



Highly Styled, Low Cost Serpentine Drive

Installation Instructions

Ford 351 Cleveland

Kit #30450 (Chrome Alternator and Power Steering)

Kit #30460 (Billet Alternator and Power Steering)



Included Parts List

Main Front Bracket P/N #30451

- 1 - 30451-A Face Bracket Body
- 2 - 740-A Idler Pulley
- 2 - 302-A Idler Pulley Cap
- 6 - S022 $\frac{8}{32} \times \frac{3}{8}$ " SHCS
- 1 - S144 $\frac{5}{16}$ " x $\frac{7}{8}$ " SHCS
- 1 - S146 $\frac{5}{16}$ " x 1" SHCS
- 2 - S148 $\frac{5}{16}$ " x 1 $\frac{1}{4}$ " SHCS
- 1 - S150 $\frac{5}{16}$ " x 1 $\frac{1}{2}$ " SHCS
- 2 - S162 $\frac{5}{16}$ " x 3" SHCS
- 1 - S170 $\frac{5}{16}$ " x 4" SHCS
- 1 - S171 $\frac{5}{16}$ " x 4 $\frac{1}{4}$ " SHCS
- 3 - S254 $\frac{3}{8}$ " x 1 $\frac{3}{4}$ " SHCS
- 1 - S264 $\frac{3}{8}$ " x 2 $\frac{3}{4}$ " SHCS
- 2 - S270 $\frac{3}{8}$ " x 3 $\frac{1}{2}$ " SHCS
- 2 - MM100 Bushing Spacer
- 2 - S622 $\frac{3}{8}$ " Id Nylon Lock Nut
- 4 - S660 $\frac{5}{16}$ " Id Flat Washer
- 2 - S666 $\frac{3}{8}$ " Id Flat Washer
- 2 - TP3-.990 Tube Spacer $\frac{3}{8}$ " Id x .990"
- 1 - TP3-1.330 Tube Spacer $\frac{3}{8}$ " Id x 1.330"
- 1 - TP3-1.730 Tube Spacer $\frac{3}{8}$ " Id x 1.730"

Alternator Rear Support P/N #30452

- 1 - 30452-A Alternator Rear Bracket Body
- 2 - S156 $\frac{5}{16}$ " x 2 $\frac{1}{4}$ " SHCS
- 1 - S452 $\frac{5}{8}$ " x .452" Set Screw

Power Steering Rear Support P/N #30453

- 1 - 30453-A Power Steering Rear Bracket Body
- 2 - S156 $\frac{5}{16}$ " x 2 $\frac{1}{4}$ " SHCS
- 1 - S452 $\frac{5}{8}$ " x .452" Set Screw
- 1 - TP3-1.400 Tube Spacer $\frac{3}{8}$ " Id x 1.400"

Belt Adjustment Tool P/N #BLT-14.75

- 1 - MM101 RH Rod End
- 1 - MM102 LH Rod End
- 1 - MM106 14 $\frac{3}{4}$ " Lg Threaded Hex Rod

Power Steering Adaptor P/N #21074

- 1 - 21074-A Adaptor Ring Body
- 2 - S244 $\frac{3}{8}$ " x $\frac{3}{4}$ " SHCS
- 1 - S311 $\frac{3}{8}$ " x $\frac{3}{4}$ " Hex Hd Bolt

Pulley Kit P/N # 2235-206

- 1 - 2236-A Crank Shaft Pulley
- 1 - 2232-A Water Pump Pulley
- 1 - 206-A Alt Pulley
- 1 - 221-A Alt Fan
- 1 - 306-A Alt Cap
- 1 - 312-A Water Pump Pulley Cap
- 1 - 360-A Power Steering Pulley Cap
- 1 - 629-A Power Steering Pulley
- 3 - S028 $\frac{8}{32} \times 1$ " SHCS
- 3 - S106 $\frac{1}{4}$ " x 1-1 $\frac{1}{4}$ " SHCS
- 4 - S186 $\frac{5}{16}$ " x 7 $\frac{7}{8}$ " SHCS
- 4 - S248 $\frac{3}{8}$ " x 1" Lg SHCS
- 1 - S685 1 $\frac{1}{16}$ " Lock Washer
- 1 - S716 Ring Adaptor $\frac{5}{8}$ " Id x $\frac{3}{4}$ " Od

