



Highly Styled, Low Cost Serpentine Drive

Installation Instructions

*Chevy Small Block,
Early Model Corvette*

Kit #21170



Included Parts List

Main Front Bracket P/N 21171

- 1 21171-A.....Main Front Bracket Body
- 1 RA-1.625.....Rod Assembly 1.625" Lg
- 1 TP3-.850.....Tube Spacer $\frac{3}{8}$ " Id x .850" Lg
- 1 AC3-2.150...Alum Bushing $\frac{3}{8}$ " Id x 2.150" Lg
- 2 744-AIdler Pulley Body
- 1 744-AIdler Pulley Body With 1.150" Bushing
- 1 311-AIdler Pulley Cap (with hole)
- 2 302-AIdler Pulley Covers
- 2 MM100.....Bolt Adjustment Sleeves
- 9 S022..... $\frac{8}{32}$ x $\frac{3}{8}$ " SHCS
- 2 S244..... $\frac{3}{8}$ " x $\frac{3}{4}$ " SHCS
- 1 S256..... $\frac{3}{8}$ " x 2" SHCS
- 1 S278..... $\frac{3}{8}$ " x 5" SHCS
- 1 S280..... $\frac{3}{8}$ " x 5 $\frac{1}{2}$ " SHCS
- 2 S323..... $\frac{3}{8}$ " x 2" Hex Hd Bolt
- 3 S339..... $\frac{3}{8}$ " x 3" Threaded Stud
- 1 S550.....M8 x 1.25 x 20mm Metric SHCS
- 2 S553.....M8 x 1.25 x 35mm Metric SHCS
- 2 S666..... $\frac{3}{8}$ " Id Flat Washer
- 1 S768..... $\frac{3}{4}$ " Dia x 1.850" Lg Threaded Spacer
- 2 S785..... $\frac{3}{4}$ " Dia x 3" Lg Threaded Spacer

Alternator Rear Support Brk P/N 21112

- 1 21112-A.....Alternator Rear Support Bracket Body
- 1 S453..... $\frac{5}{8}$ " x .850 Adjustment Screw
- 2 S675.....Paper Gaskets

A/C Rear Support Brk P/N 21113

- 1 21113-A.....A/C Rear Support Bracket Body
- 1 TP3-.400.....Tube Spacer $\frac{3}{8}$ " Id x .400" Lg
- 1 S216..... $\frac{5}{16}$ " x 2" Hex Hd Bolt
- 2 S675.....Paper Gaskets

Power Steering Bracket P/N 21174

- 1 21174-APower Steering Bracket Body
- 1 21176-AAdjustment Bracket Body
- 1 S219..... $\frac{5}{16}$ " x 2 $\frac{3}{4}$ " Hex Hd Bolt
- 2 S250..... $\frac{3}{8}$ " x 1 $\frac{1}{4}$ " SHCS
- 1 S324..... $\frac{3}{8}$ " x 2 $\frac{1}{4}$ " Hex Hd Bolt
- 3 S550.....M8 x 1.25 x 20mm Metric SHCS
- 2 S667..... $\frac{5}{8}$ " O.D. x $\frac{3}{8}$ " I.D. Washers

Belt Adjustmet Tool P/N 21106

- 1 MM101RH Rod End
- 1 MM102LH Rod End
- 1 MM10312" Threaded Rod

Pulley Kit P/N 6320-208

- 1 7671-ACrank Pulley Body
- 1 6317-AWater Pump Pulley Body
- 1 359-ACrank Pulley Adaptor
- 1 208-AAlt Pulley Body
- 1 221-AAlt Fan
- 1 307-AAlt Pulley Cap
- 1 333-AWater Pump Pulley Cover
- 1 394-AA/C Pulley Cover
- 1 600-AP/S Pulley Hub
- 1 650-AP/S Pulley Body
- 3 S028..... $\frac{8}{32}$ x 1" SHCS
- 4 S186..... $\frac{5}{16}$ " x $\frac{7}{8}$ " SHCS
- 3 S144..... $\frac{5}{16}$ " x $\frac{3}{4}$ " SHCS
- 3 S296..... $\frac{3}{8}$ " x 1 $\frac{1}{2}$ " Fine Thread SHCS
- 3 S520.....M6 x 10 x 20mm Button Hd Bolt

