March Performance Corvette Alt. & P/S Kits
21175- Revolver Chrome Alt. & P/S
21180- Revolver Billet Alt & P/S
21140-Style Track Chrome Alt & P/S Kit
21145- Style Track Billet Alt. & P/S Kit
PARTS LIST

Main Bracket
1- 21172-A........Main Bracket (Revolver)
1- 21142-A........Main Bracket (Style Track)
3- 744-A..........Idler Pulley
2- 302-A..........Idler Pulley Cover
1- 311-A..........Idler Pulley Cover (w/hole)
9- S022...........8-32 x 3/8" SHCS
2- MM100..........Spacer Bushing
2- S146...........5/16-18 x 1" SHCS
2- S248...........3/8-16 x 1" SHCS
1- S256...........3/8-16 x 2" SHCS
1- S280...........3/8-16 x 5-1/2" SHCS
2- S321...........3/8 x 1-3/4" Hex Bolt
3- S339...........3/8-16 x 3" Stud
2- S666...........3/8 Washer
1- S768..........Threaded Spacer 1.850" 
2- S785..........Threaded Spacer 3"
1- TP3-2.150......3/8 Tube Spacer 2.150"

21178 Belt Tensioning Bracket
1- 21174-A........Bracket Body
1- 21178-C........Re-Location Bracket
2- AC3-.810........Aluminum Spacer Tube
1- RA-1.625........Adjustment Rod
1- 30606-A........Idler Pulley Body
1- S143...........5/16-18 x 5/8" SHCS
2- S148...........5/16-18 x 1-1/4" SHCS
1- S248...........3/8-16 x 1" SHCS
2- S256...........3/8-16 x 2" SHCS
1- 750-A..........Idler Pulley Grooved
1- 302-A..........Idler Pulley Cover
3- S022...........8-32 x 3/8" SHCS
1- S666...........3/8 Washer

21143 Alt Rear Support
1- 21072-A.........Alt Rear Support Bracket
1- TP3-1.730......Spacer Tube 1.730"
1- S280...........3/8-16 x 5-1/2" SHCS
1- S450...........Bush 5/8 OD 1-1/8" Ig
1- S622...........3/8 Lock Nut
2- S675............Gaskets

21144 P/S Rear Support
1- 21073-A........PS Rear Support Bracket
1- TP3-1.100......Spacer Tube 1.100"
1- TP3-2.150......Spacer Tube 2.150"
1- S278...........3/8-16 x 5" SHCS
2- S675............Gaskets

21074 P/S Adapter Ring
1- 21074-A.........Adapter Ring
2- S244...........3/8-16 x 3/4" SHCS
1- S312...........3/8-16 x 1" Hex Bolt

Pulley Kit
1- 7611-A..........Crank Pulley
1- 6317-A..........Water Pump Pulley
1- 333-A..........W/P Pulley Cover
1- 359-A..........Crank Adapter
1- 221-A..........Alt. Fan
1- 206-A..........Alt. Pulley
1- 306-A..........Alt. Pulley Cover
1- 629-A..........P/S Pulley
1- 360-A..........P/S Pulley Cover
3- S028...........8-32 x 1" SHCS
4- S186...........5/16-24 x 7/8" SHCS
3- S296...........3/8-24 x 1-1/2" SHCS
1- S685...........Lock Washer 11/16"
3- S106...........1/4-20 x 1-1/4" SHCS

Accessories
1- P205...........Water Pump Aluminum
1- P555...........Alternator Chrome
1- P304...........P/S Chrome

Billet Option Part Numbers
1- 9600..........Billet PS
1- 9655..........Billet Alt

Belt Sizes
47" Belt
37" Belt
**Photo-1**
Install three 3/8 x 3" Threaded 3" Studs (S339) into the shown locations. Then install two Paper Gaskets (S675) as shown.

**Photo-2**
Install the Rear Alt Support Ear (21072-A) to the Pass. Side and the Rear P/S Support Bracket (21073-A) to the drivers side. Now insert the threaded 5/8 bushing (S450) into the 5/8 tapped hole of the Alt Support. Then add the last two Paper Gaskets (S675) as shown.

**Photo-3**
Install the Provided Water Pump (P205) sliding it over the studs. Now secure with two 3” long Stainless Spacers (S785) in the upper Water Pump holes. In the Drivers side lower hole use the 1.850 long Stainless Spacer (S768). Do Not over tighten at this time you may need to align the Rear Supports to line up with the Main Bracket.

