CHEVY BIG BLOCK LONG WATER PUMP PERFORMANCE BILLET BRACKETS

23073  KEYWAY P/S  Bracket & Pulley Kit
23083  PRESS P/S  Bracket & Pulley Kit
BA23073  Billet Alternator & Power Steering & A/C
CA23073  Chrome Alternator & Power Steering & A/C
### 20173 Alt. & A/C Bracket

1-236381-A………....Alternator & A/C Bracket  
1-236381-B………....Alternator Rear Bracket  
1-20129-B………....Rear A/C Support Bracket  
1-20140-A………....Alt. Relocation Bracket  
1-S144……………......5/16 x 7/8 SHCS  
2-S248……………......3/8 x 1” SHCS  
1-RA-1.625………....1-5/8 Adjustment Rod  
2-TP7-1.625……….1-5/8 long Spacer Tube  
1-TP7-2.000……….2” Spacer Tube  
1-TP7-2.750……….2-3/4” Spacer Tube  
1-S266……………......3/8 x 3” SHCS  
1-S150……………......5/16 x 1-1/2” SHCS  
1-S284……………......3/8 x 6-1/2” SHCS  
1-S324……………......3/8 x 2-1/4” Hex Bolt  
2-S358……………......7/16 x 2-1/2” SHCS  
1-S378……………......7/16 x 6-1/2” SHCS  
2-S550……………......M8 x 20mm SHCS  
1-S616……………......5/16 Lock Nut  
1-740-A……………....Idler Pulley  
1-302-A……………....Idler Pulley Cover  
1-S666……………......3/8 Washer  
3-S022……………......8-32 x 3/8 SHCS

### Pulley kit

1-6322-A………....Water Pump Pulley  
1-7336-A………....Crank Pulley  
1-208-A………....Alternator Pulley  
1-307-A………....Alternator Pulley Cover  
1-221-A………....Alternator Fan  
1-314-A………....Water Pump Nose Cover  
1-394-A………....A/C Cover  
3-S028……………......8-32 x 3/8 SHCS  
1-S685……………....Lock Nut  
4-S183……………......5/16 x 5/8 SHCS  
3-S248……………......3/8 x 1” SHCS  
3-S124……………......1/4 x 3/4” Button Heads (or)  
3-S520……………......M6 x 20mm Button Heads  
1-623-A………....Keyway Power Steering Pulley  
1-624-A………....Press fit Power Steering Pulley  
1-360-A………....W/P Pulley Nose Cover  
3-S106……………......1/4 x 1-1/4” SHCS

### 20151 Power Steering Bracket

1-20151-A………....Bracket Body  
2-TP3-1.980……….Spacer Tubes  
2-S275……………......3/8 x 4-1/4” SHCS  
2-S312……………......3/8 x 1” Hex Bolt  
1-20176-A………....Front Lower Support Bracket  
1-20176-B………....Rear Lower Support Bracket  
1-S268……………......3/8 x 3-1/4” SHCS  
2-S311……………......3/8 x 3/4” hex bolt  
6-S664……………......3/8 x 1” Washers

### Pulley kit

1-6322-A………....Water Pump Pulley  
1-7336-A………....Crank Pulley  
1-208-A………....Alternator Pulley  
1-307-A………....Alternator Pulley Cover  
1-221-A………....Alternator Fan  
1-314-A………....Water Pump Nose Cover  
1-394-A………....A/C Cover  
3-S028……………......8-32 x 3/8 SHCS  
1-S685……………....Lock Nut  
4-S183……………......5/16 x 5/8 SHCS  
3-S248……………......3/8 x 1” SHCS  
3-S124……………......1/4 x 3/4” Button Heads (or)  
3-S520……………......M6 x 20mm Button Heads  
1-623-A………....Keyway Power Steering Pulley  
1-624-A………....Press fit Power Steering Pulley  
1-360-A………....W/P Pulley Nose Cover  
3-S106……………......1/4 x 1-1/4” SHCS

The following is included in kits

23073-Bracket & Pulley Kit for Keyed P/S  
23083-Bracket & Pulley kit for Press fit P/S  
BA23073-Brackets & Pulleys Billet Alt & P/S & A/C Unit Aluminum Water Pump  
CA23073-Brackets & Pulleys Chrome Alt & P/C & A/C Aluminum Water Pump

I.D. Numbers for aftermarket parts in BA/CA Kits

P304……....Chrome Power Steering Pump  
9600……....Billet Power steering unit  
P411……....Polish A/C unit  
P412……....Chrome A/C unit  
P555……....Chrome Alternator unit  
9650……....Billet Alternator unit  
P126……....Long Water Pump  
P417……....A/C Line Adapter
**Photo-1**
Install the Crank Pulley (7336-A) using three 3/8 x 1” SHCS (S248). Now Install the Water Pump Pulley (6322-A) and the Water Pump Pulley Cap (314-A) use four 5/16 x 5/8 SHCS (S183).

**Photo-2**
Install the Alternator Bracket (23681-A) to the two tapped holes in the Water Pump. In the upper hole use a 3/8 x 1” SHCS (S248). In the lower hole use the 740-A Idler Pulley a 3/8 Washer (S666) securing with a 3/8 x 2-1/4” Hex Bolt (S324). Then add the Idler Pulley Cap (302-A) using three 8-32 x 3/8 SHCS (S022).

