CHEVY BIG BLOCK LONG WATER PUMP PERFORMANCE BILLET BRACKETS

23685 ALT/AC Bracket & Pulley Kit
23690 ALT/AC/P/S Bracket & Pulley Kit
### Parts List:

#### Alt & A/C Bracket

- 1 – 23681-A .......... Alternator & AC Brkt
- 1 – 23681-B .......... Alternator Rear Bracket
- 1 – 20129-B .......... A/C Rear Support Brkt
- 1 – 20140-A .......... Alt. Relocation Bracket
- 1 – S144 ............... 5/16-18 x 7/8” SHCS
- 3 – S248 ............... 3/8-16 x 1” SHCS
- 1 – RA-1.625 .......... Adjustment Rod 1-5/8”
- 2 – TP7-1.625 .......... Spacer Tube 1-5/8”
- 1 – TP7-2.000 .......... Spacer Tube 2”
- 1 – TP7-2.750 .......... Spacer Tube 2-3/4”
- 1 – S266 ............... 3/8-16 x 3” SHCS
- 1 – S150 ............... 5/16-18 x 1-1/2” SHCS
- 1 – S282 ............... 3/8-16 x 6” SHCS
- 1 – S324 ............... 3/8-16 x 2-1/4” Hex Bolt
- 2 – S358 ............... 7/16-14 x 2-1/2” SHCS
- 1 – S376 ............... 7/16-14 x 6” SHCS
- 2 – S550 ............... M8-1.25 x 20mm SHCS
- 1 – S616 ................ 5/16 Lock Nut
- 1 – 740-A .......... Idler Pulley
- 1 – S666 ............... 3/8 Washer
- 2 – S260 ............... 3/8-16 x 2-1/4” SHCS

#### Pulley Kit

- 1 – 6322-A .......... Water Pump Pulley
- 1 – 7336-A .......... Crank Pulley
- 1 – 208-A .......... Alternator Pulley
- 4 – S183 ............... 5/16-18 x 5/8 SHCS
- 3 – S248 ............... 3/8-16 x 1” SHCS
- 1 – 623-A .......... Keyway PS Pulley (23690 Kit)

#### Accessories

- P300  Black Power Steering Unit
- P425  A/C Unit
- P580  Black Alternator
- P120  Water Pump
- P419  A/C Line Adapter

#### 20151 Power Steering Bracket

- 1 – 20151-A .......... Bracket Body
- 2 – TP3-1.980 .......... Spacer Tube 1.980”
- 2 – S275 ............... 3/8-16 x 4-1/4” SHCS
- 2 – S312 ............... 3/8-16 x 1” Hex Bolt
- 1 – 20176-A .......... Frt Lower Support Brkt
- 1 – 20176-B .......... Rear Lower Support Brkt
- 1 – S268 ............... 3/8-16 x 3-1/4” SHCS
- 2 – S311 ............... 3/8-16 x 3/4” Hex Bolt
- 6 – S664 ............... 3/8 x 1” Washer
- 3 – S666 ............... 3/8 x 3/4” Washer

#### Note: Kit Color Codes

-08  Black
-09  Silver
**Photo-1**
Install the Water Pump to the block with gaskets in between the block and the pump. Use two 3/8-16 x 2-1/4" SHCS (S260) to secure the pump on the passenger side. Now install the Alternator Bracket (23681-A) to the two tapped holes in the W/P. In the upper hole use a 3/8 x 1" SHCS (S248). In the lower hole use a (740-A) idler and a 3/8 Washer (S666) securing with a 3/8 x 2-1/4" Hex Bolt (S324) as shown.

**Photo-2**
Mount the Front Power Steering Bracket (20151A-08). Use two (TP3-1.980) Spacer Tubes and two 3/8 x 4-1/4" SHCS (S275).

**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**
Mount the Alternator (P580). First run the 3/8 x 6" SHCS (S282) or the 7/16 x 6" (S376) thru the bracket. Depending on the tapped hole in the head. Then on the back side of the bracket add a (TP7-2.000) Spacer Tube (2") the use the Alt Rear Support (20126-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 (20140A-08) 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. Pulley (208A-08) using the (S685) Lock Washer.

**Photo-6**
Mount the A/C Unit (P425) to the two lower tangs of the Alternator Bracket using two M8 x 20mm SHCS (S550).

**Photo-7**
Line up the rear A/C Support Bracket (20129-B) 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 (S666).  
NOTE: If the power steering pump has a stud in the rear it must be removed. Due to variations in the W/P ear thickness more then one (S666) washer may be needed for shimming.
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 1-5/8 " Adjuster Rod. To install Alt belt, disconnect Adjustment Rod, move Alt inward and install belt. Re-Check all bolts and pulleys and belt alignment before starting.

Photo-9
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. Now thru the slot use a 3/8 Washer (S666) and a 3/8 x 1” Hex Bolt (S312).

Photo-10
Install the Power Steering Pulley (623-A) to pump and tighten with supplied Lock Nut.

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 1-5/8 " Adjuster Rod. To install Alt belt, disconnect Adjustment Rod, move Alt inward and install belt. Re-Check all bolts and pulleys and belt alignment before starting.

Photo-9
Install the Power Steering Pulley (7336-A) using three 3/8 x 1” SHCS (S248). Now install the Water Pump Pulley (6322-A) using four 5/16 x 5/8 SHCS (S186).
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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.
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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.

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Address ___________________________

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