



***Ford 460 Alternator, Air Conditioning & Power Steering
Ultra Serpentine Kit***

Kit # 30260 Keyway Power Steering

Kit # 30265 Press Fit Power Steering

PARTS LIST

Alternator Bracket # 30200

1-30201-A.....Alternator Main Bracket
2-S174.....5/16" x 5-1/2" SHCS
2-S248.....3/8" x 1" SHCS
1-S280.....3/8" x 5-1/2" SHCS
1-S374.....7/16" x 5-1/2" SHCS
1-S667.....3/8" Flat Washer
1-BS3-3.000.....Alternator Bushing Spacer
2-TP3-1.680.....3/8" x 1.680 Tube Spacer
1-TP7-1.890.....7/16" x 1.890 Tube Spacer
1-RA-4.375.....4.375 Adjustment Rod

Power Steering Bracket # 30210

1-30211-A.....Power Steering Main Bracket
1-30211-B.....Power Steering Rear Support
1-S248.....3/8" x 1" SHCS
1-S250.....3/8 x 1-1/4" SHCS
1-S254.....3/8" x 1-3/4" SHCS
1-S256.....3/8" x 2" SHCS
1-S312.....3/8" x 1" Hex Head
2-S356.....7/16" x 2-1/4" SHCS
1-S664.....3/8" x 1" Diameter Flat Washer
5-S666.....3/8" x 3/8" Diameter Flat Washer
1-AC3-.650.....3/8" x .650 Aluminum Spacer
1-AC3-.725.....3/8" x .725 Aluminum Spacer
1-AC3-.875.....3/8" x .875 Aluminum Spacer
1-AC3-1.000.....3/8" x 1.000 Aluminum Spacer
1-TP3-.300.....3/8" x .300 Tube Spacer
1-TP3-.800.....3/8" x .800 Tube Spacer
2-TP7-1.625.....7/16" x 1.625 Tube Spacer

***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 product's 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.

Air Conditioning Bracket # 30220

1-30221-A.....Air Conditioning Main Bracket
1-30221-B.....Air Conditioning Rear Support
1-740-A.....Idler Pulley
1-302-A.....Idler Pulley Cover
3-S022.....8-32 x 3/8" SHCS
2-S172.....5/16" x 5" SHCS
1-S248.....3/8" x 1" SHCS
1-S250.....3/8" x 1-1/4" SHCS
2-S252.....3/8" x 1-1/2" SHCS
1-S254.....3/8" x 1-3/4" SHCS
1-S256.....3/8" x 2" SHCS
1-S329.....3/8" x 3" Hex Head
1-S622.....3/8" Lock Nut
1-S666.....3/8" Flat Washer
1-AC3-1.250.....3/8" x 1.250 Aluminum Spacer
1-TP3-.400.....3/8" x .400 Tube Spacer
1-TP3-.800.....3/8" x .800 Tube Spacer
2-TP5-.800.....5/16" x .800 Tube Spacer
1-RA-8.000.....8.000 Adjustment Rod

Pulley Kit # 1880-208

1-1874-A.....Crank Pulley
1-1873-A.....Water Pump Pulley
1-620-A.....Power Steering Pulley (Press Fit)
1-535-A.....Power Steering Pulley (Keyway)
1-395-A.....Air Conditioning Clutch Cover
1-313-A.....Water Pump Pulley Cap
1-307-A.....Alternator Pulley Cap
1-302-A.....Power Steering Pulley Cap
1-221-A.....Alternator Fan
1-208-A.....Alternator Pulley
3-S022.....8-32 x 3/8" SHCS
3-S028.....8-32 x 1" SHCS
3-S124.....1/4" x 3/4" Button Head
4-S186.....5/16" x 7/8" SHCS
4-S248.....3/8" x 1" SHCS
1-S685.....11/16" Lock Washer



Tech Support:
1-888-729-9070
info@marchperformance.com
www.marchperformance.com

Photo 1

Mount the crank pulley (1874-A) to the balancer using four 3/8" x 1" SHCS (S248) and tighten down. **NOTE:** If crank pulley is not going over balancer pilot shaft easily, it maybe be necessary to use light grit Scotch Bright to remove some powdercoat to help. It also helps to clean pilot shaft of balancer with sandpaper of any excess paint or grime to help.