**Photo-4**
Install the Main Face Plate (21172-A) or (21142-A) to the two 3” Stainless Spacers using two 3/8 x 1” SHCS (S248) as shown.
This is a Side View of the drivers side Spacer and Idler in the lower W/P hole. Between the Main Plate and the 1.850 Spacer install the (744-A) Idler Pulley. First install the Idler Cap (311-A) using three 8-32 x 3/8 SHCS (S022). Note: This Idler Cover has the thru hole in it. With the Cap facing the W/P, install the Idler Pulley between the Main Plate and the 1.850 Spacer. Secure with a 3/8 x 2” SHCS (S256) thru the Main Plate.

In the lower Passenger Side W/P hole insert a Spacer Tube (TP3-2.150) between the Main Plate and the Water Pump Boss. Secure with a 3/8 x 5-1/2” SHCS (S280) thru the Main Plate.

Mount the Power Steering Adapter Ring (21074-A) to the Pump using two 3/8 x 3/4” SHCS (S244) and one 3/8 x 1” Hex Bolt (S312) as shown.

This is a side view of the P/S mounting installation. Behind the P/S Adapter use the Spacer Tube (TP3-1.100). Now insert the Adjustment Rod (RA-1.625), then insert the next Spacer Tube (TP3-2.150). Now run a 3/8 x 5” SHCS (S278) thru the Main Bracket into the two tubes, the adjustment rod, and into the Rear P/S Support as shown.
**Photo-9**

Side view: Installation of the Lower Alt. Thru the Main Face Plate use the 3/8 x 5-1/2" SHCS (S280). Behind the Alt Mounting Ear use the Spacer Tube (TP3-1.730). Use the Adjuster Screw in the rear support to take up any gap. Then secure with a 3/8 Lock Nut (S622).

**Photo-10**

In the upper slot of the Alternator use a Aluminum Bushing (MM100) and a 5/16 x 1” SHCS (S146). Now add the Alt. Fan (221-A), the Alt pulley (206-A). Secure with the provided Lock Washer (S685) and nut. Now install the Alt Cover (306-A) using three 8-32 x 1” SHCS (S028).

**Photo-11**

Finish the Power Steering installation: In the Upper slot use the Aluminum Bushing (MM100) and a 5/16 x 1” SHCS (S146). Now install the P/S Pulley (629-A) securing with the locknut then add the P/S Cover (360-A) using three 1/4-20 x 1-1/4" SHCS (S106).

**Photo-12**

Install the Water Pump Pulley (6317-A) and the W/P Pulley Cover (333-A) using four 5/16 x 7/8 SHCS (S186).
Photo-13
Mount the Crank Spacer (359-A) and Crank Pulley (7611-A) using three 3/8 x 1-1/2" SHCS (S296)

Photo-14
This picture shows the parts of the Belt Adjustment Bracket. Note: The Idler Pulley (750-A) is already pressed on the the Bracket Body (30606-A).

Photo-14
Installing the Base Bracket (21174-A): Between the bracket and the block use two Alum. Spacers (AC3-.810) then add the bracket and secure with two 3/8 x 2" SHCS (S256).

Photo-15
Mount the Idler Body and Bracket to the Base Bracket. Note: The re-location bracket (21178-C) mounts above the Idler Body Bracket as shown. Run a 5/16 x 1-1/4" SHCS (S148) thru the upper hole and into the lower hole. Thru the (REAR) slot use the second 5/16 x 1-1/4" SHCS (S148) threading it in to the re-location bracket. Now attach the Adjustment Rod to the outer hole using a 3/8 x 1" SHCS (S248). Now add a 3/8 Washer (S666) and a 5/16 x 5/8 SHCS (S143) to the tapped hole in the center of the Idler. Add the Idler Cap (302-A) with three 8-32 x 3/8 (S022).
Mount the two remaining Idler Pulleys (744-A) to the Face Plate. Use two 3/8 washers (S666) and two 3/8 x 1-3/4” Hex Bolts (S321) then add the two Idler Caps (302-A) using six 8-32 x 3/8 SHCS (S022).

Photo-17
Belt installation: Install the Rear Belt 37” over the rear set of serps on the W/P Pulley, under the idler, over to the belt tensioning bracket, then under the Crank Pulley. Tighten with the 1.625 Adjustment Rod (BLT-12). Install the front belt, 47” as shown in the cover photo. Tilting the P/S and Alt inward (remove one of the MM100 Bushings and bolts if necessary) Install the Belt and tighten with the provided (BLT-12) March Tool. Remove the tool and store for future use. See photo below.

Motor Start Up Instructions
Re-Check All Install Bolts and start the motor checking for coolant leaks and proper belt alignment. Make sure to properly bleed you Power Steering Unit. Check for any signs of unusual belt wear or belt squeal. Belt squeal is caused by improper alignment or in proper belt tensioning.