"
2-TP7-.900	Tube Spacer .900"
1-AC3-.500	Tube Spacer .500"
2-S590	M10-1.5 x 45mm SCHC
1-S543	M8-1.25 x 40mm Hex Bolt
1-S660	5/16" Washer

**20024 A/C Bracket**

1-20024-A	Front Bracket
1-20026-A	Spacer Block
1-20027-A	Rear Support Bracket
2-S563	M10 x 70mm SHCS
2-S551	M8-1.25 x 25mm SHCS
1-S561	M10-1.5 x 30mm SHCS
1-S158	5/16" x 2-1/2" SHCS
1-S616	5/16" Lock nut
1-S452	5/8" threaded bushing
1-S660	5/16 Washer

**20028 Tensioner Bracket**

1-20028-A	Bracket
1-307-A	Tensioner Pulley Cap
1-780-A	Tensioner Cap Retainer
3-S025	8-32" x 5/8" SHCS
1-S324	3/8" x 2-1/4" Hex Bolt
3-S545	M8-1.25 x 95mm SHCS

**Pulleys**

1-6361-A	Crank Pulley
1-6366-A	Water Pump Pulley
1-659-A	P/S pulley (20035 Kit Only)
1-394-A	Air Conditioning Cap
1-306-A	Alternator Cap
1-221-A	Alternator Fan
1-206-A	Alternator Pulley
3-S028	8-32" x 1" SHCS
3-S124	1/4" x 3/4" Button Head
3-S248	3/8" x 1" SHCS
3-S520	M6 x 20mm Button Head
1-S685	11/16" Lock Washer
4-S183	5/16-24 x .625" SHCS
4-S186	5/16-24 x .9375" SHCS

**Accessories**

1-P2116	LS Water Pump
1-P2342	P/S Pump (20035 Kit Only)
1-P2412	Air Conditioning Compressor
1-P2525	Alternator
1-P755	Belt Tensioner
1-417	A/C Hose Fittings
1-PS-RES	Power Steering Reservoir

**\*NOTE:** Inspect all items for any imperfections or shortages of items. If any of those instances do come up, please call our tech line that's listed below. If you prefer a color copy of these instructions, please refer to our website listed below and click the instructions tab on your products web page. Some pulleys might have powdercoat build up and it may be necessary to remove with light grit sandpaper. These pulleys include alternator inner hole, and any pulley with a pilot shaft or locator hole.



Tech Support: 1-888-729-9070  
[info@marchperformance.com](mailto:info@marchperformance.com)  
[www.marchperformance.com](http://www.marchperformance.com)

### **Photo-1**

Install required hub adapter (355-04, 356-04, 358-04 ect.) to factory balancer. Remove stock 16mm bolt, and place adapter onto balancer. Apply loc-tite to supplied 16mm x 130mm bolt

(S569) and install with new 11/16" (S686) washer and tighten down to secure hub. The recommended torque is 74 ft lbs.

\*NOTE: Hub adapters must be purchased separately based off your engines factory balancer. Bolt and washer are included in hub adapter, NOT in the serpentine kit.



### **Photo-2**

Install the P2116 water pump and gasket on the passenger side first, using the tensioner bracket 20028-A and securing with three (S545)M8 x 95mm SHCS as shown. Leave slightly loose until driver side is secured.



### **Photo-3 Non power steering**

For the non power steering kits start by inserting gasket between water pump and block and installing alternator bracket 20021-A with three (TP3-2.150) spacers between water pump and bracket. Secure with three (S547)M8 x 140mm SHCS. Leave slightly loose for now and move to photo 7.

### **Photo 3 With power steering**

Start by inserting gasket between water pump and block and installing alternator bracket 20021-A and stacking bracket 20022-A behind the alternator bracket. Use three (TP3-1.580) spacer tubes between the power steering bracket and the water pump. Secure with three M8 x 140mm SHCS (S547). Leave slightly loose for now.





Photo 4

**Photo 4**

Install a AC3-.500 spacer in between 20019-A rear support bracket and backside of power steering pump with a (S543) M8-1.25 x 40mm hex head bolt and (S660) 5/16 washer. Leave bolt loose enough so bracket can pivot.

**Photo 5**

Mount the power steering pump (P2342) to the power steering bracket. Use two M8 x 20mm SHCS (S550).