Accessories

- 1 - P164 Ford Cleveland Alum Water Pump
- 1 - P304 Power Steering Pump Chrome
For Kit #30450 Only
- 1 - P555 Alternator Chrome
For Kit #30450 Only
- 1 - 9600 Power Steering Pump Billet
For Kit #30460 Only
- 1 - 9655 Alternator Billet
For Kit #30460 Only

Required Tools and Materials

- RTV Silicone
- Loc-Tite® Thread Locker
- 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
- 1 $\frac{1}{16}$ " Combo Wrench

- $\frac{3}{4}$ " Combo Wrench
- Socket Wrench & Extension
- 10mm 12pt. socket
- 12mm 12pt. socket

Serpentine Belt

- Dayco Belt (5060780) 78" 6 Rib Belt



Tech Support 1-888-729-9070

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

FIG-1 Ensure the sealing of the face of the coolant are clean and free of old gasket material. Assemble the water pump to the timing cover along with proper gaskets and a thin coat of RTV Sealant. Water pump (P164).

See **Diagram 1**. For proper bolt positions.

Mount the water pump using the SHCS bolts shown in locations A thru D

(NOTE: The 4 locations also each get a $\frac{5}{16}$ " washer (S660).

[A] $\frac{5}{16}$ x $\frac{7}{8}$ " (S144) [B] $\frac{5}{16}$ X $1\frac{1}{2}$ " (S150)
 [C] $\frac{5}{16}$ X 3" (S162) [D] $\frac{5}{16}$ X $1\frac{1}{4}$ " (S148)

