



**25154 & 25156**

## **PARTS LIST**

### **Alternator bracket 25122**

1-25122-A.....alternator main bracket  
1-25122-B.....rear alternator support  
2-S338.....3/8-16 x 2 1/2" threaded studs  
2-S777.....2.820 stainless spacer  
1-S282.....3/8-16 x 6 " shcs  
2-S244.....3/8-16 x 3/4 shcs  
1-TP3.3.250.....3-1/4" spacer tube  
1-TP3-.600.....600 spacer tube  
1-S252.....3/8 x 1-1/2" shcs  
1-S144.....5/16 x 7/8 shcs  
1-P758.....belt tensioner  
1-759-A.....tensioner cover  
2-S022.....8-32 x 3/8" shcs  
2-S660.....5/16" washer  
1-S616.....5/16" lock nut  
1-S160.....5/16-18 x 2 3/4" shcs

### **Power steering bracket 25164**

1-25164-A.....front main bracket  
1-25164-B.....rear support bracket  
2-S775.....3/4 x 2.720" stainless spacers  
2-S338.....3/8-16 x 2-1/2" threaded studs  
1-TP3-.150.....150" spacer tube  
1-TP3-.400.....400" spacer tube  
2-S250.....3/8-16 x 1-1/4" shcs  
2-S244.....3/8-16 x 3/4" shcs  
1-S313.....3/8-16 x 1-1/4" hex bolt  
1-S666.....3/8" washer  
1-TP3-.700.....700" tube spacer  
1-S252.....3/8-16 x 1 1/2" shcs

### **Pulley kit 25154-206**

1-6371-A.....crank pulley  
1-2012-A.....water pump pulley  
1-221-A.....alternator fan  
1-206-A.....alternator pulley  
1-S685.....lock washer  
1-306-A.....alternator pulley cap  
1-319-A.....water pump pulley cap  
3-S292.....3/8-24 x 1" shcs  
4-S550.....M8-1.25 x 20mm shcs  
3-S028.....8/32 x 1" shcs  
1-360-A.....p/s nose cover  
3-S106.....1/4-20 x 1 1/4" shcs

1-623-A.....keyed p/s pulley **kit 25154**

or

1-624-A.....press fit p/s pulley **kit 25156**

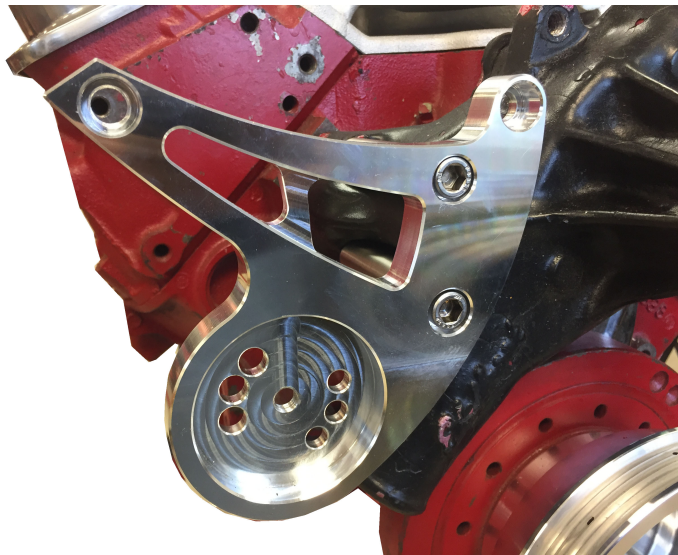
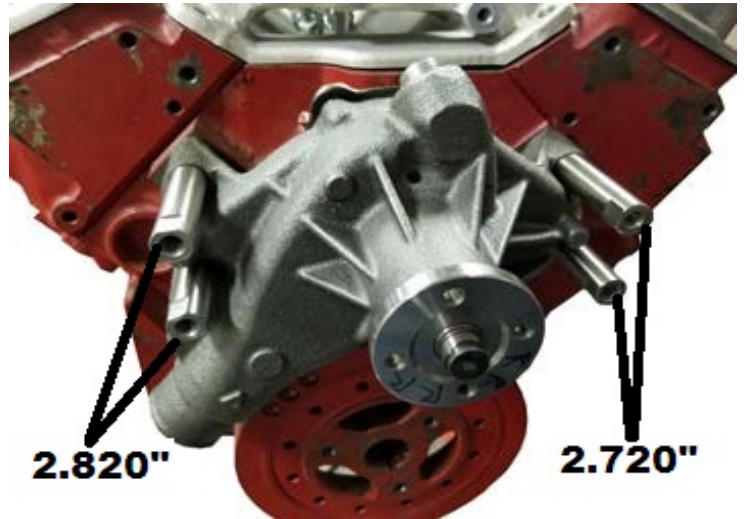


### Step 1

Install four of (S338) 3/8-16 x 2 1/2" studs into the engine block water pump mounting holes. Now install water pump gaskets.

