Highly Styled, Low Cost Serpentine Drive

Installation Instructions

Chevy LT-1

Kit #20970 (Alternator Only)
#20975 (Alternator and Power Steering)
#20980 (Alternator and A/C)
#20985 (Alternator, A/C and Power Steering)
Included Parts List

Alternator Bracket P/N 20971
1 - 20971-A............Alternator Bracket
4 - S248..................3⁄8 x 1″ SHCS
1 - S270..................3⁄8 x 3 1⁄2 SHCS
1 - S551..................M8 x 25 mm
1 - 20971-B............Rear Support
1 - 20971-C............Rear Support Tube
1 - S450..................Adjustment screw
1 - 744....................Idler
1 - S322..................3⁄8 x 1 1⁄2 Hex Bolt
1 - S666..................3⁄8 Washer
2 - S766..................3⁄8 - 16 Stainless Threaded Studs
2 - S341..................3⁄8 - 16 Studs

A/C Bracket P/N 20972
1 - 20972-A............A/C Bracket
2 - S248..................3⁄8 x 1″ SHCS
2 - S551..................M8 x 25 MM SHCS
1 - 20972-B............Rear A/C Support
1 - S256..................3⁄8 x 2″ SHCS
1 - AC3-1.350............Spacer
1 - S150..................7⁄16 x 1 1⁄2″ SHCS
1 - S616..................7⁄16 Lock nut
1 - 744....................Idler Pulley
1 - S322..................3⁄8 x 1 1⁄2 Hex Bolt
1 - S666..................3⁄8 Washer
2 - S766..................3⁄8 - 16 Stainless Spacers
2 - S341..................3⁄8 - 16 Studs

Power Steering Bracket P/N 20973
1 - 20973-A............Power Steering Bracket
2 - S144..................5⁄16 x 7⁄8″ SHCS
2 - S551..................M8 x 25mm SHCS
1 - 337-A............Water pump Center Cover
(Kit 20980 and 20985 with A/C)
1 - 338-A............Water Pump Center Cover
(Kit 20970 and 20975 without A/C)
6 - S501..................M6 x 12 mm SHCS
1 - S730..................O-Ring Rear Seal for Covers

Thermostat Relocator Bracket P/N 20974
1 - 20974-A............Thermostat Relocator Bracket Body
2 - S500..................M6-1.0 x 25mm SHCS

Pulleys
1 - 394..................A/C Cover
1 - 221..................Alt Fan
1 - 208..................Alt Pulley
1 - 307..................Alternator Pulley Cover
1 - 651..................P/S Pulley with 601 Hub

Accessories
1 - P315..................P/S unit Rem Style
1 - P412..................A/C unit
1 - P572..................Alt. Unit
1 - P417..................A/C line kit
1 - P109..................Corvette Water pump

CRANK HUB NOT SOLD IN KITS
1 - 348-A............Vette Crank Spacer Hub
1 - 340-A............Vette Crank Pulley Cover
3 - S370..................7⁄16 x 4 1⁄2 SHCS
1 - 349-A............Camaro Crank Spacer Hub
1 - 341-A............Camaro Crank Pulley Cover
3 - S370..................7⁄16 x 4 1⁄2 SHCS
3 - S315..................3⁄8 x 1⁄2″ Button Head Bolts

Required Tools and Materials

RTV Silicone
Loc-Tite® Thread Locker
Anti-seize Compound
Gasket Scraper, Steel Wool or Sandpaper to clean gasket surfaces
3⁄16″ Allen Head Driver
5⁄16″ Allen Head Driver
1⁄4″ Allen Head Driver
6mm Allen Head Driver
3⁄8″ Combo Wrench
7⁄16″ Combo Wrench
11⁄16″ Combo Wrench
3⁄4″ Combo Wrench
Socket Wrench & Extension
10mm 12pt. socket
12mm 12pt. socket

Serpentine Belt
471⁄2″ #20970 Alt. Only
541⁄2″ #20975 Alt. and P/S
711⁄2″ #20980 Alt. and A/C
781⁄2″ #20985 Alt., A/C and P/S

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.

**Installing the Kit**

Photo-1  Install Crank Pulley Adapter hub (349-A) or (348-A) Depending on the Dampener for Camaro or Corvette. Use the 3 Provided 7/16 x 4½" SHCS (S370).