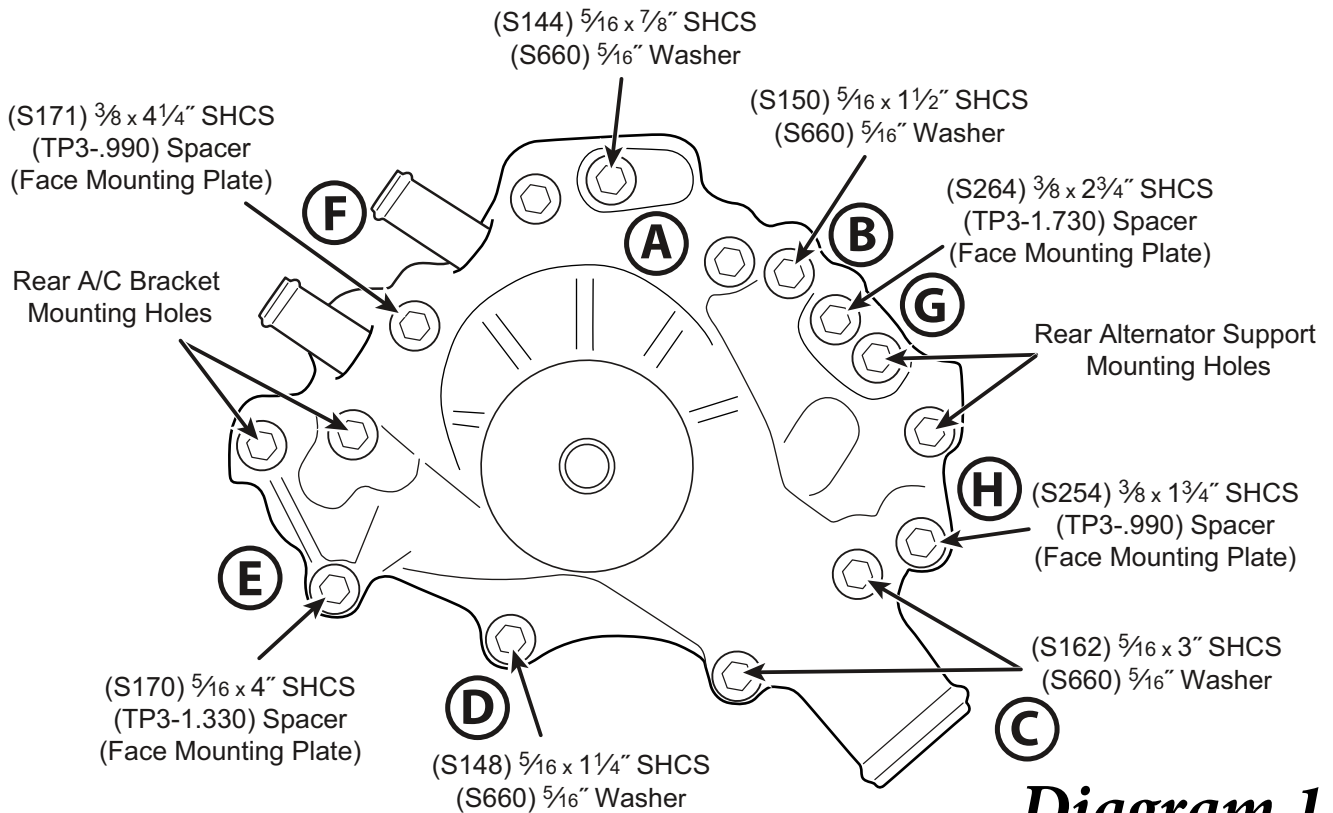


Diagram 1.

FIG-2 Install the Alternator Rear Support Bracket (30452-A) to the water pump using (2) $\frac{5}{16}$ x $2\frac{1}{4}$ " SHCS (S156) As Shown. Install the rear Power Steering Bracket (30453-A) to the water pump using (2) $\frac{5}{16}$ x $2\frac{1}{4}$ " SHCS (S156) Install a $\frac{5}{8}$ " O.D. Threaded Bushings (S452) into each Rear Support.

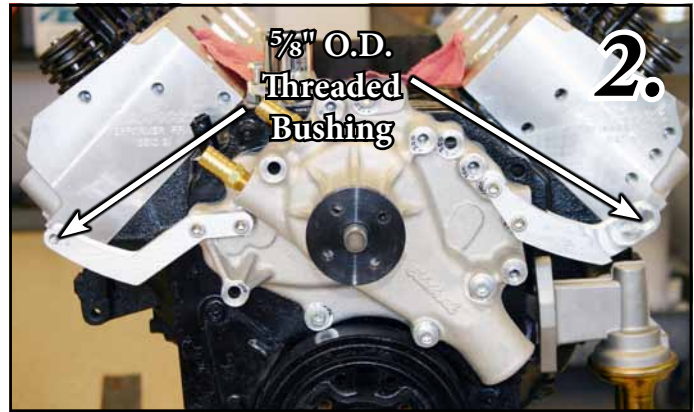


FIG-3 Install the Main Face Plate (30451-A) See Diagram and install the main face plate using the following bolt Sizes and spacers.

Position (E)

$\frac{5}{16}$ x 4" (S170) & TP3- 1.330 Spacer

Position (F)

$\frac{5}{16}$ x $4\frac{1}{4}$ " (S171) & TP3-.990 Spacer.

Position (G)

$\frac{3}{8}$ x $2\frac{3}{4}$ " (S264) & TP3-1.730 Spacer

Position (H)

$\frac{3}{8}$ x $1\frac{3}{4}$ " (S254) & TP3-.990 Spacer.

Apply Loc-Tite to the threads.

See Diagram 1. on previous page for proper water pump mounting locations.