### Step 2

Slide the water pump (1988 to 1995 reverse rotation long water pump) over the four studs. On the passenger side install two of (S777) 3/4" o.d. x 2.820" long stainless spacers. On the driver side install two (S775) 3/4" o.d. x 2.720" stainless spacers.



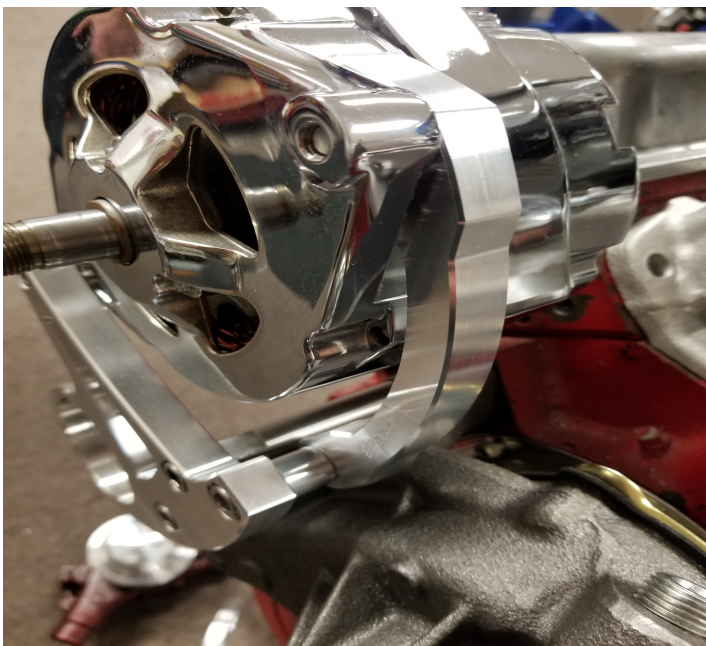
### Step 3

Install the (25122-A) alternator bracket to the two stainless spacers with two (S244) 3/8-16 x 3/4" shcs.

### Step 4

Mount GM 10si alternator (6.6" center to center) to the outer head bolt hole with a (S282) 3/8-16 x 6" shcs and a (TP3-3.250) spacer in between alternator and cylinder head.



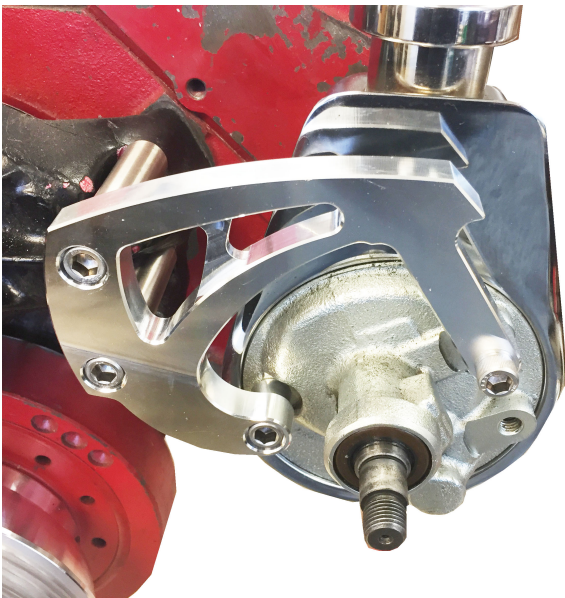
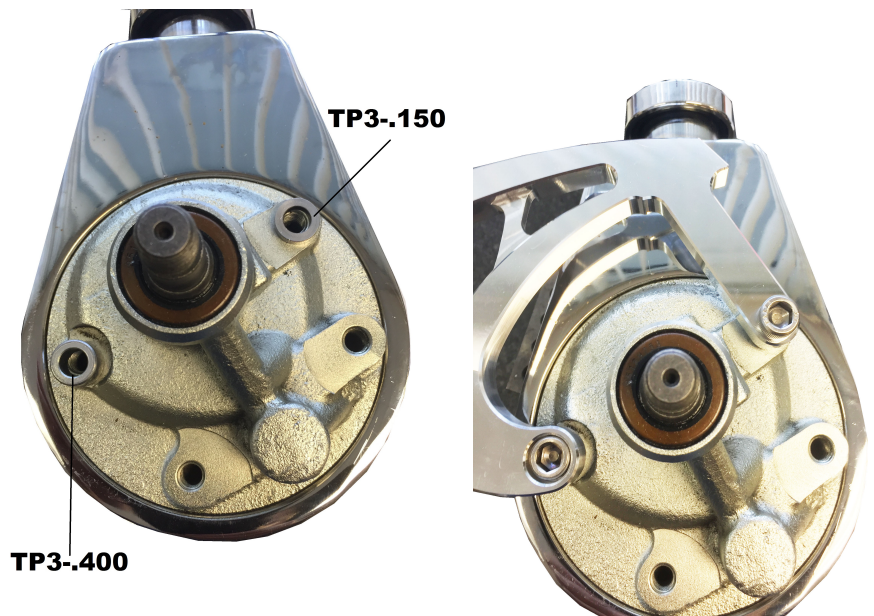