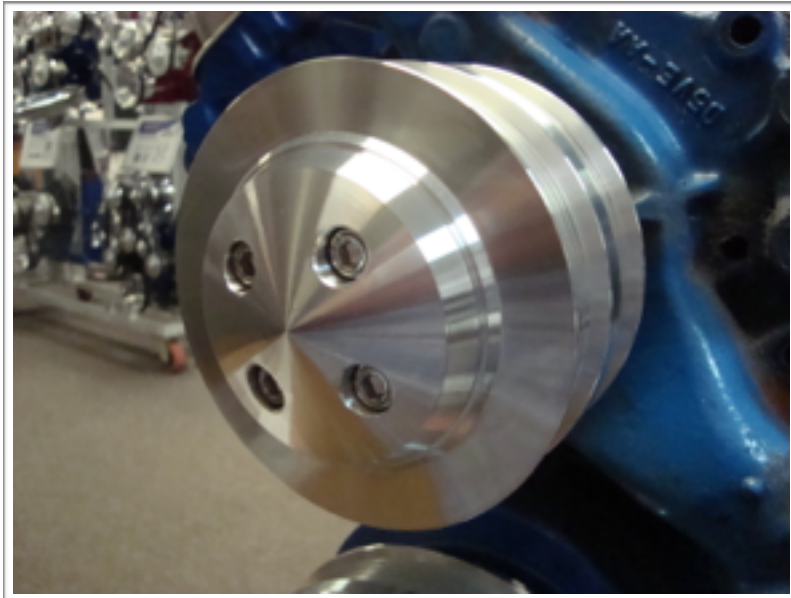
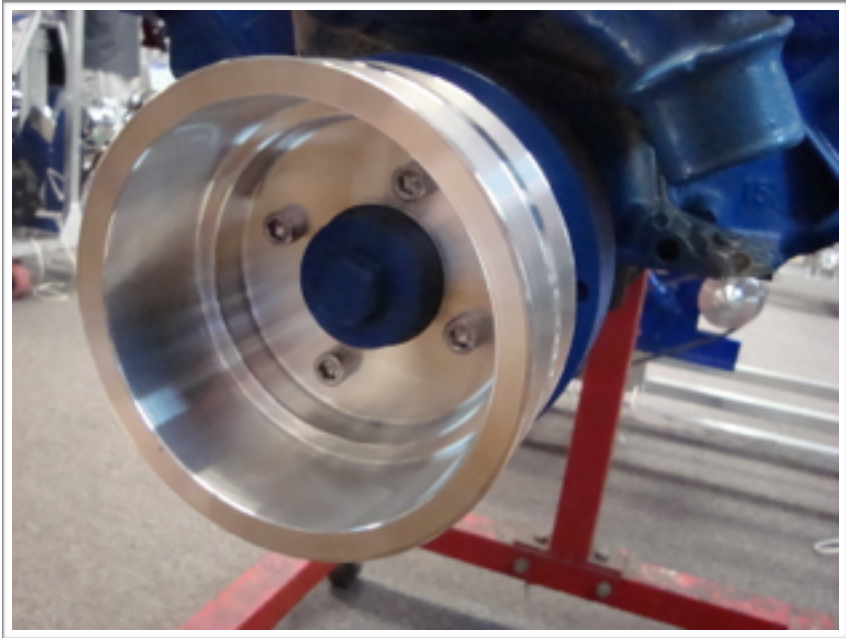


Photo 2

Install the water pump pulley (1873-A) and the (313-A) water pump cap using four 5/16" x 7/8" SHCS (S186). ***NOTE:** If using a mechanical fan **DO NOT** install the water pump cap. We **DO NOT** supply bolts for mechanical fans or adapters.

Photo 3

Install the alternator bracket (30201-A) to the water pump by running two 5/16" x 5-1/2" SHCS (S174) through the bracket. Then space bracket from water pump with two (TP3-1.680) spacer tubes and leave hand tight.