Photo-2  Install the Crank Pulley Cover (340-A) or (341-A) by first Tapping 3 of the 5/16 dampener holes with a 3⁄8-16 tap and use the (3) 3⁄8 x 1⁄2" Button head screws (S315) to secure.

Photo-3  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 (4) 4½” mounting studs (S341) slide waterpump gaskets In place and install the Corvette Water pump (P109) and secure with (4) 3/8 Threaded Stainless Spacers (S766) As Shown.

Photo-4  Install the A/C Rear Support Bracket (20972-B) Using a (AC3-1.350) Long Spacer Between the Head and the bracket and use a 3/8 x 2" SHCS (S256) in the Slot of the bracket.

**NOTE:** For non-A/C kits 20970 and 20975, skip instructions 4, 5 and 6.

- 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.

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Install the Front Main A/C Bracket (20972-A) to the Water pump with (2) \( \frac{3}{8} \times 1" \) SHCS (S248). Install the Front Main Alternator Bracket (20971-A) to the water pump using (2) \( \frac{3}{8} \times 1" \) SHCS (S248) as shown in Photo 5.

Install the A/C unit (P412) to the main bracket with (2) M8 x 25mm SHCS (S551). Tie the Rear A/C ear to the Rear Support Bracket with the \( \frac{5}{16} \times 1\frac{1}{2}" \) SHCS (S150) and use a \( \frac{5}{16} \) Lock Nut (S616).

Install the A/C unit (P412) to the main bracket with (2) M8 x 25mm SHCS (S551). Tie the Rear A/C ear to the Rear Support Bracket with the \( \frac{5}{16} \times 1\frac{1}{2}" \) SHCS (S150) and use a \( \frac{5}{16} \) Lock Nut (S616).

Install the rear Alternator Support and Rear Support Tube (20971-B) and (20971-C) by bolting the two parts together with a \( \frac{3}{8} \times 1" \) SHCS (S248) and mount to the head with a \( \frac{3}{8} \times 1" \) SHCS (S248). In the front of the aluminum tube install the (S450) Threaded Adjustment Screw.

Install the rear Alternator Support and Rear Support Tube (20971-B) and (20971-C) by bolting the two parts together with a \( \frac{3}{8} \times 1" \) SHCS (S248) and mount to the head with a \( \frac{3}{8} \times 1" \) SHCS (S248). In the front of the aluminum tube install the (S450) Threaded Adjustment Screw.

Install the (2) Idler Pulleys (744) using (2) \( \frac{3}{8} \) Washers (666) and (2) \( \frac{3}{8} \times 1\frac{1}{2}" \) Hex Head Bolt (S322) To the A/C and Alternator Brackets. (Non A/C kits will use alternator bracket idler only)

Install the Center Water Pump Cover (337-A) using the (6) M6 x 12mm SHCS (S501) and the O-Ring (S730) to the rear of the cover as a replacement seal.
Photo-11 **NOTE: For non-A/C kits 20970 and 20975** Install Center Water Pump Cover (338-A). using the (6) M6 x 12mm SHCS (S501) and the O-Ring (S370) to the rear of the cover as a replacement seal. *(This cover comes with a pre-installed idler for used with kits without A/C)*

Photo-12 Install the Thermostat Relocator (20974), this bottom view shows a small notch in the thermostat bolt holes, use the relocator as a guide and drill a notch in the thermostat housing for bolt hole clearance as shown.

Photo-13 Using a new gasket mount the thermostat housing in its re clocked position using the relocator (20974-A) and (2) M6 x 25mm SHCS (S500) as shown.

For Kits With Power Steering

Photo-13 Mount the Power Steering Pump (P315) to the Power Steering Bracket (20973-A) using (2) M8 x 25mm SHCS (S551) and mount the Pump/Bracket Assembly to the Alternator bracket using (2) 5/16 x 7/8" SHCS (S144)
15. 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.

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**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.
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2. To avail yourself of this Limited Warranty, return the Product with a copy of the paid receipt, postage paid to:
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   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
70% return fee on all repairable product

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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.

RGA# ______________________ CT# ______________________ Issued by: ______________________ Date: ______________________

Purchaser’s Name: ______________________________________ Phone: ______________________

Address: ______________________________________

Purchased Directly Through: ______________________ Invoice#: ______________________

Product ID: ______________________________________ Invoice Date: ______________________

Reason: ______________________________________

** MOUNTED PRODUCTS ARE NONREFUNDABLE **