### Step 5

Install (25122-B) rear alternator support bracket to the back side of the alternator using a (S144) 5/16-18 x 7/8" shcs through the countersink on bracket. Attach the other end to (25112-A) bracket with a (TP3-.600) spacer between the two brackets and secure with a (S252) 3/8 x 1 1/2" SHCS As shown.

### Step 6

Place a (TP3-.150) spacer to the upper Right mounting hole of the power steering pump . The Left mounting hole use a (TP3-.400) spacer. Now secure (25164-A) power steering bracket to pump with two (S250) 3/8-16 x 1 1/4" shcs.

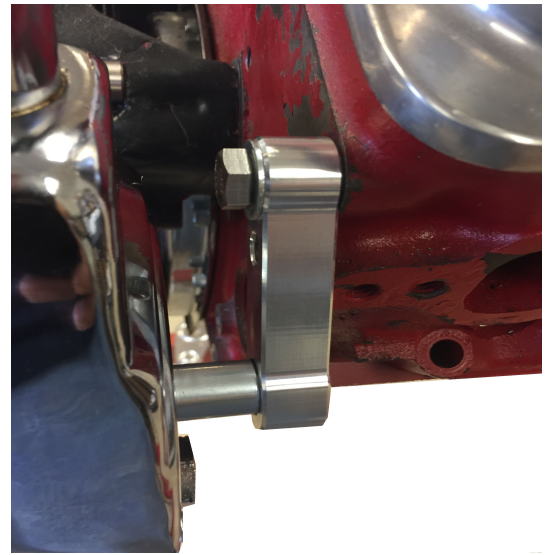


### Step 7

Mount bracket and pump to the stainless spacers on drivers side of water pump with two (S244) 3/8-16 x 3/4" shcs.

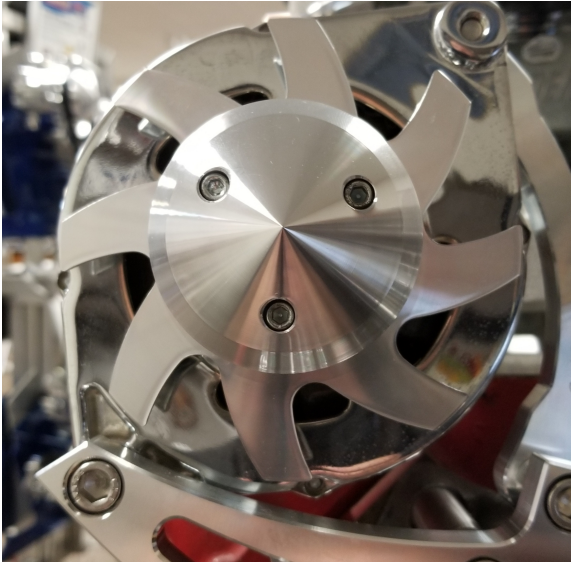
### Step 8

Attach the slotted side of (25164-B) power steering rear support to the outer head bolt using a (S666) 3/8 washer with a (S313) 3/8-16 x 1-1/4" hex bolt. Now attach the bracket to the back of power steering pump using a TP3-.700 spacer in between the pump and bracket and secure with a (S252) 3/8-16 x 1 1/2" shcs. Head of bolt should be in countersink of bracket. **Note: Most pumps will have a stud that will need to be removed for rear support to install.**