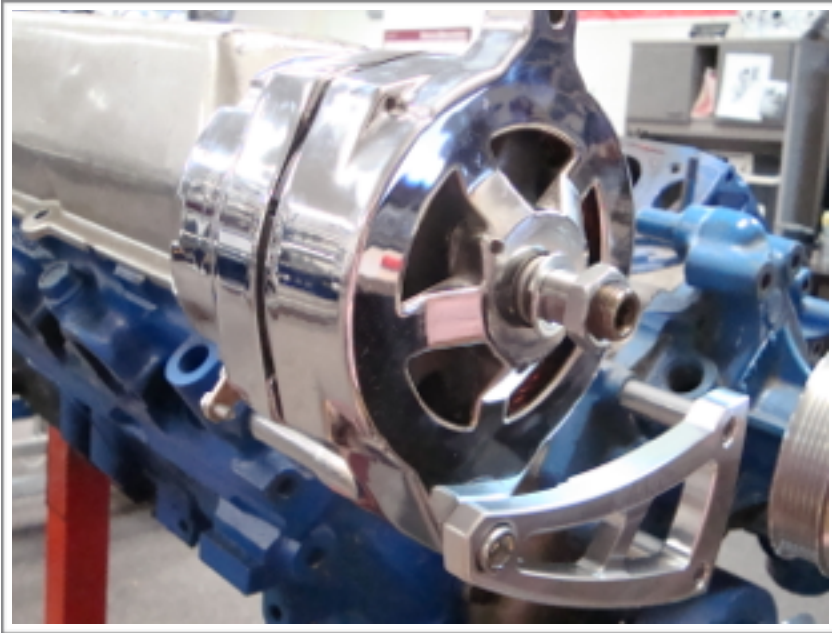


Photo 4

To mount the alternator to the bracket, hold alternator behind bracket then run a 7/16" x 5-1/2" SHCS (S374) through the bracket and alternator ear. Next place a (TP7-1.890) spacer between the head and alternator ear and tighten down bracket assembly. **NOTE:** If your head is tapped for a 3/8" hole, install the alternator bushing spacer into your alternator lower ear and run a 3/8" x 5-1/2" SHCS (S280) into the alternator and (TP7-1.890) spacer, then into the head. For alignment issues, use the supplied 3/8" washer (S667) in front or behind alternator to properly align. Not needed if head is tapped for 7/16" bolt.

Photo 5

Install the (RA-4.375) adjustment rod to the front of the upper alternator ear and water pump as shown. Use two 3/8" x 1" SHCS (S248) and tighten down.

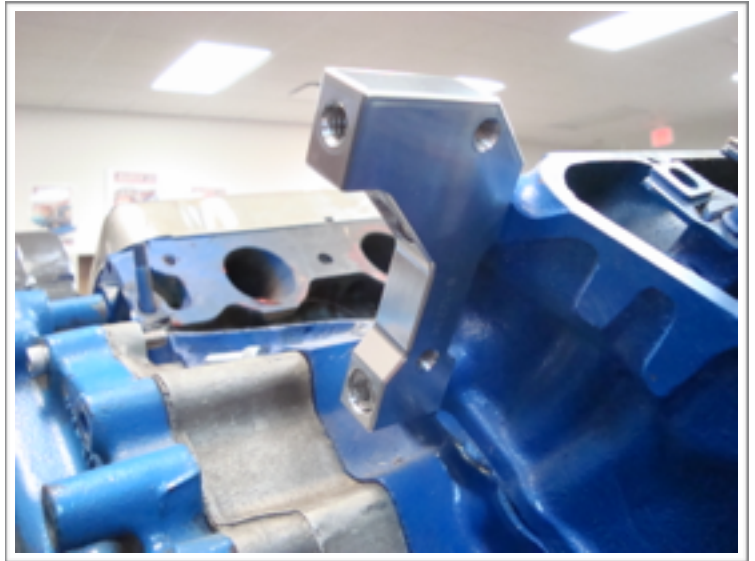


Photo 6

Install the alternator fan (221-A), then the alternator pulley (208-A). Use the provided lock washer (S685) and tighten down with the alternator nut and impact pulley on. Next add the alternator nose cover (307-A) and tighten down with three 8-32 x 1" SHCS (S028).

Photo 7

Mount the air conditioning rear support (30221-B) to the driver side head using two 3/8" x 1-1/2" SHCS (S252) and leave loose at this time.

