Highly Styled, Low Cost Serpentine Drive

Installation Instructions

Chevy Small Block
Kit #21110 (without Power Steering)
Kit #21160 (with Remote Power Steering)
Kit #21165 (with Saginaw Power Steering)
Included Parts List

Main Front Bracket Kit  P/N 21111
1 - 21111-A........Main Front bracket body
4 - S248 ..........½ - 16 x 1” SHCS
1 - S276 ..........½ - 16 x ½” SHCS
3 - S339 ..........½ - 16 x 3” Threaded Stud
1 - S340 ..........½ - 16 x 4” Threaded Stud
1 - S550 ..........8mm - 1.25 x 20mm SHCS
2 - S553 ..........8mm - 1.25 x 35mm SHCS
3 - S775 ..........1.900” Threaded Spacer Stainless
1 - S770 ..........2.800” Threaded Spacer Stainless
1 - S750 ..........Hose Extension
2 - MM100........Alum Bolt Cap

Alt Rear Support Bracket  P/N 21112
1 - 21112-A........Alt Support Bracket Body
2 - Q153,...........N_rcpU_rcpSk n E_q crq
1 - S452 ..........⅜” Threaded Bushing
1 - A3-1.350........Alum Spacer 1.350” Lg

A/C Rear Support Bracket  P/N 21113
1 - 21113-A........A/C Support Bracket Body
1 - S155 ..........⅜ - 18 x 2” SHCS
1 - S616 ..........⅜ - 18 Nylon Lock Nut
1 - S660 ..........⅜” Flat Washer
2 - S675 ........... Paper Water Pump Gaskets

Power Steering Bracket  P/N 21104  
(For Kit # 21150)
1 - 21104-A........Power Steering Bracket Body
1 - 21104-B........Power Steering Rear Spacer Block
2 - S260 ..........⅜ - 18 x 2¼” SHCS
2 - S551 ..........M8 - 1.25 x 25mm SHCS

Power Steering Bracket  P/N 21109  (For Kit # 21165)
1-21109-A........Front Bracket
1-21109-B........Rear Bracket
1-20114-C........Spacer Block
2-S311 ..........⅜ x ¼” hex bolts
1-S312 ..........⅜ x 1” hex Bolt
2-S270 ..........⅜ x 3½” SHCS
1-TP3-.150 .........Alum Spacer

Belt Tensioner Tool  P/N 21105
1 - MM101........Right Hand Rod End
1 - MM102........Left Hand Rod End
1 - MM103........12” Threaded Rod

Pulley Kit  P/N 6305-206
1 - 6301-A........Crank Pulley body
1 - 6307-A........Water pump Pulley Body
1 - 221-A.........Alternator Fan
1 - 206-A.........Alternator Pulley Body
1 - 306-A.........Alternator Cap Body
1 - 394-A.........A/C Cover
3 - S028 ..........⅜ x 1” SHCS
3 - S520 ..........M6 - 10 x 16mm Button Hd Bolt
4 - S186 ..........⅜ - 24 x ⅞” SHCS
3 - S292 ..........⅜ - 24 x 1” SHCS
1 - S685 ..........⅜” Lock Washer
1 - 619-A.........P/S Pulley (Press Fit)  (For Kit # 21150)
1 - 302-A.........P/S Pulley Nose Cover  (For Kit # 21150)
1 - 535-A.........P/S Pulley  (For Kit # 21165)
3 - S022 ..........¼ x ⅝” SHCS  (For Kit # 21150)

Accessories
1 - P112............Alum Water Pump
1 - P412............Sanden A/C Compressor (Chrome)
1 - P572............Alum Alternator
1 - P417............A/C Line Kit
1 - P315............Remote P/S Pump  (For Kit # 21150)

Tensioner Bracket (optional)  PN 21105
1 - 21105-A........Tensioner Base
1 - P750............Spring Tensioner.
1 - 780-A............Tensioner Base Cover
1 - 307-A..........Cap
3- S025 ..........⅜ x ⅝” SHCS
2 - S250 ..........⅜ - 16 x 1⅛” SHCS
2 - S268 ..........⅜ - 16 x 3¼” SHCS

Required Tools and Materials

RTV Silicone
Loc-Tite® Thread Locker
Anti-seize Compound
Gasket Scraper, Steel Wool or Sandpaper to clean gasket surfaces
⅜” Allen Head Driver
⅜” Allen Head Driver
¼” Allen Head Driver
6mm Allen Head Driver
⅝” Combo Wrench
⅜” Combo Wrench
⅜” Combo Wrench
⅝” Combo Wrench
10mm 12pt. socket
12mm 12pt. socket
Serpenine Belt
59” for Kits Without Power Steering
62” for Kits With Remote Power Steering
64” for Kits With Canister Power Steering

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

NOTE: The following instructions show March Performance Style Track Kit 21101/21150 photos. Revolver Kit 21110 and 21160 looks different but installation is identical.

1. Install the Alternator Rear Support Brackets (21112-A) on the drivers side and A/C Rear Support (21113-A) on passenger side. Use the (4) provided Paper Gaskets (S675) and a small amount of silicon sealant at the block side. These brackets have gaskets on the back (block side) and front (water pump side)

Fig-2. Install (S452) 5/16”-18 threaded bushing into alternator rear support bracket as shown.

2. 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. Install (S452) 5/16"-18 threaded bushing into alternator rear support bracket as shown.