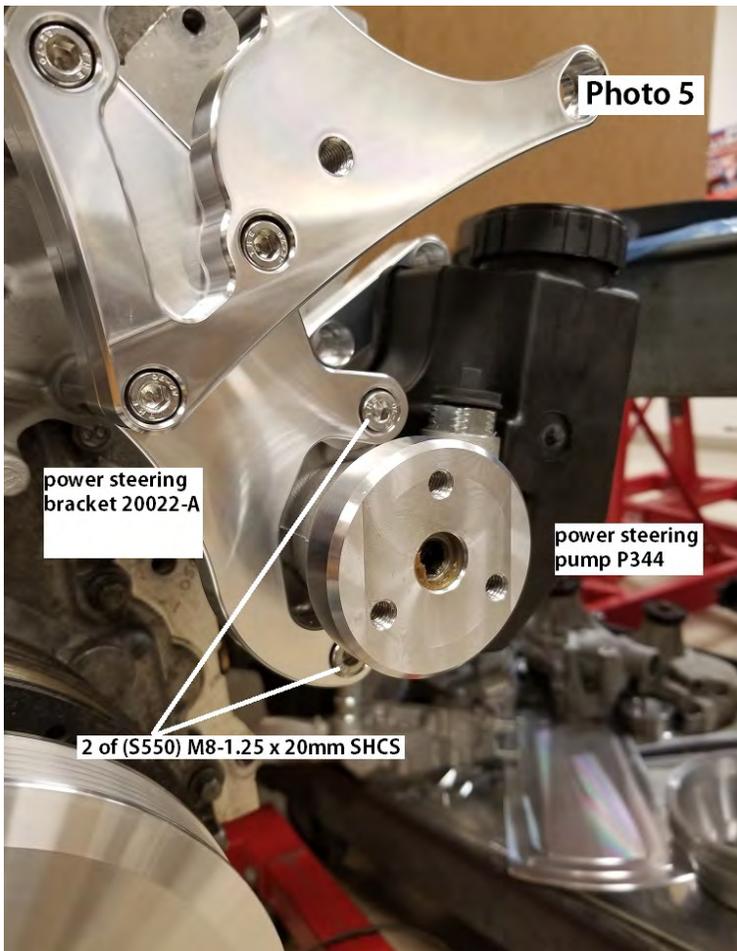


Photo 5

**Photo 6**

Install rear support bracket (20019-A) to cylinder head with two (S590) M10-1.5 x 45MM SHCS and two TP7-.900 tube spacers in between bracket and cylinder head .

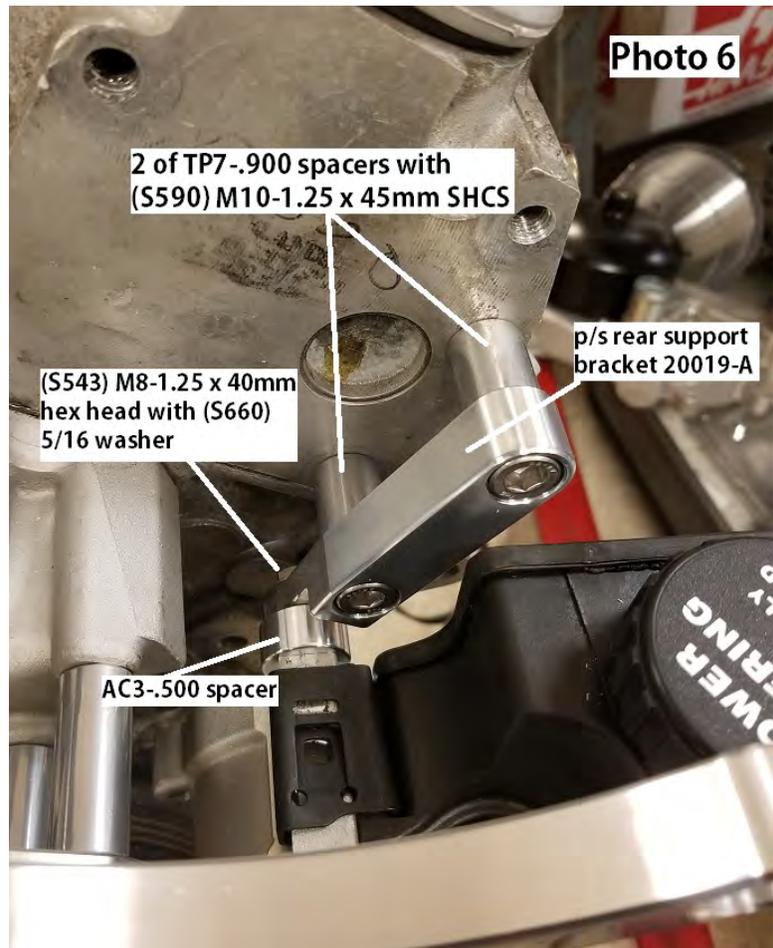
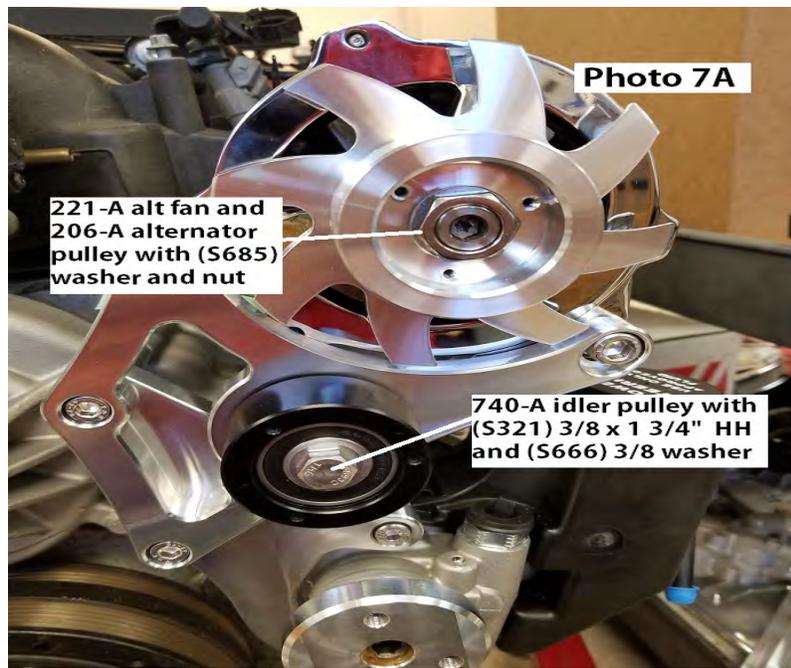