**Photo 8**

Mount the air conditioning front support bracket (30221-A) to the water pump running two 5/16" x 5" SHCS (S172) through the bracket and spacing it off with two spacers (TP5-.800) and leave loose at this time.

Photo 9

Line up the lower left air conditioning ears with the front and rear support air conditioning brackets. In the front ear run one 3/8" x 1-3/4" SHCS (S254) through the ear and space it with one (TP3-.800) spacer and tighten into bracket. Next tie in the rear support ear to the rear support bracket with one 3/8" x 1-1/4" SHCS (S250) and tighten. Finally tighten both brackets down.



Photo 10

Mount the (RA-8.000) adjust rod to the water pump with one 3/8" x 1" SHCS (S248). Tie the other end to the top left ear using one 3/8" x 2" SHCS (S256) and place a (TP3-.400) spacer between the back of the ear and the adjustment rod. Tighten with a 3/8" lock nut (S622).

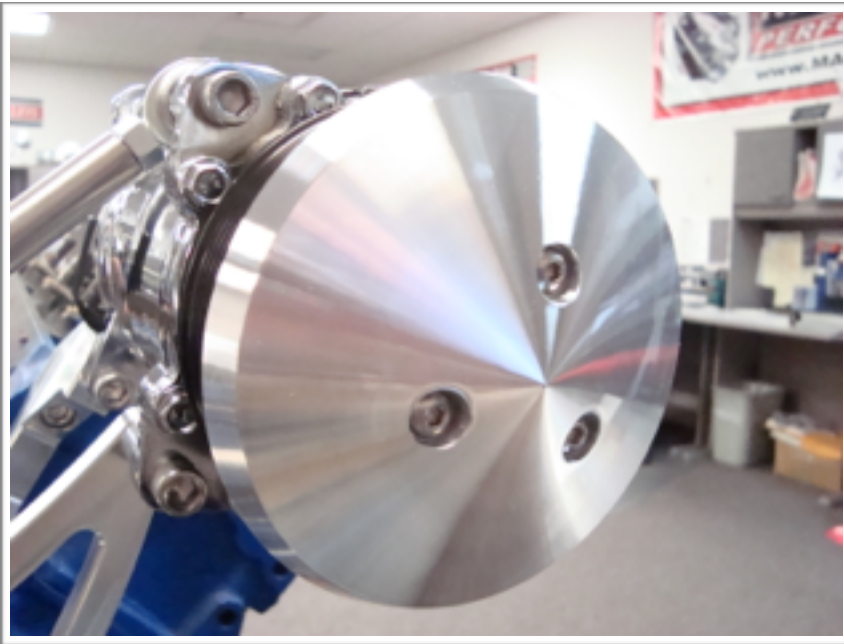


Photo 11

Next mount the air conditioning clutch cover (395-A) to air compressor using three 1/4" x 3/4" SHCS (S124) and tighten. **NOTE:** Do Not over tighten bolts on cover, will cause damage to air conditioning unit.

Photo 12

Mount the idler pulley (740-A) to the lower boss of water pump inlet and tighten with one 3/8" x 3" hex head (S329) and 3/8" washer (S666). Space off boss with one aluminum spacer (AC3-1.250) as shown.