Accessories

- 1 P204Water Pump Standard Rotation
- 1 P310Power Steering Pump Remote
- 1 P412Sanden A/C Compressor
- 1 P417A/C Line Kit
- 1 P572Alternator

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

41.5" and 50" 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 (3) $\frac{3}{8}$ x 3" Studs (S339) into the block leaving the lower passenger side block hole without a stud as shown .

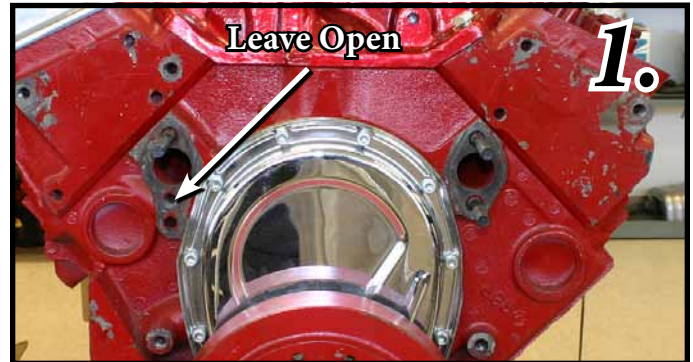


Photo 2 Install the (2) Rear Support Brackets (21112-A) drivers side and (21113-A) passenger side. Use the (4) provided Paper Gaskets (S675) and a small amount of silicon sealant installed on the front and rear of both brackets. In the Alternator Rear Support Install the $\frac{5}{8}$ "-18 O.D. Ajustment Screw (S453) into the bracket for later ajustment.

Photo 3 Install the provided Water Pump (P204). Sliding it over the (3) studs and then use the (2) 3" Stainless Threaded Spacers (S785) in the two upper mounting holes of the water pump. (Note **Optional Polished Water Pump Shown**)



Photo 4 In the The lower drivers side water pump hole install the 1.850 long Threaded Spacer (S768) As Shown. Onto the 3" Stud.

Photo 5 Installing the main plate (21171-A). Use (2) $\frac{3}{8} \times \frac{3}{4}$ " SHCS (S244) to mount the main plate to the (2) threaded studs. (do not tighten at this time)

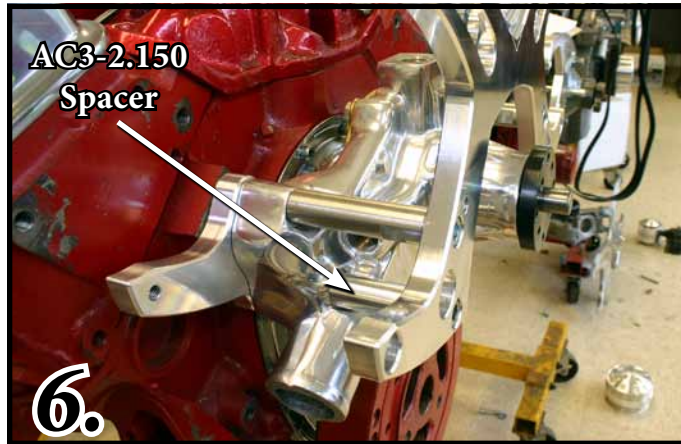


Photo 7 In the lower Drivers side Water Pump hole Install the Idler (744-A) with the cap (311-A) (cap with hole thru center) between the main front plate and the 1.850 Spacer as shown Note the cap will be facing the block, use a $\frac{3}{8} \times 2$ " SHCS (S256) to install.



Photo 9 Install Alternator fan (221-A) Alternator Pulley (208-A) to the alternator shaft using the nut that comes with the alternator.