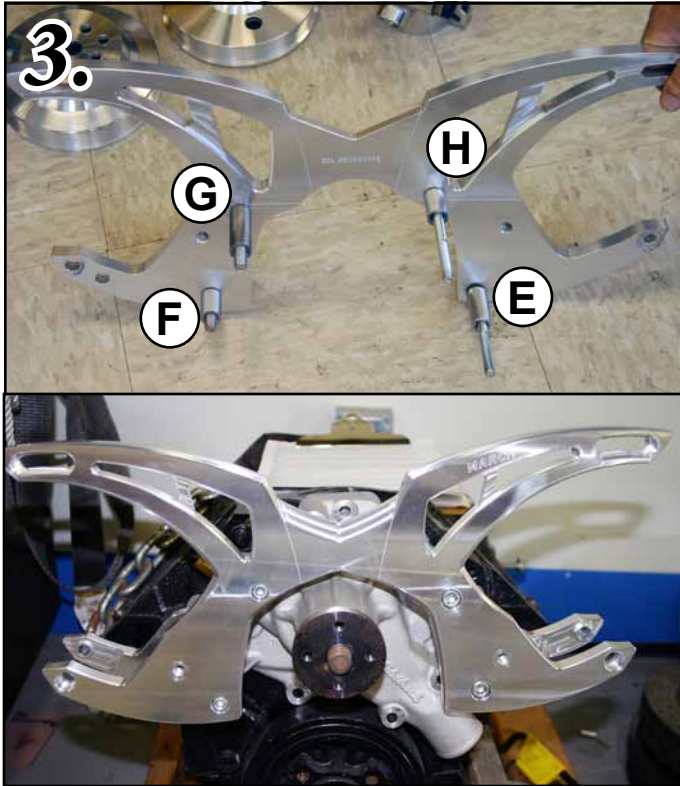


FIG-4 Install the Alternator (P555 Chrome or 9655 Billet) on the passenger side using a $\frac{3}{8}$ x $3\frac{1}{2}$ " SHCS (S270) in the lower hole. Screw in making sure the (S452) adjustment screw is tight on the back mounting ear of the Alternator. Add a $\frac{3}{8}$ " Lock nut (S622) to the rear of the $\frac{3}{8}$ SHCS.

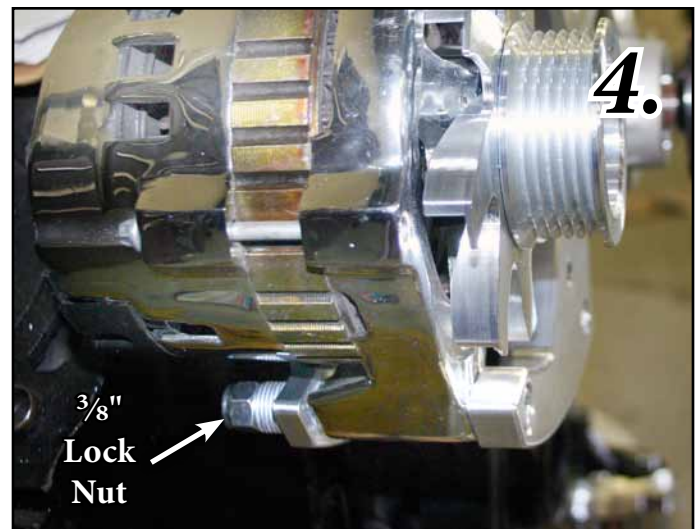


FIG-5 Add a MM100 Aluminum Bushing thru The top slot and a $\frac{5}{16}$ x $1\frac{1}{4}$ " (S148) Leave loose at this time.



Fig-6 Install the Power Steering pump (9600 Billet or P304 Chrome). First install the power steering adapter ring (21074-A) Use Two $\frac{3}{8}$ x $\frac{3}{4}$ " SHCS (S244) in the counter bored holes and (1) $\frac{3}{8}$ x $\frac{3}{4}$ " Hex bolt (S311) As shown.