Photo 6

### Photo-7

To mount the alternator (P2525) to the main bracket, In the upper bracket hole use a (S551) M8 x 25mm SHCS. In the outer bolt hole use the provided (S568) M10 x 140mm long SHCS. Between the head and the rear of the alternator use the (TP7-2.560) tube spacer. Slide the bolt through the main bracket, alternator and spacer tube then thread into the outer tapped hole of the head. Now Install the alternator fan 221-A and alternator pulley 206-A with (S685) lock washer then alternator nut. Torque to 70 ft lbs . Now install the alternator nose cover 306-A with three (S028) 8-32" x 1" SHCS as shown. Next install the 740-A idler pulley to the alternator bracket using the provided (S321) 3/8 x 1-3/4" hex bolt and also a 3/8" washer (S666). Install 302-A nose cover to idler with three (S022) 8-32 x 3/8" SHCS. Now secure all the mounting bolts that secure water pump to the block from steps photo 2 & 3. Also secure the (S543)hex bolt from photo 4



### Photo-8

Install the crank pulley 6361-A onto the hub with three (S248) 3/8" x 1" SHCS.



**Photo-9**

Mount the belt tensioner (P755) to the idler bracket 20028-A by first Aligning the pin with the hole in the bracket and then securing with a (S324) 3/8" x 2-1/4" Hex Bolt. Now remove the idler pulley by unbolting counter clockwise. Discard factory washer and install the cap retainer 780-A. Then re-install pulley and secure with factory bolt.

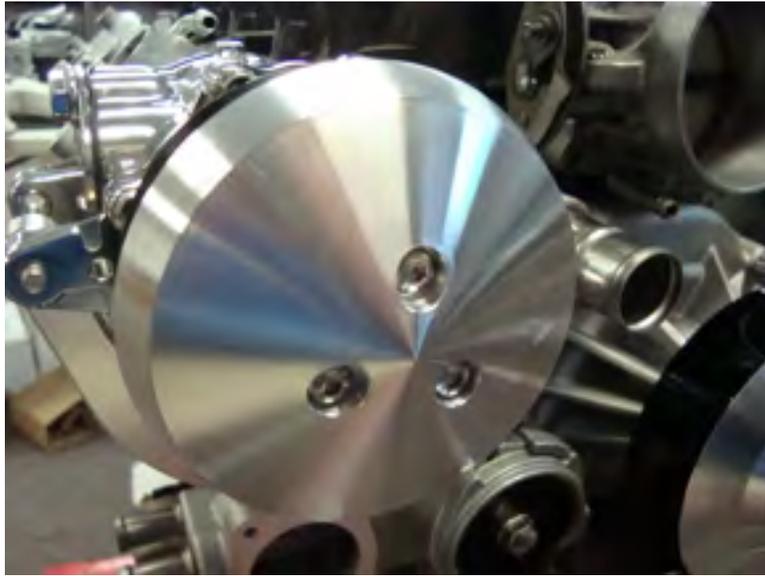
**Photo-10**

Mount the front air conditioning bracket 20024-A to the backside of the air conditioning unit P2412 front mounting ears. Make sure the counterbore holes are facing up in bracket. Secure with two (S551) M8-1.25 x 25mm SHCS through backside of bracket into compressor.

