

MARCH

Instructions



Note: These instructions are also for the listed kits in all optional finishes. Example 21100-06, 21100-07, 21100-08

21100, 21150, 21155



21110, 21160, 21165



21163, 21166, 21169



21610, 21615, 21620



Optional parts for kits



Part # 480 or 480-08
type II power steering
pump billet housing
cover



Part # 224 or
224-08 Water
pump cover



We carry a selection of
power steering remote
reservoirs to complete
your type II power
steering installation.



Part # 418 or
418-08 a/c
manifold wrap
around fittings



Stainless braided hose
packages for plumbing
your power steering
system



Part # P545
320amp alternator



Part # P306 power
steering psi regulator
kit. Typically required
for most rack & pinion
systems



We are specialists in matching
aftermarket air conditioning
systems such as Vintage Air, Old
Air Products and Nostalic Air with
our drive systems. Please contact us
for help in selecting a matching kit
for your application. 888-729-9070

Main front bracket assembly 21101,21111,21162,21611

- 1-.....main bracket
- 3-S339.....3/8 x 3" threaded stud
- 1-S340.....3/8 x 4" threaded stud
- 3-S777.....2.820" stainless spacer
- 1-S770.....1.900" stainless spacer
- 1-S277.....3/8-16 x 4 3/4" shcs
- 8-S248.....3/8-16 x 1" shcs
- 1-S550.....M8-1.25 x 20mm shcs
- 2-S553.....M8-1.25 x 35mm shcs
- 2-S622.....3/8 lock nut
- 2-MM100.....bolt bushing
- 1-S750.....heater hose barb

Alt rear support bracket assembly 21602

- 1-21602-Aalt support bracket
- 1-TP3-1.890.....alum. spacer 1.890" long
- 2-S675.....w/p gaskets

A/c rear support bracket assembly 21603

- 1-21603-Aa/c support bracket
- 1-TP3-.150.....spacer .150" long
- 1-S221.....5/16-18 x 1 3/4" hex head
- 1-S660.....5/16 washer
- 2-S675.....w/p gaskets

Tensioner assembly 21124 or 21119

- 1-21119-Atensioner bracket
- 1-759-A.....tensioner cover
- 1-P758.....tensioner
- 2-S022.....8-32 x 3/8" shcs
- 1-S163.....5/16-18 x 3.25" shcs
- 2-S660.....3/8 x 3/4 washer
- 1-S616.....5/16-18 lock nut

Rem p/s bracket assembly 21108

- 1-21108-Apower steering bracket
- 2-S551.....M8-1.25 x 25mm shcs

Saginaw p/s bracket assembly 21109-09

- 1-21109A-09.....front p/s bracket
- 1-21109B-09.....rear p/s bracket
- 1-20114C-09.....spacer block
- 2-S270.....3/8-16 x 3 1/2" shcs
- 2-S311.....3/8-16 x 3/4" hex head
- 1-S312.....3/8-16 x 1" hex head
- 1-TP3-.150.....spacer .150" long

Pulleys

- 1-6301-A.....crank pulley
- 3-S292.....3/8-24 x 1" shcs
- 1-6302-A.....water pump pulley
- 4-S183.....5/16-24 x 5/8" shcs
- 1-221-A.....alterator fan
- 1-206-A.....alternator pulley
- 1-306-A.....alt pulley cover
- 3-S028.....8-32 x 1" shcs
- 1-394-A.....a/c clutch cover
- 3-S124.....1/4-20 x 3/4 bh
- 3-S520.....M6-1.0 x 20mm bh
- 1-S685.....11/16 alt lock washer

Rem p/s kits

- 1-650-A.....remote p/s pulley
- 3-S144.....5/16-18 x 7/8" shcs

Saginaw p/s kits

- 1-535-A.....keyway p/s pulley
- 1-302-A.....p/s pulley nose cover
- 3-S022.....8-32 x 1" SHCS

Accessories

- 1-P2112.....cast alum water pump
- 1-P2412-06..chrome alum 7176 compressor
- 1-P2572-06..chrome alum alternator
- 1-417.....A/c manifold

Rem p/s kits

- 1-P2313.....cast alum type 2 rem. p/s pump

Saginaw p/s kits

- 1- P2304....chrome Saginaw keyed p/s pump

Revolver kits sub in pulleys 6307 w/p, 399 a/c, 231 fan.

Sport Track kits sub in pulleys 6308 w/p, 398 a/c, 225 fan, 652 rem p/s, 541 Saginaw p/s.

Note: We do NOT include belts with kits. We do recommend Dayco, Goodyear or Continental brands only. These are available through most local auto parts stores.