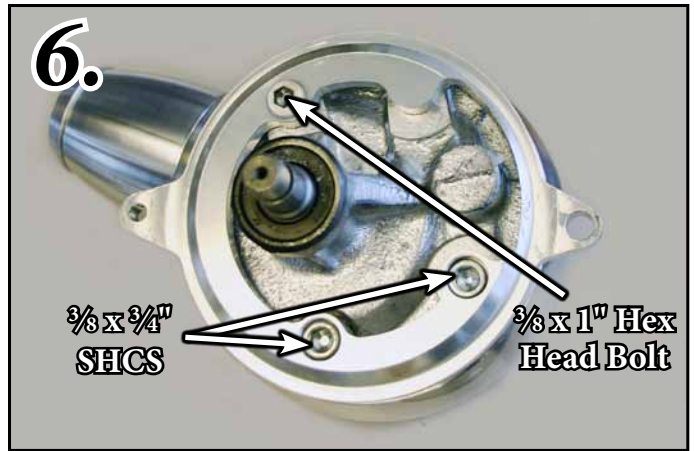


Fig-7 Install the unit to the main bracket using a $\frac{3}{8}$ x $3\frac{1}{2}$ " SHCS (S270) in the lower hole, Use a TP3-1.400 Spacer Between the rear of the adapter ring and the rear adjustment Bushing. Make sure the bushing is snug to the spacer and thread thru, now add a $\frac{3}{8}$ " lock nut (S622). In the upper Slot use a MM100 Alum bushing And a $\frac{5}{16}$ x 1" SHCS (S146) leave loose at this time..

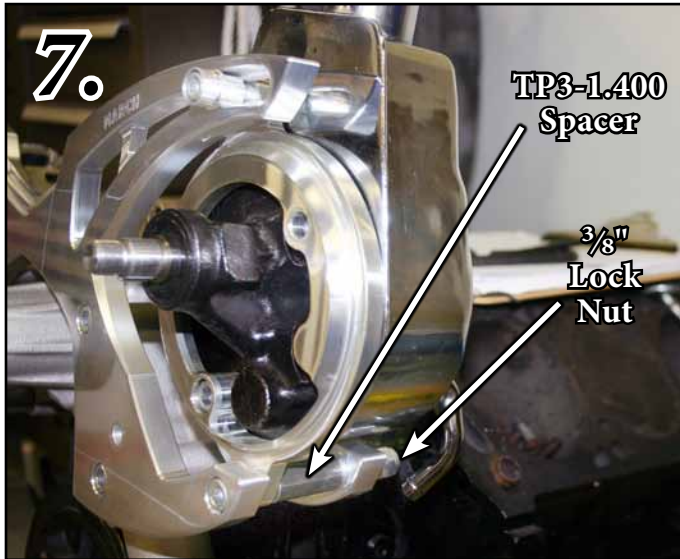


Fig-8 Install the Two (740-A) Idlers to the main plate using Two $\frac{3}{8}$ x $1\frac{3}{4}$ " (S254) and two $\frac{3}{8}$ " washers (S666) and then add the two covers (302-A) with $\frac{8}{32}$ x $\frac{3}{8}$ " SHCS (S022).



Fig-9 Use the Adapter ring $\frac{3}{4}$ " O.D. x $\frac{5}{8}$ " I.D. (S716) over the water pump shaft and install the water pump pulley (2232-A) and the water pump nose cover (312-A) with four $\frac{5}{16}$ x $\frac{7}{8}$ " SHCS (S186).

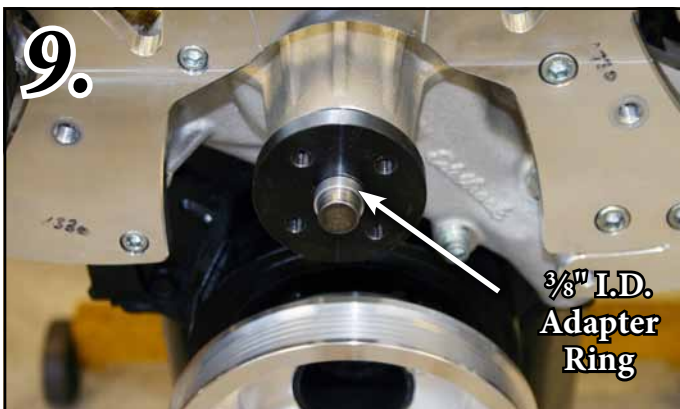


Fig-10 Install alternator fan (221-A) and Pulley (206-A) along with Lock Washer (S685) and tighten pulley nut (impact to 90 ft, pounds). Install Alt Cap (306-A) with (3) $\frac{8}{32}$ x 1" SHCS (S028).



