MARCH PERFORMANCE

BIG BLOCK CORVETTE

Highly Styled, Low Cost Chevy Big Block Corvette

Serpentine Drive System Kit 21270
### Parts List 21270 Corvette Big Block

#### Main Front Bracket  P.N. 21271
- 1- 21271-A  Main Bracket
- 4- S339....... 3/8 x 3” Studs
- 4- S676....... Gaskets
- 1- S768....... 3/4 x 1.850 long Spacer
- 3- S786....... 3/4 x 3.400 long Threaded Spacers
- 3- S248....... 3/8 x 1” SHCS
- 1- 744-A..... Idler with 1.150 Bushing
- 2- 740-A..... Idler Pulleys
- 2-302-A.......Idler pulley caps
- 3- S666....... 3/8 Washers
- 2- S321.......3/8 x 1-3/4 Hex Bolts
- 1- AC3-.400.. 400 Long Alum. Spacer
- 1- S262.......3/8 x 2-1/2 SHCS
- 1- S279.......3/8 x 5-1/4 SHCS
- 1- TP3-1.400..Steel Tube Spacer 1.400 Long
- 1- RA-2.500....Adjustment Rod
- 6-S022......... 8/32 x 3/8 SHCS
- 2-S553.............M8 x 35 MM SHCS
- 2-MM100........Alum. Bushings
- 1-S550...........M8 x 20 MM SHCS

#### Rear A/C Support Bracket  P.N. 21274
- 1-21203-A......A/C support Bracket
- 1-TP5-.800..... .800 long Spacer Tube
- 1-S216........... 5/16-2” Hex Bolt

#### Rear Alt. Support Bracket  P.N. 21273
- 1-21202-A.......Rear Alt. Support Bracket
- 1-S452............ 5/8 O.D. Threaded Bushing

#### Power Steering Bracket  P.N.21272
- 1-21272-A.......P/S Bracket
- 1-21176-A.......P/S Relocation Bracket
- 3-S550.............M8 x 20mm SHCS
- 1-S219...........5/16 x 2-3/4
- 2-S348.........7/16 x 1-1/2 SHCS
- 1-S324.........3/8 x 2-1/4 Hex Bolt
- 1-TP3-1.100..... 1.100 Long Spacer tube

#### Pulley Kit  21270-208
- 1- 7671-A.......Crank Pulley
- 1- 361-A.......Crank Spacer
- 1- 650-A.......P/S Pulley
- 1- 6317-A......W/P Pulley
- 1- 333-A.......W/P Pulley Cap
- 1- 394-A.......A/C Cover
- 1- 208-A.......Alt Pulley
- 1- 307-A.......Alt Cap
- 1- 221-A.......Alt Fan
- 3- S252.............3/8 x 1-1/2 SHCS
- 3- S144..........5/16 x 7/8 SHCS
- 4- S186...........5/16-24 x 7/8 SHCS
- 1- S685........11/16 Lock Washer
- 3- S028..........8/32 x 1” SHCS
- 3- S520.........M6 x 1 x 20MM SHCS

#### Accessories
- P133........Alum. Water Pump
- P572.........Alternator
- P314.........Rem. P/S Pump W/601
- P412........A/C Unit
- P417.........A/C line kit

#### Required Tools And Materials
- RTV Silicone 5/8 “ Combo Wrench
- Lock tite 9/16” Combo Wrench
- Anti-seize 11/16” Combo Wrench
- Gasket Scraper 3/4 “ Combo Wrench
- 3/16 “Allen head Driver Socket Wrench & Extension
- 5/16” Allen head Driver 10MM 12 Point Socket
- 1/4 “ Allen head Driver 12 MM 12 Point Socket
- 6mm Allen Head Driver

**MARCH PERFORMANCE  TECH Support 1-888-729-9070**
**Photo-1**
Install the (4) 3/8 x 3” Studs into the block (S339) and slide two of the provided Gaskets (S676) over the studs as shown. Make sure the block is clean and use a sealer.

**Photo-2**
Slide P.N. (21203-A) over the Pass. Side Studs, and Part (21202-A) over the Drivers Side Studs. Add the Second Pair Of Gaskets (S676) now in the (21202-A) Bracket add the Provided (S452) 5/8 Threaded Bushing as shown.

