Chevy Small Block Front Mount Kit

#20275, #20285

- Tensioner
- Crank Pulley (6266)
- Alt. Fan
- Tensioner Base (20256-A)
- A/C Support Bracket (20254-A)
- A/C Bracket (20253-A)
- use (1) 3/8-16 x 3/4" S.H.C.S. & washer
- A/C (side view)
- Alternator (side view)
- Power Steering Pump, Pulley (619)
- Power Steering Base (20257-A) or Support Bracket (20258-A) w/o P/S
- Crank Pulley (6266)

- A/C Support Bracket (20254-A)
- use (1) 3/8-16 x 3/4" S.H.C.S. & (1) 3/8-16 x 1" button head bolt & washer

- Alt. Bracket (20251-A)
- use (1) 3/8-16 x 5" S.H.C.S., (1) 3/8-16 x 3 1/2" S.H.C.S. & (1) 8mm x 1.25 x 100 S.H.C.S.

- Perfect Positioning Bushing
- H.H.S. & washer
- S.H.C.S.

- (1) 8mm x 1.25 x 120 S.H.C.S.
- (1) 3/8-16 x 3/4" H.H.S.
- (1) 3/8-16 x 4" S.H.C.S.
- S.H.C.S. & (1) 8mm x 1.25 x 100 S.H.C.S.

- Alt. Fan
- Perfect Positioning Bushing and locknut

- (1) 3/8-16 x 3/4" S.H.C.S.
- (1) 3/8-16 x 1" button head bolt & washer

- TP3 .625 Spacer
- (1) 3/8-16 x 3/4" S.H.C.S.
- 8mm x 1.25 x 100 H.H.S. & .200 bevel washer

- Revised 6-26-07

62" Serpentine Belt (with power steering)
61" Serpentine Belt (with out power steering)

S.H.C.S. = Socket Head Cap Screw  H.H.S. = Hex Head Screw  S.S. = Stainless Steel
Tensioner
1. Hold Tensioner Body in a vise to remove bolt & washer from tensioner pulley (note; bolt is a left handed thread, turn clockwise to remove). Discard washer.
2. Mount Tensioner Assembly to Tensioner Housing Cover (20256-B) using (1) 3⁄8"-16 x 3⁄4" socket head cap screw.
3. Mount Tensioner to Tensioner Base (20256-A) using (2) 3⁄8"-16 x 1" socket head cap screws (note; clocking position of Tensioner Pulley, approximately 2 o’clock).
4. Mount Tensioner Assy. (20256-A) to engine block using (2) 3⁄8"-16 x 1" socket head cap screws. This bracket replaces the power steering pump base on kits with out power steering. Insert .200 bevel washer and (1) 8-1.25 x 1—H.H.S. Thriugh upper base bracket hole (fig. 2 item A) Bolt must be in P/S before bolting to engine due to exhaust clearence.
5. Postioning Bushing (fig. 3) Mount Support Bracket (20258-A) to engine block using (2) 3⁄8"-16 x 1" socket head cap screws.
6. Mount Tensioner Assy. (20256-A) to engine block using (2) 3⁄8"-16 x 1" socket head cap screws.

Power Steering Pump
(kits with power steering)
7. Mount Remote Power Steering Pump to P/S Base (20257-A) using (2) 3⁄8"-16 x 3⁄4" socket head cap screws (note; line hose toward bottom).
8. Mount P/S Base (20257-A) to engine block using (2) 3⁄8"-16 x 1" socket head cap screws. Insert .200 bevel washer and (1) 8-1.25 x 1--H.H.S. Thriugh upper base bracket hole (fig. 2 item A) Bolt must be in P/S before bolting to engine due to exhaust clearence.
9. Mount Support Bracket (20254-A) to engine block using (2) 3⁄8"-16 x 1" socket head cap screws. Insert .200 bevel washer and (1) 8-1.25 x 1--H.H.S. Thriugh upper base bracket hole (fig. 2 item A) Bolt must be in P/S before bolting to engine due to exhaust clearence.
10. Mount P/S Pulley (619) to Power Steering Pump using a pulley installation tool.

Alternator
13. Mount Alt. Bracket (20251-A) to Alternator using (1) 3⁄8"-16 x 3⁄4" socket head cap screw, one Positioning Bushing, & (1) 3⁄8"-16 locknut (note; position of Alt. Bracket to Alternator, left side & down from Alternator) (leave loose for positioning). (Note: perfect positioning bushing will draw alt into position when tightened).
14. Mount Alt. Bracket (20251-A) & Assembly thru Water Pump mounting holes into engine block using (1) 3⁄8"-16 x 5" socket head cap screw in top hole and (1) 3⁄8"-16 x 3⁄4" socket head cap screw in bottom hole.
15. Mount Alt. Support Bracket (20251-B) to Alternator using (1) 8mm x 1.25 x 100mm" hex head screw, and TP3 .625 spacer between P/S bracket and support bracket as shown (fig.2). Mount support bracket (20251-B) to P/S Base (20257-A) using (1) 3⁄8"-16 x 3⁄4" socket head cap screw.
16. Tighten Alt. Bracket (20251-A) to Alternator.
17. Using an impact gun mount Alt. Fan (220) to Alternator using supplied nut and lock washer.

Air Conditioner
19. Mount A/C Bracket (20253) to A/C Compressor using one (1) 8mm x 1.25 x 100 hex head screw. (note; position of A/C Bracket to A/C Compressor, A/C Compressor lines to the left, A/C Bracket right side & down from A/C Compressor) (leave loose for positioning).
20. Mount A/C Support Bracket (20254-A) & A/C Support Bracket (20253-B) to A/C Compressor using (1) 8mm x 1.25 x 120 socket head cap screw making sure to run bolt through rear support bracket first and then perfect positioning bushing (fig.3) (leave loose for positioning).
21. Mount A/C Bracket (20253-A) through Water Pump mounting holes into engine block using (1) 3⁄8"-16 x 3⁄4" socket head cap screw in bottom hole and (1) 3⁄8"-16 x 4" socket head cap screw in top hole.
22. Mount rear support bracket (20254-B) to cylinder head using (1) 3⁄8"-16 x 3⁄4" hex head bolt and (1) 3⁄8" x 3⁄4" flat washer.
23. Attach A/C support bracket (20254-A) to tensioner base (20256-A) using (1) 3⁄8" x 1" button head bolt and (1) 3⁄8" x 5⁄8" flat washer.

Support Bracket
(kits without power steering only)
12. Mount Support Bracket (20258-A) to engine block using (2) 3⁄8"-16 x 1" socket head cap screws. This bracket replaces the power steering pump base on kits with out power steering. Insert .200 bevel washer and (1) 8-1.25 x 1--H.H.S. Thriugh upper base bracket hole (fig. 2 item A) Bolt must be in P/S before bolting to engine due to exhaust clearence.

Rear Support Bracket
220 Bevel Washer (A) TP3 .625 Spacer

Technical Support 888-729-9070

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