Step-1

Make sure all surfaces are clean. Install one (S340) 3/8 x 4" threaded stud in the lower passenger side hole. In the remaining three holes install three (S339) 3/8 x 3" threaded studs. When installed the 4" stud should be 3-5/16" from the face of the block and the three 3" studs should be 2-3/8" from the face of the block.

Step-2

Install the (21602-A) alternator rear support bracket on the drivers side and the (21603-A) rear a/c support on the passenger side. Use four (S675) gaskets, two in between the brackets and the block surface and two in between the face of the brackets and the water pump.



Step-3

Slide (P2112) aluminum water pump over threaded studs and install (S750) barbed heater hose fitting in to water pump.

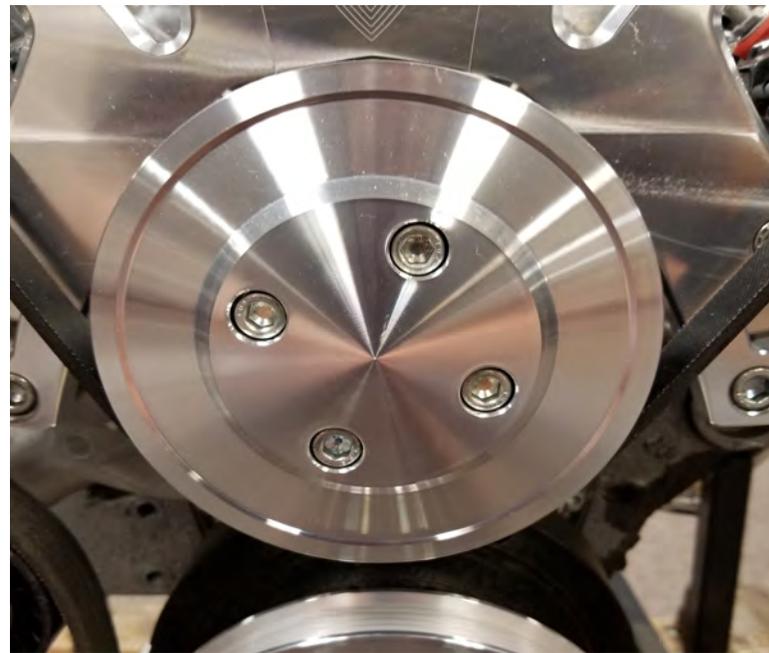


Step-4

Install (S770) 1.900" long stainless spacer onto the bottom passenger side stud. Then install three (S777) 2.820" long stainless spacers to the remaining studs as shown. All four spacers should extend from the block evenly.

Step-5

Install main bracket (21101-A),(21111-A), (21162-A) or (21611-A) to the four threaded spacers with four (S248) 3/8-16 x 1" SCHS.



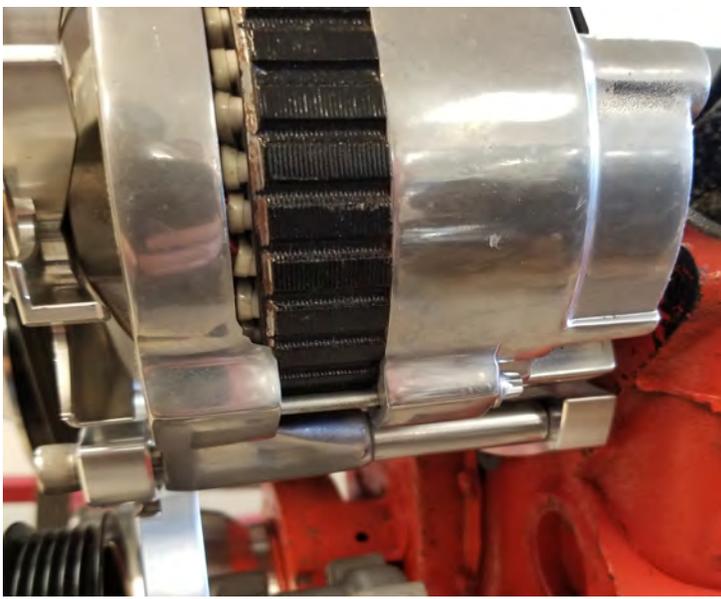
Step-6

Install (6302-A), (6307-A) or (6308-A) water pump pulley to water pump with four (S183) 5/16-24 x 5/8" SHCS

Step-7

Install (6301-A) crank pulley with three (S292) 3/8-24 x 1" SCHC.





Step-8

Install the (P2572-06) alternator in between the main bracket and rear support bracket on the driver side. Use a (TP3-1.890) spacer behind the lower alternator ear and the rear bracket. Then secure with a (S277) 3/8-16 x 4-3/4" SHCS.