The Alternator (P572) is installed using a $\frac{3}{8} \times 5$ " SHCS (S278) thru the front of the main plate, behind the alternator lower mount place a TP3-.850 Spacer, then the RA-1.625 Rod as shown. Adjust the (S453) Adjustment Screw to take up any play between the rod end and the rear Alternator Support.



Photo 6 In the lower passenger side water pump hole install Aluminum Spacer (AC3-2.150) Between the water pump and the rear of the Main Plate. Apply thread sealant to the threads of (1) $\frac{3}{8} \times 5\frac{1}{2}$ " SHCS (S280) and install thru the front of the main plate, the spacer and into the water pump.

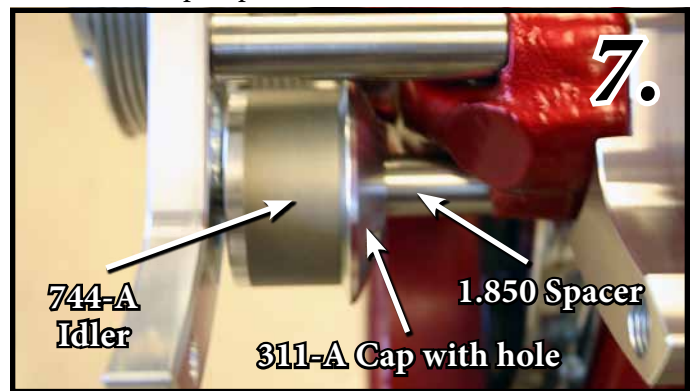


Photo 8 Installing the A/C Compressor Unit (P412) thru the front of the main bracket use a 8 mm x 20 mm SHCS (S550) in the lower hole of the main bracket making sure the A/C lines are pointing up. Thru the rear of the A/C Unit install a $\frac{5}{16} \times 2$ " (S216) hex bolt and use a $\frac{3}{8} \times .400$ (TP3-.400) Spacer between the Rear Support Bracket and the rear A/C ear as shown into the rear support bracket. Place the compressor clutch cover (394-A) onto the compressor clutch and align. Thread the three (S520) M6 - 10 x 20mm Button Head Bolt through the cover and into the clutch and tighten. **Caution - Do not over-tighten!**

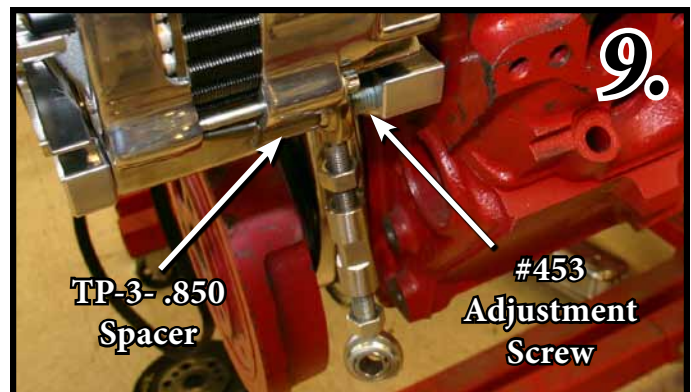




Photo 10 Install (S553) M8 x 1.25 x 35 mm bolt into (MM100) bushings as shown. Install one each into Alternator, and A/C units top adjustment slots. Leave loose at this time, these will be use with the belt adjustment tool later.

Photo 11 This is a front view Power Steering Pump (P310), Mounting Bracket (21174-A) and Adjustment Bracket (21176-A). *(Note: Shown without pressed on hub installed, this will come pre-installed)* Use two M8 x 20 mm SHCS (S550) to attach Adjustment Bracket to front of pump. Then attach pump to mounting bracket using (1) $\frac{5}{16}$ -18 x $2\frac{3}{4}$ " Hex Head Bolt (S219). **Do not fully tighten at this point this will be done after belt installation.**