**Photo-11**

Mount the air conditioning bracket 20024-A with the attached compressor P2412 to the two passenger side water pump ears by using spacer bracket 20026-A in between the water pump ears and the front bracket and then secure with two (S563) M10 x 70mm SHCS.





**Photo-12**

Install the air conditioning clutch cover 394-A to the front of the air conditioning unit P2412. Use three (S124) 1/4-20 x 3/4" button heads or three (S520) M6 x 20 mm button heads depending on the threads in clutch on your compressor.

**Photo-13**

To install the rear air conditioning support 20027-A, first install the (S452) 5/8" threaded bushing as shown and the (S561) M10 x 30mm SHCS into the counterbore slot. Use the 5/8 bushing to adjust any gap in between the rear air conditioning ear and cylinder head.



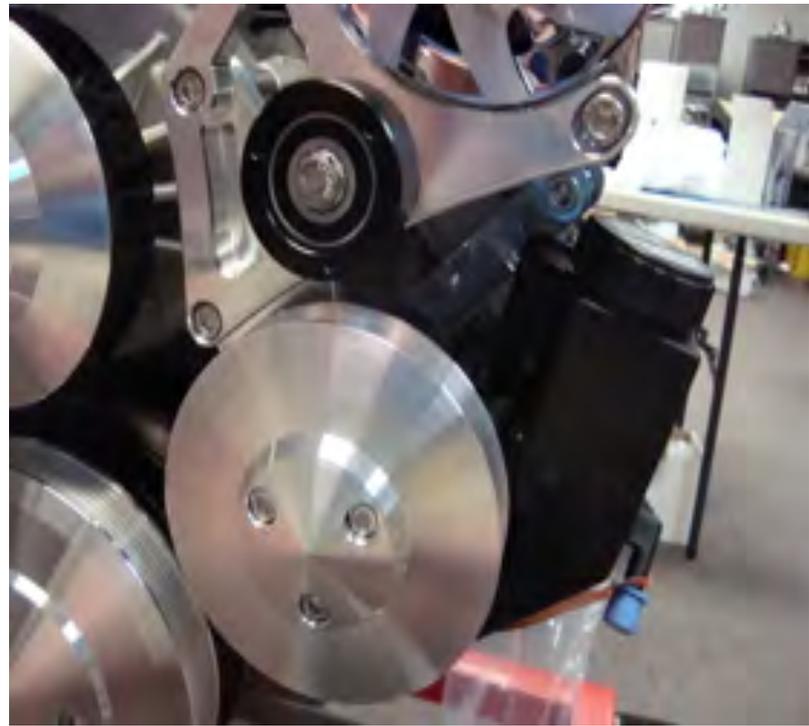
**Photo-14**

Mount the rear support bracket 20027-A to the outer head bolt on the passenger side with the (S561) M10 x 30 mm SHCS. Then install the (S158) 5/16" x 2-1/2" bolt through the rear counter sunk hole of the support bracket, through the rear compressor ear and secure with the (S616) 5/16" lock nut and (S660) 5/16 washer.



### Photo-15 Kit 20035 only

Install the power steering pulley 659-A using four (S183) 5/16-24 x 5/8" SHCS. **Note: The power steering hub is pressed on as a courtesy and is not guaranteed to be in correct alignment. You may have to adjust the hub by pulling it forward to the correct alignment. This can be achieved with a harmonic balancer puller or a 3 jaw puller with the pulley not installed. Using a straight edge off of the water pump flange is a good point to measure from when checking alignment.**



### Photo-16

Install the water pump pulley 6366-A with four (S186) 5/16" x 7/8" SHCS.

### PHOTO-17

For kit **20030** install the **71" Dayco (5060710)** belt, for kit **20035** install a **75-1/2" Dayco (5060755)** belt, for kit 20090 install the 71" Dayco (5060710) belt, and for kit 20095-08 install a 75.5 Dayco (5060755) belt by using the tensioner's 15mm bolt, pulling up **clockwise** on tensioner and route belt according to picture. Once belt is installed, add the tensioner pulley nose cover (307-A) using three (S025) 8-32" x 5/8" SCHS.

**\*NOTE:** Due to belt variations in manufacturing it may be necessary to get belts that are either larger or smaller than we recommend.

