Highly Styled, Low Cost Serpentine Drive

Installation Instructions

Chevy Small Block Twin Alternator
Kit #21075 and #21080

MARCH
PERFORMANCE PULLEYS & BRACKETS
### Included Parts List

**Main Front Bracket Kit P/N 21071**
1-21071-A .......... Main Front Bracket Body
2-S148 ............. 3/16-18 x 1 1/2" SHCS
2-S553 ............. M8-1.25 x 35mm
1-S150 ............. 3/16-18 x 1 1/2" SHCS
4-S248 ............. 5/16-16 x 1" SHCS
3-S339 ............. 3/8 x 3" lg Stud Threaded
1-S340 ............. 3/8 x 4" lg Stud Threaded
4-S675 ............. Paper Water Pump Gasket
1-S770 ............. 1.900" Lg Threaded Spacer Stainless
3-S775 ............. 2.800" Lg Threaded Spacer Stainless
2-MM100 .......... Bolt Adjustment Bushing

**Alternator Rear Support P/N 21072**
1-21072-A .......... Alternator Rear Support Body
1-S280 ............. 3/8"-16 x 5 1/2" SHCS
1-S450 ............. 5/8" Set Screw
1-S622 ............. 3/8" Lock Nut
1-TP3-1.775 ........ 3/8" Id x 1.775" Lg Spacer

**Dual Alt Rear Support P/N 21076**
1-21073-A .......... Dual Alt Rear Support Brk Body
1-S276 ............. 3/8"-16 x 4 1/2" SHCS
1-TP3-1.890 ........ 3/8" Id x 1.890" Lg Spacer

**Power Steering Bracket P/N 21104**
*For Kit #21075 Only*
1-21104-A .......... Power Steering Front Brk Body
1-21104-B .......... Power Steering Rear Brk Body
2-S260 ............. 3/8-16 x 2 1/4" SHCS
2-S551 ............. 8mm-1.25 x 25mm SHCS

**Belt Tensioner Tool P/N 21106**
1-MM101 .......... RH Rod End
1-MM102 .......... LH Rod End
1-MM103 .......... threaded Adjustment Rod 12" Long

**Pulley Kit P/N 6304-206**
1-6306-A .......... Crank Pulley Body
1-6307-A .......... Water Pump Pulley Body
2-206-A .......... Alternator Pulley Body
2-222-A .......... Alternator Fan Body
2-306-A .......... Alternator Pulley Cap
6-S028 ............. 5/32 x 1" SHCS
4-S186 ............. 5/16-24 x 7/8" SHCS
3-S292 ............. 3/8-24 x 1" SHCS
2-S685 ............. 11/16" Alt Lock Washer

1-619-A .......... Power Steering Pulley Body For Kit #21075 Only
1-302-A .......... Power Steering Nose Cover For Kit #21075 Only
3-S022 ............. 5/32 x 3/8" SHCS For Kit #21075 Only

**Accessories**
1-P112 .......... Water Pump Alum Rev Rotation
2-P573 .......... Alternator Chrome Single Wire
1-P315 .......... Power Steering Pump For Kit #21075 Only
3-S022 ............. 8/32 x 3/8" SHCS For Kit #21075 Only

### 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
- 5/6" Combo Wrench
- 9/16" Combo Wrench
- 11/16" Combo Wrench
- 3/4" Combo Wrench
- Socket Wrench & Extension
- 10mm 12pt. socket
- 12mm 12pt. socket

**Serpentine Belt**
- 56" Belt without Power Steering
- 57.5" Belt with Power Steering
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

Installing the Kit

1. 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 mounting studs into the four water pump mounting holes placing the longer (S340) 3/8" x 4" stud in the lower passenger side hole. Place the other three (S339) 3/8" x 3" studs in the remaining holes. When fully installed the 3/8" x 4" stud should be 3 5/16" from the face of the block. The other three studs should be 2 3/8" from face of block. Fig-1

2. Install the Rear Support Brackets (21172-A) on the passenger side and Rear Support (21172-A) on drivers side. Use the (4) provided Paper Gaskets (S675) and a small amount of silicon sealant installed on the front and rear of both brackets to ensure a water tight seal.

3. Slide the Water Pump (P112) Over the Studs and secure with the (3) 3/8 x 2.800" Stainless Spacers (S775) two to the upper water pump studs and one to the lower drivers side water pump stud. Install (1) 3/8 x 1.900" Stainless spacer (S770) on the lower passenger side water pump stud. Use a sealer if necessary.
**FIG 4.** Mount the Main Face Plate (21071-A) to the (4) studs with (4) ⅜ x 1” SHCS (S248). Note: leave the studs loose to aid in proper alignment.

**FIG 5.** For kit #21075 with Remote Power Steering apply Loc-Tite to the threads of the two (S551) M8-1.25 x 25mm socket head caps screws and attach the Remote Power Steering Pump (P315) to Power Steering Bracket (21104-A).

**FIG 6.** Apply loc-tite to the threads of the two (S260) ⅞ x 2⅛ Socket cap screws. Install the Power Steering Bracket and Pump assembly to the lower right holes of the engine block. Use the provided spacer (21104-B) between the engine block and the Power Steering bracket as shown. Install the Power Steering Pulley (619-A).

**FIG 7.** Install (S450) threaded bushing into Alternator Rear Support Bracket (21072-A) (as shown Fig 7a). Install the passenger side Alternators (P573) using (1) ⅜ x 5½” SHCS (S280) and a TP3-1.775 Spacer Between the rear of the Alt and the (S450) Set Screw. Turn the S450 set screw to take up any slack between the lower alternator support and the spacer. Secure with a ⅜” Lock Nut (S622). The drivers side Alternator uses a ⅜-16 x 4½” SHCS with (TP3-1.890) Spacer. Install between Rear Support and Alternator. Thread into Rear Support (21073-A). (snug only at this time).
FIG 8. Install alternator fans (222-A) and Pulleys (206-A) using lock washers (S685) and nut that comes with the alternators. Tighten alternator pulley nuts (impact to 90 ft, pounds). Install Crank Pulley (6306-A) using three 3/8-24 x 1” SHCS (S292). Install Water Pump Pulley (6307-A) with four 5/16-24 x 7/8” SHCS (S186). Install alternator pulley covers (306-A) with three 8-32x1” SHCS. Install Power Steering Nose Cover (302-A) with three 9/32-32 x 3/8” SHCS. Kit #21075 Only.

With the Alternators units tilted inward Install the belt 56” (non-power steering) or 57.5” (power steering).

FIG 9. In both upper alternator adjustment slots install the provided MM100 Adjustment Bushings and the 5/16 x 1 1/4” SHCS (S148), leave loose. For Billet Chrome Alternators use M8-1.25 x 35mm (S553)

FIG 10. Slip the supplied March Adjustment tool over the two (MM100) Adjustment bushings. 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 8mm socket head cap screws when correct belt tension has been achieved. Remove the adjustment tool and keep for future use.

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

Final Assembly

Check and tighten all bracket bolts and alternator and power steering 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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   NAPLES, FL 34110
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