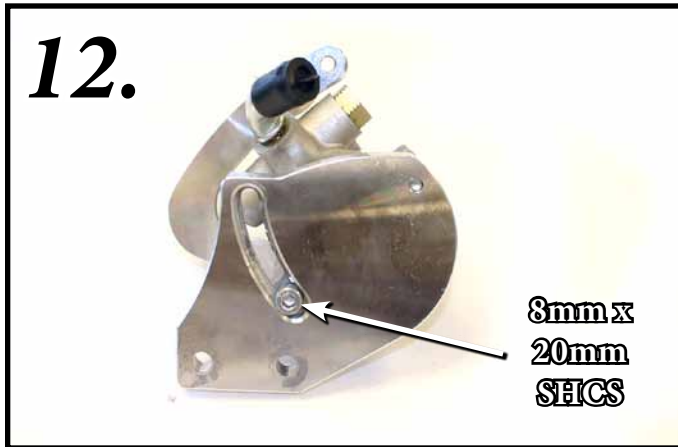
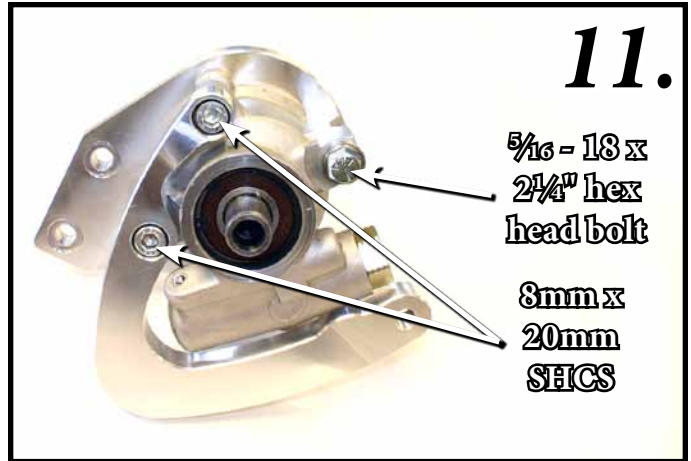


Photo 12 From rear install M8 x 20 mm SHCS in adjustment slot as shown do not fully tighten at this point this will be done after belt installation.



Photo 13 Install the Power Steering Pump and Bracket to the engine block using (2) $\frac{3}{8}$ x $1\frac{1}{4}$ " SHCS (S250) and (2) $\frac{5}{8}$ " O.D. x $\frac{3}{8}$ " I.D. washers. Attachment of the rod end to Adjustment Bracket will be done later when belt is installed (see Photo 18)

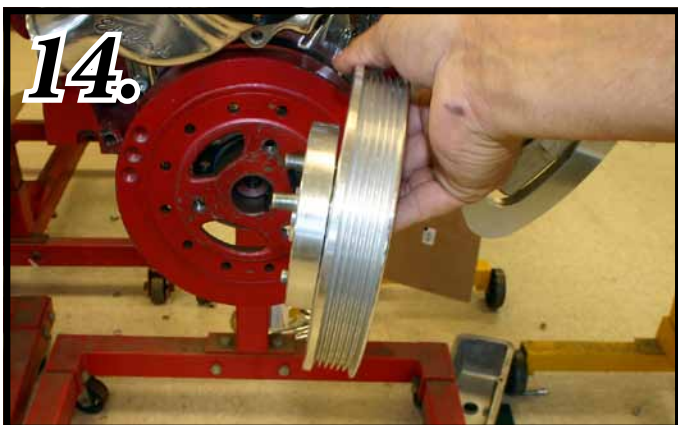


Photo 14 Apply Loc-Tite to the threads of the three $\frac{3}{8}$ x $1\frac{1}{2}$ " SHCS (S296) and mount the Crank Pulley 7671-A with the Crank Pulley Adaptor (359-A) between vibration dampner and pulley tighen firmly (50 ft/lbs)

Photo 15 Apply Loc-Tite to the threads of the three 5/16 x 7/8" SHCS (S144) and mount Power Steering Pulley (650-A) to Hub (600-A) then tighten firmly (28 ft/lbs) Place the Water Pump Pulley (6317-A) and Pulley Cover (333-A) to the Water Pump and thread the (4) 5/16 x 7/8" SHCS (S186) through pulley and into Water Pump pulley flange, tighten firmly (28 ft/lbs.) Install the 41 1/2" belt to the rear grooves of the water pump pulley, crank pulley and power steering pulley.