Fig-11 Install the Power Steering Pulley (629-A) with the lock nut and then install the cover (360-A) with (3) $\frac{1}{4}$ x $1\frac{1}{4}$ " SHCS (S106).

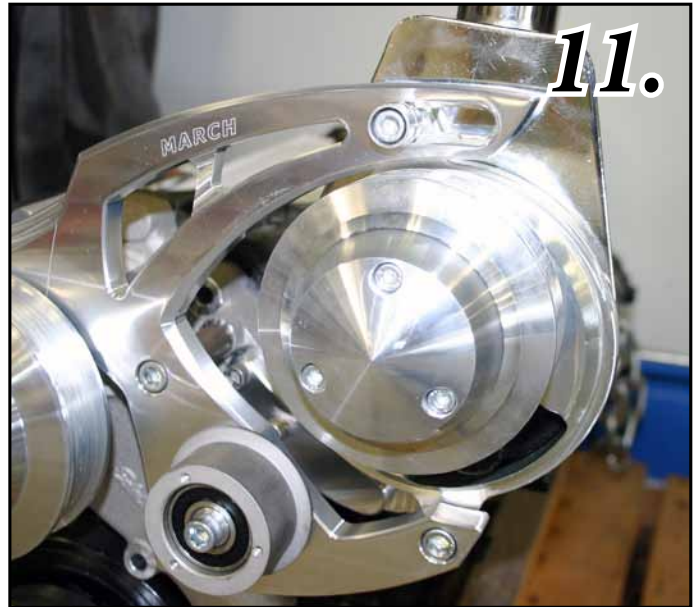


Fig 12: Install Crank Pulley (2236-A) with (4) $\frac{3}{8}$ x 1" SHCS (S248).

Fig 13: Install Dayco Belt (5060675) 67.5" wrapping as shown.

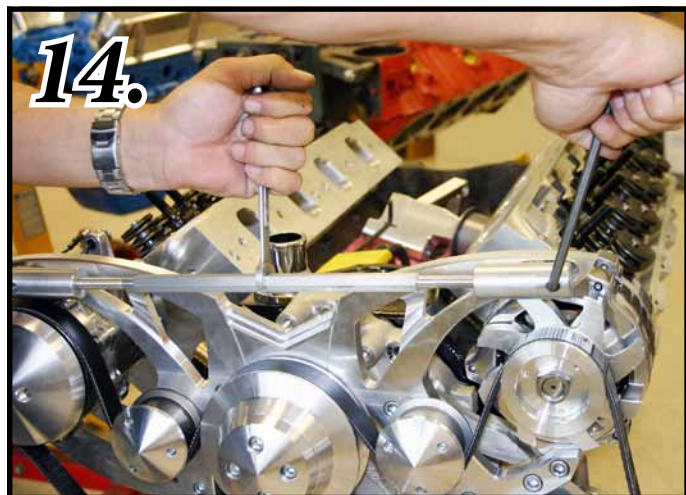


Fig 14: Slip the supplied (BLT-14.75) March Adjustment Tool over the two (MM100) bushings at the Alternator an A/C sides. Use a wrench to turn the adjustment tool outward to tighten the serpentine belt to 100 ft. lbs. Use the holes in the adjustment tool to tighten both M8 socket head cap screws when correct belt tension has been achieved. Remove the adjustment tool and keep for future use.

TIP: Fig-13a: Your Serpentine belt is tight when it can't be moved by more than 1/2 inch at it's longest span between pulleys. The belt should not be able to be twisted by more than half a turn.

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.



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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

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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.

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