Step-9

Secure alternator upper ear to main bracket slot with a (MM100-A) bolt bushing and a (S553) M8-1.25 x 35mm SHCS as shown. Now install alt fan (221-A), (231-A) or (225-A) and pulley (206-A) and secure with (S685)) lock washer and nut. Use impact to install to 70 lbs. Now install cover (306-A) with three (S028) 8-32 x 1" SHCS.



Step-10

To mount the (P2412-06) a/c compressor, Use one (S550)M8-1.25 x 25mm SHCS through the front of the lower hole on the main bracket. On the top ear use a (MM100-A) bolt bushing and a (S553) M8-1.25 x 35mm SHCS through the slot on the main bracket. Now install clutch cover (394-A), (399-A) or (398-A) with either three (S520) M6-1.0 x 20mm or three (S124) 1/4-20 x 3/4 button head bolts. These are to be installed a 1/4 turn past finger tight.

Step-11

The rear mounting ear will use a (S221) 5/16-18 x 1 3/4" HH through the front of the rear compressor ear with a (S660) 5/16 washer and thread in to rear support bracket. Use a TP3-.150 spacer between rear ear of compressor and bracket if there is a gap.





Step-12

Install (21124-A) or (21119-A) tensioner bracket to main bracket on passenger side with two (S248) 3/8-16 x 1" SHCS.



Step-13

Install (P758) pulley tensioner to tensioner bracket with one (S163) 5/16-18 x 3.25" SHCS, two (S660) 5/16 washers and one (S616) 5/16-18 lock nut. Install tensioner cover (759-A) with two (S022) 8-32 x 3/8" SHCS after belt is on.

Note: There are 3 positions the tensioner can be installed. Install in the middle location.

The additional positions and slotted adjustments on the main bracket are to aid in correcting variations in belt lengths or stretched belts. This will also help with custom applications.



For kits with type 2 p/s

Step-14

Install (P2313) power steering pump to backside of (21108-A) power steering bracket with two (S551) M8-1.25 x 25mm SHCS.



Step-15

Install power steering bracket to main bracket with two (S248) 3/8-16 x 1" SHCS.





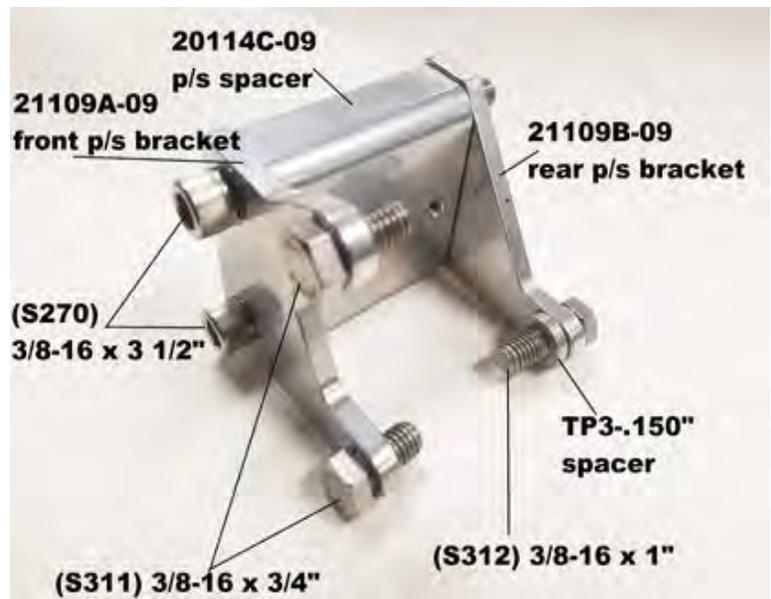
Step-16

Install (650-A) or (652-A) power steering pulley to pump with three (S144) 5/16-18 x 7/8" SHCS

For kits with Saginaw power steering

Step-17

First **Remove stud** from back of (P2304) power steering pump.



Step-18

Install (21109A-09) to front of pump as shown with two (S311) 3/8-16 x 3/4" hex heads.