Fig-3. Install (S452) 5/16"-18 threaded bushing into alternator rear support bracket as shown.
Fig-4. For Revolver kit #21160 with Power Steering apply Loc-Tite to the threads of the two (S551) M8 x 1.25 x 25 mm socket head caps screws and attach the remote power steering pump unit to bracket #P315.

Fig-5. Apply loc-tite to the threads of the two (S260) 3⁄8 x 2 1⁄4" 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.

Kit 21165 with canister style power steering pump.

Fig-6. Mount the front bracket (20109-A) to the front of the Power Steering pump with (2) 3⁄8 x 3⁄4" Hex Head Bolts. (S311). Mount the rear plate (20109-B) to the rear of the pump in the lower pump housing hole using (1) 3⁄8 x 1" hex bolt (S312).

Fig-7. Use the (TP-3 .150) spacer between the pump and the bracket. Insert the Spacer block (20114-C) between the two plates and install the unit to the lower right (drivers side) Engine Block tapped holes using (2) 3/8 x 3-1/2 SHCS. Install the power steering pulley (535).

Fig-8. Make sure the paper gaskets are in place, and using silicone sealer slide the water pump over studs and onto the face of rear brackets. As shown.
Fig-9. Apply anti-seize to the exposed threads on each stud. Thread the short (S770) 1.900 Threaded Stainless Spacer onto the bottom passenger side stud and then thread the three remaining longer (S775) 2.800 Threaded Stainless Spacer onto the remaining studs.

Fig-10. Tighten threaded spacer bushings as shown.
Install (S750) Hose Extension to water pump using Teflon tape.

Fig-11. Mount main bracket to threaded studs using four (S248) 3/8"-16 x 1" socket head cap screws.
Fig-12. Press Power Steering pulley (619-A) on with a install tool or bolt and washer as shown. When properly installed pulley should be flush with top of shaft as shown. Fig-12a

Fig-13. Apply Loc-Tite to the threads of the three (S292) \( \frac{3}{8}'' \)-24 x 1" socket head cap screws. Place the crank pulley (6301-A) on damper and align holes. Thread the three screws through pulley and into damper, tighten firmly (50 ft/lbs.) Re-install Dampener Bolt

Fig-14. Apply Loc-Tite to the threads of the four (S186) \( \frac{5}{16} '' \)-24 x \( \frac{7}{8} '' \) socket head cap screws. Place the water pump pulley (6307-A) to the Water Pump and thread the cap screws through pulley and into Water Pump pulley flange, tighten firmly (28 ft/lbs.)

Fig-15. Install the alternator (P572) behind the main front bracket. Turn the adjustment screw (S452) in the rear alternator support bracket, to remove any gap in between the (AC3-1.350) spacer, and the lower alternator mounting flange. Using the provided \( \frac{3}{8} '' \times 4 \frac{1}{2} '' \) shcs (S276) secure the alternator thru the front of the main bracket into the rear support bracket. Tighten lightly at this time.
**Fig-16.** Place the compressor clutch cover (394-A) onto the compressor clutch and align. Thread the three (S520) M6 - 10 x 16mm Button Head Bolt through the cover and into the clutch and tighten. **Caution – Do not over-tighten!**

**Fig-17.** Install A/C compressor Unit (P412) use a (S155) \( \frac{3}{16} \) x 2" socket head cap screw, washer, and lock nut to support the rear tang and a M8 x 1.25 x 25 mm socket cap thru the front bracket-into front. tang. Tighten lightly at this time.

**Fig-18.** Push the Alternator and A/C inward to their fullest position and Install a 62" belt for power steering or a 59" belt for non power steering kits. Slip the belt over the crank pulley last. **Fig-18a**

- Use Dayco #5060590 59" 6 rib serpentine belt for kit #21110 (without power steering)
- Use Dayco #5060620 62" 6 rib serpentine belt for kit #21160 (with remote power steering pump)
- Use Dayco #5060640 64" 6 rib serpentine belt for kit #21165 (with canister power steering pump)
Fig-19. Install (S553) M8 x 1.25 x 35 mm bolt into (MM100) bushings as shown install, One each into Alternator, and A/C units in adjustment slots, leave loose at this time.

Fig-20. Slip the supplied March Adjustment tool over the two (MM100) 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.

Fig-21. 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.

Fig-22. Install Alternator fan (221-A) and Pulley (206-A) using the nut that comes with the alternator. Tighten alternator pulley nut (impact to 90 ft, pounds). Check and tighten all bracket bolts and 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.

Install Alternator Pulley cover (306-A) with three (S028) socket head cap screws.

Install Power Steering Pulley Cover (302-A) with three (S022) socket head cap screws.

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.
March Performance warrants to the original retail purchaser that for a period of ninety (90) days from the date of purchase, March Performance will repair or replace, at their option, any Product, which is found to be defective in material or workmanship.

**Exclusions from Warranty Coverage**
March Performance does not warrant any Product that is damaged from abuse, misuse or misapplication or not used for its intended purposes.

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**Your Responsibilities:**
1. Use and install the Product only for its intended purpose.
2. To avail yourself of this Limited Warranty, return the Product with a copy of the paid receipt, postage paid to:
   MARCH PERFORMANCE
   16160 PERFORMANCE WAY
   NAPLES, FL 34110
   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

**NO CREDIT WILL BE ISSUED ON RETURNED PRODUCT BEYOND REPAIR**
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**