**Photo-3**
Install the rear A/C support (20129-B) . Use two 7/16 x 2-1/2” SHCS (S358) and shim the bracket from the block using two (TP7-1.625) Spacer Tubes 1-5/8” Long.

**Photo-4**
To mount the Alternator, First run the 3/8 x 6-1/2” SHCS (S284) or the 7/16 x 6-1/2” (S378), depending on the tapped hole in the head, thru the bracket. Then on the back side of the bracket add a (TP7-2.000) Spacer tube (2”), then use the Alt Rear Support (23681-B) then stack a 2-3/4” Spacer Tube (TP7-2.750) securing to the block as shown.
Now in the upper hole of the Main Bracket use a 3/8 x 3” SHCS (S266) to secure the alternator threading it into the rear Alt Support as shown.
**Photo-5**
Mount the Alternator RE-locator (20140-A) to the top of the Alternator Ear backside with a 5/16 x 7/8 SHCS (S144). Then attach the (RA-1.625) Adjustment Rod to the RE-locator and the Water Pump with two 3/8 x 1” SHCS (S248). Now add the Alt. Fan (221-A) the Alt. Pulley (208-A) using the (S685) Lock Washer, then add the (307-A) Pulley Cap using three 8-32 x 1” SHCS (S028).

**Photo-6**
Mount the A/C Unit to the two lower tangs using two M8 x 20mm SHCS (S550). Also add the (394-A) A/C Cover using three 1/4 x 3/4” Button Heads (S124) or three M6 x 20mm Button Heads (S520) depending on the clutch tapped holes.

**Photo-7**
Line up the rear A/C Support Bracket with the Rear A/C Ear and secure the two with a 5/16 x 1-1/2” SHSC (S150) and a 5/16 Lock Nut (S616).

**Photo-8**
Mount the two Power Steering Lower Brackets (20176-A) on the front of the pump using two 3/8 x 3/4” Hex Bolts (S311). On the rear of the pump mount the (20176-B) using one 3/8 x 1” Hex Bolt (S312) and a 3/8 Washer (S664).
Photo 9
Mount the Front Power steering bracket (20151-A). Use two (TP3-1.980) Spacer Tubes and two 3/8 x 4-1/4” SHCS (S275). Mount the Power Steering Pump to the thru hole on the Water Pump using a 3/8 x 3-1/4” SHCS (S268). NOTE: Extra Washers are provided due to different heights and locations of the P/S mounting boss, use them as shims as needed to line up your P/S unit with the crank.

Thru the Slot use a 3/8 x 1” Hex Bolt (S312) with a 3/8 Washer (S664) use the extra washers as shims as necessary.

Photo-10
Install the Power steering Pulley (623-A) Keyed or (624-A) Pressed. Once done install Power Steering Nose Cover (360-A) with three 1/4 x 1-1/4 SHCS (S106).

Photo-12
Install the Power Steering Belt 42-1/2” and tighten the belt using the slot. Now install the Alt & A/C belt 62-1/2” and adjust with the 2-1/2” Adjuster Rod.

Re-Check all Bolts and Pulleys and Belt Alignment before starting.
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.

This Limited Warranty does not cover or apply to any damage or loss sustained to the engine or any other parts which may have been caused by the defective Product and does not cover or apply to any personal injury, labor charges or any other incidental costs for damages caused by the defective Product. **THIS IS THE ONLY EXPRESS WARRANTY GIVEN WITH RESPECT TO YOUR PRODUCT. ALL OTHER EXPRESS WARRANTIES, GUARANTEES, OR STATEMENTS REGARDING THE PRODUCT, WHETHER WRITTEN OR VERBAL, ARE HEREBY DEEMED NULL AND VOID AND OF NO EFFECT.**

Normal wear and tear and damage to the Product not caused by March Performance are also excluded from this Warranty.

**DISCLAIMER OF OTHER WARRANTIES**
EXCEPT TO THE EXTENT PROHIBITED BY APPLICABLE LAW, ANY IMPLIED WARRANTY WHETHER OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR WARRANTY, SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY WILL LAST SO THAT THE PRECEDING LIMITATION MAY NOT APPLY TO YOU.

**Limitation on Remedies**
REPAIR OR REPLACEMENT AS PROVIDED IN THIS WARRANTY IS YOUR EXCLUSIVE REMEDY. MARCH PERFORMANCE SHALL NOT BE LIABLE FOR ANY INCIDENTAL OR CONSEQUENTIAL DAMAGE FOR BREACH OF ANY EXPRESS OR IMPLIED WARRANTY ON THE PRODUCT. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES SO THE PROCEEDING LIMITATION OR EXCLUSIONS MAY NOT APPLY TO YOU. YOU HAVE NO RE COURSE OR REMEDY FOR DAMAGE OR DEFECT CAUSED BY MISUSE, ABUSE OR NEGLIGENCE.

**This Warranty gives you specific rights and you may also have other rights, which may vary from state to state.**

**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**
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 resalvable 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**