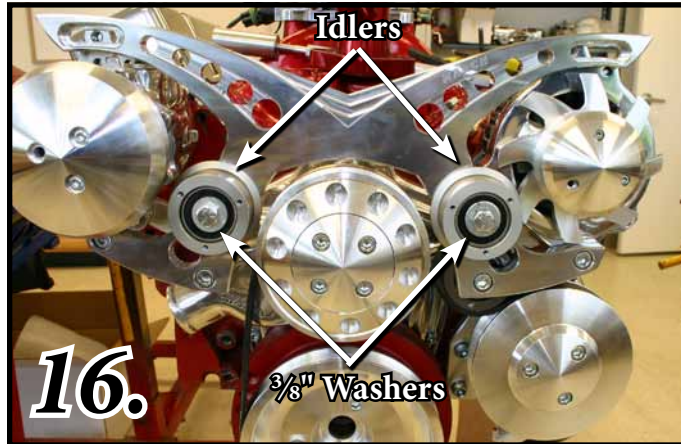


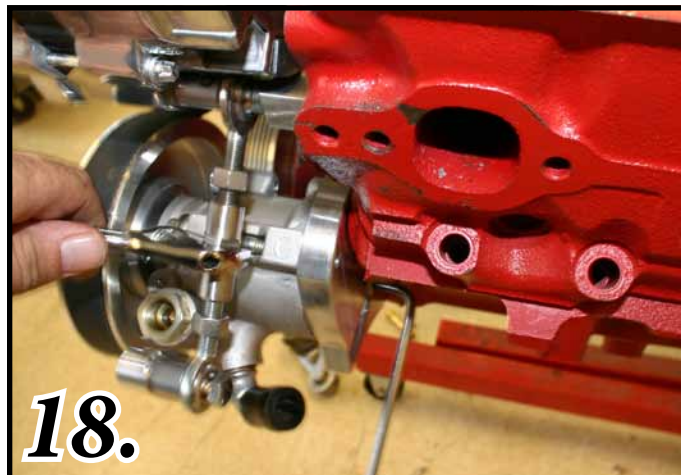
Photo 16 Mount the (2) Idlers (744-A) to the main bracket with (2) 3/8 x 2" Hex Bolts (S323) and (2) 3/8" Washers (S666).



Photo 17 Mount the 50" Belt to the front serp pulleys as shown. Slip the supplied March Adjustment Tool (21106) over the two (MM100) bushings and use a wrench to turn the adjustment tool outward to tighten the serpentine belt to 100 ft. lbs. Be sure to have lower alternator and a/c compressor bolts snug but not tight to allow proper adjustment of belt. Before removing adjustment tool tighten lower alternator and A/C compressor bolts and use the holes in the adjustment tool to tighten both top 8mm socket head cap screws when correct belt tension has been achieved. Remove the adjustment tool and keep for future use. Attach idler pulley caps (302-A) with (3) 8/32 x 3/8" SHCS (S022). Install Alternator Pulley Cover (307-A) with (3) (S028) SHCS.

Photo 18 A 5/16 x 2 1/4" hex head bolt (S324) should be installed thru the adjustment rod end then the (AC3-1.250) Aluminum Bushing and threaded into Adjustment Bracket. Be careful to have a few turns of the rod ends equally into the spacer. The 8mm SHCS in the slot should be slightly loose during belt adjustment. Tighten adjustment rod pulling belt to 75 to 80 ft/lbs. then tighten rear 8mm SHCS and the 5/16 x 2 3/4" hex head bolt in pump.

Check and tighten all bracket bolts, 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.*

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.

DISCLAIMER OF OTHER WARRANTIES

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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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
30% 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.

Form fields for RGA#, CT#, Issued by, Date, Purchaser's Name, Phone, Address, Purchased Directly Through, Invoice#, Product ID, Invoice Date, Reason.

** MOUNTED PRODUCTS ARE NONREFUNDABLE **