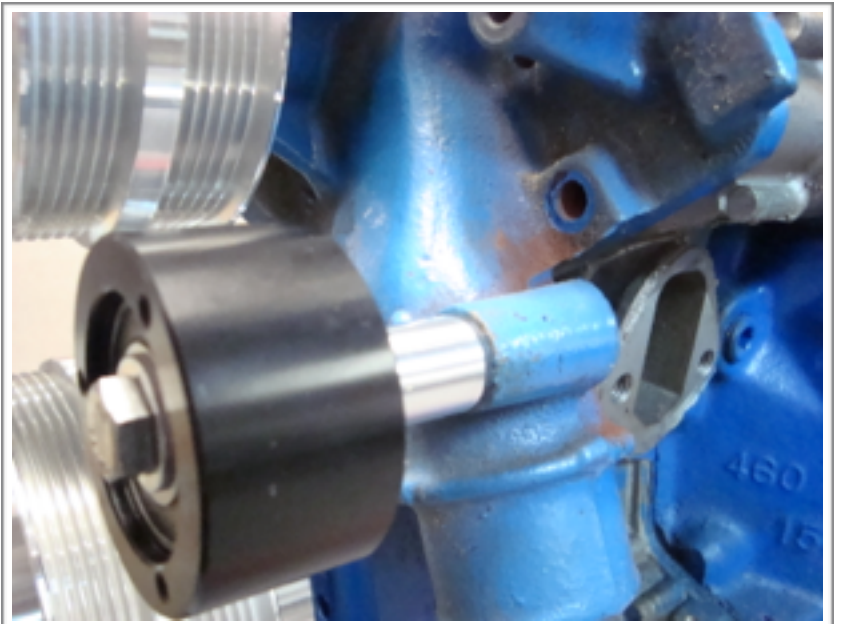




Photo 7

Install the power steering rear support bracket (30211-B) to the two outer head holes with two (TP7-1.625) spacer tubes between head and bracket and tighten with two 7/16" x 2-1/4" SHCS (S356).

Photo 8

Install the power steering pump to the rear support bracket placing a spacer (AC3-1.000) for steel cased saginaw pumps or a (AC3-.875) for the March billet pump 9600 in the lower hole. Secure with a 3/8" x 2" SHCS (S256) and a 3/8" washer (S666). In the upper hole place spacer (AC3-.725) for steel cased saginaw pumps or a (AC3-.650) for the March billet pump 9600. Secure with a 3/8" x 1-3/4" SHCS (S254) and a 3/8" washer (S666). Leave hand tight for now.



Photo 9

Install the power steering front bracket (20311-A) to the water pump by running a 3/8" x 1-1/4" SHCS (S250) with a (TP3-.800) spacer in the upper hole. In the lower hole run a 3/8" x 1" SHCS (S248) with a (TP3-.300) mounting hole and tighten.

Photo 10

Pull power steering pump up and run a 3/8" x 1" hex head bolt (S312) and a 3/8" x 1" diameter washer (S664) through adjustment slot. To align use two or three 3/8" washers (S666) between the front bracket and the power steering pump. Now install the (535-A) pulley for keyway pumps or (620-A) pulley for press fit pumps. Next install the nose cover (302-A) using three 8-32 x 3/8" SHCS (S022) and tighten.

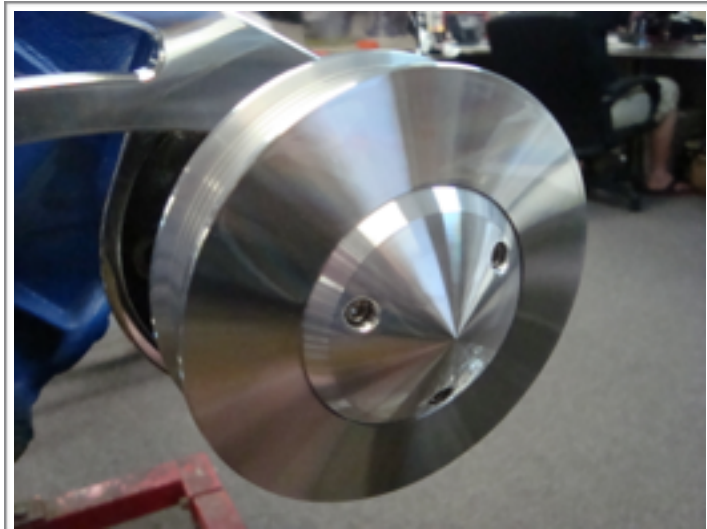


Photo 11

First install the **46-1/2" Dayco (5060465)** belt on alternator side first, tighten by turning adjustment rod expanding it outward to tighten belt. To install belt on air conditioning side, first expand adjustment rod outward. Then install a **61-1/2" Dayco (5060615)** belt on the air conditioning side. Tighten by turning adjustment rod inward to tighten belt. For more adjustment pull down on power steering pump to tighten and lock down front and rear support bracket bolts. Due to belt variations in may be necessary to remove adjustment rods, install belt and re-install each adjustment rod and tighten. Once belts are installed, install idler pulley cover (302-A) and tighten with three 8-32 x 3/8" (S022) bolts. Make sure all bolts are tight on all brackets and pulleys before running engine.

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



Tech Support:
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