Highly Styled, Low Cost Serpentine Drive

Installation Instructions

Chevy Big Block Electric

Water Pump Bracket Kit

#23115 (Alternator A/C & Power Steering Pump)
**Parts List**

**Main Bracket 21201-A**
- 4 - (S338) ............ 3/8 x 2 1/2” Studs
- 4 - (Q76) ............ Paper Gaskets
- 4 - (S776) ............ 3/8 x 2.720 Spacers
- 4 - (S252) ............ 3/8 x 1 1/2” SHCS
- 1 - (S055) ............ 3/8 x 4 1/2” SHCS
- 1 - (TP3-.700) ...... Tube Spacer
- 2 - (MM100)....... Alum. Bushings
- 2 - (S553) ............ M8 x 1.25 x 35 MM SHCS
- 1 - (S551) ............ M8 x 1.25 x 25 MM SHCS

**Alt Support Bracket 21202-A**
- 1-(S450) ............ Threaded Bushing

**A/C Support Bracket 21203-A**
- 1 - (S150) ............ 5/16 x 1 1/2” SHCS
- 1 - (TP3-.300) ..... Tube Spacer
- 2 - (RN6-650) ..... Washers
- 1 - (23101-A) ...... Left Idler Bracket
- 1 - (23102-A) ...... Right Idler Bracket

**Power Steering Bracket 21204**
- 2 - (S556) ............ M8 x 1.25 x 40K k SHCS
- 2 - (S134) ............ 7/16 x 2 3/4” SHCS

**Pulleys**
- 1 - (345-A) .......... W/P Cover (4) (S047)
- 1 - (394-A) ........... A/C Cover
- 1 - (221-Ø) .......... Alt Fan
- 1 - (208-Ø) .......... Lt Pulley
- 1 - (307-Ø) .......... Alt Pulley Cap
- 1 - (650-Ø) .......... P/S Pulley
- 1 - (7666-Ø) ....... Crank Pulley
- 2 - (740) .............. Idlers
- 2 - (S264) ............ 3/8 x 2-3/4 SHCS
- 2 - (Q66) ............. Washers

**MARCH AJUST. TOOL 21206**
- 1 - Ø 572", "Alternator
- 1 - (P412) .......... A/C unit
- 1 - (P900) .......... BB Electric W/P
- 1 - (P315) .......... P/S Unit

**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
- 3/4” Allen Head Driver
- 6mm Allen Head Driver
- 5/8” Combo Wrench
- 9/16” Combo Wrench
- 11/16” Combo Wrench
- 3/4” Combo Wrench
- Socket Wrench & Extension
- 10mm 12pt. socket
- 12mm 12pt. socket
- 70.5” Serpentine Belt

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**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

Installing the Kit

Photo-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 the (4) 3/8x 2 1/2” mounting studs (S338) into the four water pump mounting holes 1/2” inch deep into block as shown. Using a sealer install (2) Paper Gasket (S676) over the studs,

Photo-2 Slide the rear A/C Support (21203-A) and the rear Alt Support (21202-A) over the studs and using a sealer add the Second Pair of Gaskets (S676).

Photo-3 Slide the CSR Electric Water Pump (P900) over the four studs, and secure with Four 3/8 x 2.720 Long Threaded Spacers (S776). You can also add the Electric Water Pump Cover (345-A) at this time using the Four 10/32 x 3” SHCS (S047).

Photo-4 Using four 3/8 x 1 1/2”SHCS (S252) install the Main Front Plate (21201-A) along with the two Rear Idler Brackets (23101-A) Left Side and (23102-A) Right Side.

Photo-4a Note the Idler Brackets will mount behind the Main bracket with the tapped holes pointing inward to the centerline of the motor. Install the idler brackets and the main plate at the same time.
Photo-5 Install the rear Adjustment Spacer (S450) into the rear Alternator Support as shown.

Photo-6 Using one \( \frac{3}{8} \times 4\frac{1}{2} '' \) SHCS (S055) through the Main Bracket, install the Alternator (P572), Put a .700 spacer (TP3-.700) behind the alternator mounting ear and adjust the Adjustment Spacer (S450) so its tight to the back of the alternator. In the upper slot use a MM100 Bushing and a M8 x 1.25 x 35 mm SHCS (S553).

Photo-7 Installing the A/C Snit (P412), Thru the front top slot In the main Bracket install a M8x1.1.25 x 35 MM SHCS (S553) and a MM100 Bushing (as per Alternator side). Through the bottom Front of the main bracket use a M8 x 1.25 x 25 MM SHCS. (S551) Thru the Rear lower A/C Ear use a \( \frac{5}{8} \times 1\frac{1}{2} '' \) (S150) SHCS and use a \( \frac{3}{8} \times .300 \) (TP3.300) Spacer between the rear Support ear and the rear A/C ear as shown. Install the A/C Cover (394-A) with the provided button head Screws.

Photo-8 Using two \( \frac{3}{8} \times 2\frac{3}{4} '' \) SHCS (S264) and two \( \frac{3}{8} '' \) Washers (666) mount the Idlers (740) To the Idler Brackets.

Between the Idlers and the Idler Brackets use the two (RN8 4650) Aluminum Spacers. Install the Idler Caps (302-A) using (3) \( \frac{5}{32} \times \frac{3}{8} '' \) SHCS (S022).

Photo-9 Install ? Alternator Dan (221-A) and Nalley (208-A) over the alternator shaft. Use the lockwasher (S685) and then tighten pulley nut (impact to 90 ft, pounds). Install Alt Cap (307-A) with (3) \( \frac{5}{32} \times 1 '' \) SHCS (S028).

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Photo-10 From the back of the Power Steering Bracket (21204-A) and using two M8 x 1.25 x 40k \( \text{SHCS (S556)} \) mount the Power Steering unit (P315) noting the Position of the pump (\textit{NOTE the back of the bracket has the 1-1/8 inch Hole}.)

Photo-11 Mount the Pump and Power Steering Bracket Unit to the block using two \( \frac{7}{16} \times 2\frac{1}{4}" \) SHCS (S134). Install the Power Steering Pump Pulley (650-?) with the three \( \frac{5}{16} \times \frac{7}{8}" \) SHCS

Photo-12 Apply Loc-Tite to the threads of the (3) \( \frac{3}{8}-16 \times 1" \) SHCS (S248). Place the Arank Pulley (7666-A) on damper and align holes. Thread the (3) screws through pulley and into damper, tighten firmly (50 ft/lbs.)

Photo-13 Push the Alternator and A/C inward you may have to remove one of the MM100 bushings and the bolt. Install the 70\(1/2" \) Long Belt routing as shown.

Photo 14 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 8M socket head cap screws when correct belt tension has been achieved. Remove the adjustment tool and keep for future use.

\textbf{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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2. To avail yourself of this Limited Warranty, return the Product with a copy of the paid receipt, postage paid to:
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   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.
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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
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Please Complete the Information below, detach and include with returned product.
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Purchaser’s Name__________________________________________ Phone______________________________
Address_______________________________________________________________________________________
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Product ID_________________________________________________ Invoice Date_________________________
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