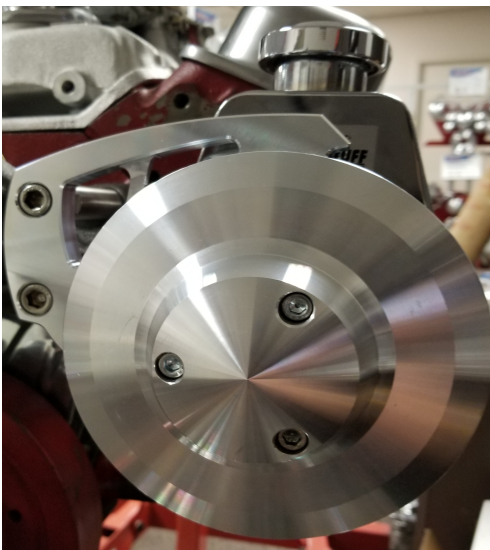
### Step 9

Install (221-A) alternator fan and (206-A) alternator pulley on to alternator and secure with the (S685) lock washer and nut from alternator. Use impact and install to 70 lbs. Now install (306-A) alternator cap with three (S028) 8-32 x 1" shcs.



### Step 10

Install (2012-A) water pump pulley with (319-A) water pump pulley nose cover using four (S550) M8-1.25 x 20mm shcs. Now install (6371-A) crank pulley using three (S292) 3/8-24 x 1" shcs.

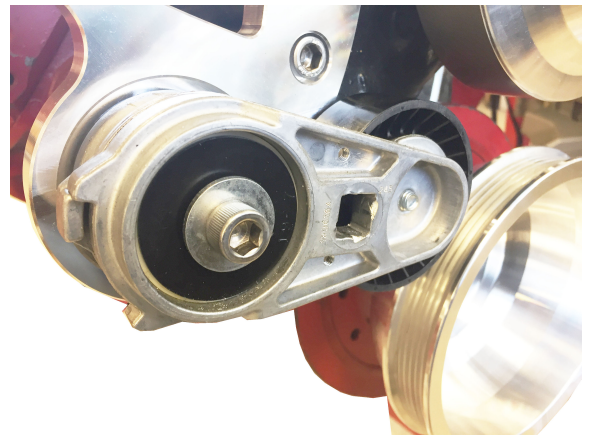


### Step 11

To install power steering pulley. Kit 25154 includes (623-A) keyway pulley which is installed by lining up pulley with key on shaft and then slide pulley on. Retain pulley with nut. **Note: Make sure key does not move in shaft when installing pulley as this may cause pulley failure.** Kit 25156 includes (624-A) this pulley is installed with a power steering pulley install press tool. Press pulley on until correct alignment is achieved. Now install (360-A) pulley cover with three (S106) 1/4-20 x 1 1/4" shcs.

## Step 12

Install (P758) spring tensioner to alternator bracket pocket. Use two (S660) 5/16 washers, (S160) 5/16-18 x 2 3/4" shcs and a (S616) 5/16 lock nut. One washer on the front of tensioner and one on the rear of bracket. There are 3 positions the tensioner can be installed in. This is to aid with various belt lengths and custom configurations. We recommend the tensioner first installed in the bottom position where the pulley is farthest away from the crank pulley or the 5 o'clock position.



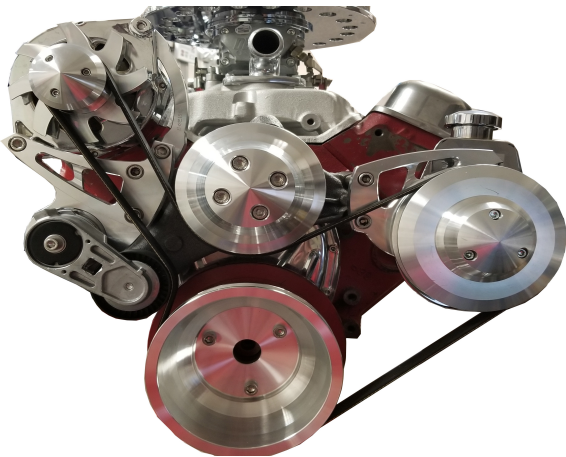
## Recommended belt routing



## Step 13

Install a 75" 6 rib belt (tensioner installed in bottom position) using a 1/2" ratchet in the square of the tensioner and rotate clockwise to install belt. Route belt as shown. **Note we recommend Dayco 5060750 or Goodyear / Continental belts 4060750.** Once belt is on then install (759-A) tensioner cover plate with two (S022) 8-32 x 3/8" shcs.

## Alternative belt routing

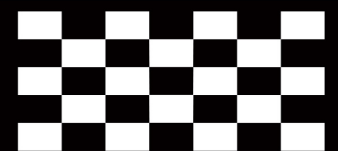


## Alternative belt routing

With tensioner installed in the bottom position use a 58" 6 rib belt (5060580). Tensioner in middle position use 58.5 or 59" 6 rib belt.

Questions contact our technical support at 1-800-729-9070

# MARCH



PERFORMANCE PULLEYS & BRACKETS