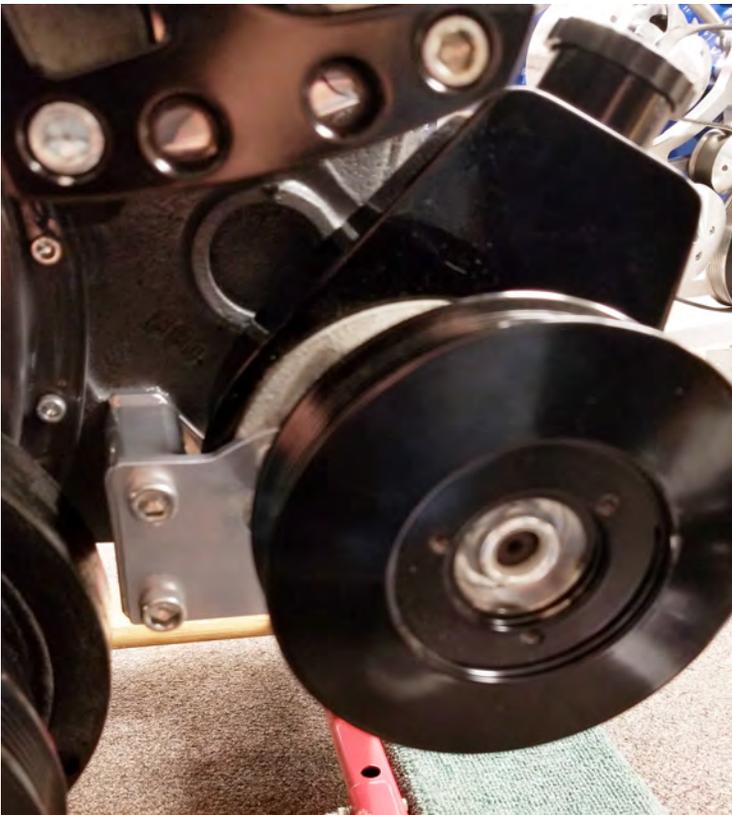
Step-19

Install (21109B-09) rear support bracket to backside of pump where stud was with a (S312) 3/8-16 x 1" hex head. Use (TP3-.150") spacer in between pump and bracket.



Step-21

Install pump and bracket assembly to the lower driver side of the engine block with two (S270) 3/8-16 x 3 1/2" SHCS and (20114C-09) in between the front and rear brackets as shown in photo.

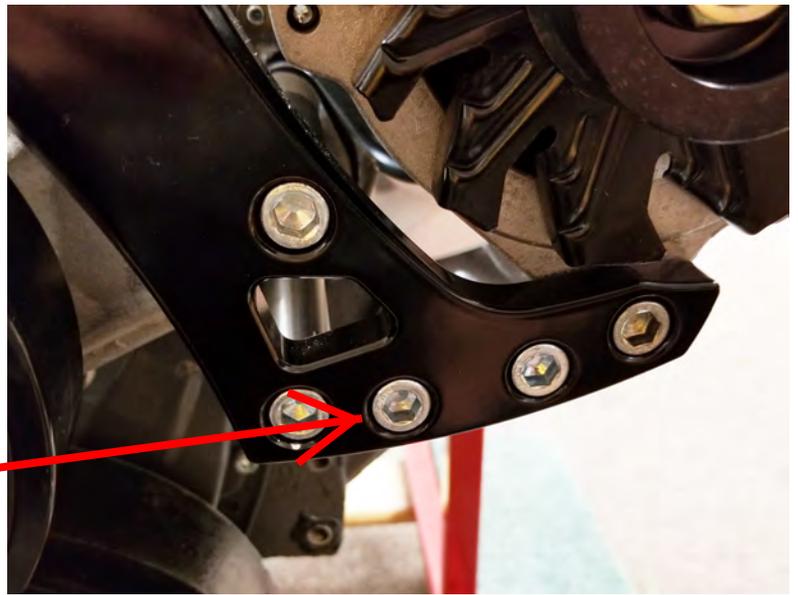


Step-22

Install (535-A) or (541-A) to power steering pump and retain with lock nut. **Make sure woodruff key is straight on shaft of pump and does not slide up in rear upon install.** Now install pulley nose cover (302-A) with three (S022) 8-32 x 3/8" SHCS.

Step-23

For kits **not** using remote power steering. Install two (S248) 3/8-16 x 1" SHCS in lower driver side holes of main bracket and secure with two (S622) 3/8-16 lock nuts.



Step-24

If installing air conditioning at this time, Remove block off plate from compressor and then install (417A-04) with two (S550) M8-1.25 x 20mm SHCS

Step-25

Installing belts. We recommend **Dayco** brand belts. To install belt make sure alternator and a/c compressor are all the way inward on the slots of the main bracket. Use a 1/2" drive to pull and release the tensioner. You can adjust the position of the components in the slots as well as adjust the position of the tensioner if needed to aid in custom applications or if a belt is too loose. See pictures below for routing and belt sizes.



Kits without p/s use a 60.5" 6 rib belt (Dayco 5060605)



Kits with Type 2 p/s use a 62.5" 6 rib belt (Dayco 5060625)



Kits with Saginaw p/s use a 64" 6 rib belt (Dayco 5060640)