*(NOTE): If using old style heads with freeze plugs Please contact Tech Support. For necessary Modifications.*

**Photo-3**
Install the Provided Water Pump (P133) over the Studs and Rear Support Brackets. Now on the Drivers Side lower stud install a 3/4 O.D.x 1.850 long Threaded Spacer (S768) . On the Three Remaining Studs install three 3/4 O.D.x 3.400 long Threaded Spacers (S786) . Tighten with a 9/16 Wrench.

**Photo-4**
Install the Main Faceplate (21271-A) to the three 3.400 Long Studs using three 3/8 x 1” SHCS (S248) (leave loose at this time) And do not install the drivers side lower bolt into the main bracket at this time.

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Photo-5
This is a side view of the drivers side lower stud, (Note) the (744-A) Idler has a pressed in bushing. This will face the back side of the main mounting plate between the back of the idler and the 1.850 long Threaded Spacer (S768) install a AC3-.400 Spacer then thru the front of the main bracket use a 3/8 x 2-1/4 SHCS (S262) After installing go ahead and tighten the remaining three main bracket mounting bolts.

Photo-6
Install the two (740-A) idler pulleys to the Main front bracket into the two 3/8 Tapped holes as shown. Using Use two 3/8 Washers (S666) and two 3/8 x 1-3/4 Hex Bolts. (S321).

PHOTO-7
Between the rear ear of the A/C and the rear A/C support use a TP5.-800 long Spacer and install a 5/16 x 2” (S216) Hex Bolt As Shown. In the front of the main bracket upper slot use a MM100 Bushing and a M8 x 35 MM SHCS. (S553) . In the lower Front main bracket Bolt hole use a M8 x 20 MM SHCS(S550).

Photo-7
Installing the Alternator (P572). in the lower front hole of the main bracket use a 3/8 x 5-1/4 SHCS (S279) Thru the front of the main Bracket Now in between the rear of the alt mounting ear and the rear bracket set screw use a TP3-1.400 Spacer Tube then add the 2-1/2” (RA-2.500) Adjustment Rod As shown. Adjust the 5/8 bushing so its tight to the rear of the adjustment rod. In the upper slot of the main bracket use a MM 100 Bushing and a M8 x 35MM SHCS (S553).
Now install the Crank pulley (7671-A) and the Crank pulley Spacer (361-A) using three 3/8 x 1-1/2 SHCS (S252). Install Alternator Fan (221-A) and alt Pulley (208-A) using a 11/16 Lock Washer (S685) tighten nut to 90 Foot Pounds. Install the Pulley Cap (307-A) with three 8/32 x 1” SHCS (S028) and the A/C cover (394-A) with three M6 x 20 MM SHCS (S520). Now install the Water pump pulley (6317-A) and W/P pulley cover (333-A) using four 5/16-24 x 7/8 SHCS (S186).

Install the P/S Re-locater Bracket (21176-A) to the P/S Pump use two M8 x 20 mm SHCS (S550) As shown.

Mounting the P/S Pump To the base Bracket (21272-A) Use one 5/16 x 2-3/4 Hex bolt (S219) thru the drilled hole and one M8 x 20 MM SHCS (S550) thru the rear of the base bracket into the slot then mount the base Bracket to the block using two 7/16 x 1-1/2 (S348) now Mount the 2-1/2” rod to the Relocation Bracket using a 3/8 x 2-1/4” Hex Bolt (S324) and a TP3-1.100 long Spacer. Now install the power Steering pulley (650-A) using three 5/16 x 7/8 SHCS (S144).

Now install the 43.3” Belt to the rear set of serps, over the water pump then under the rear idler pulley over the top of the P/S pulley then under the crank pulley and tighten the rear belt with the adjustment rod. Now move the Alt. and A/C units inward fully install the 53” drive belt to the front set of serps over the top of the water pump then under the two idlers then over the alt. and A/C units and back under the water pump. Now tighten the belt with the march adjustment tool (BLT-13).

(Note!) After the belt is tight REMOVE the tool and store it till needed!
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.

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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:

   MARCH PERFORMANCE
   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.

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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 resellable product
70% return fee on all repairable product

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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 ___________________________________

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