Highly Styled, Low Cost Serpentine Drive

Installation Instructions

Ford Small Block 289-302-351 Windsor
Kit #30420 (with Power Steering)
and #30410 (without Power Steering)
### Included Parts List

**Main Front Bracket PN 30411**
1. - 30411-A......Face Plate Body
2. - TP3-1.100.....Tube Spacers
2. - MM-100 ......Bolt Adjustment Sleeves
4. - S144 ............\(\frac{3}{16}\) - 18 x \(\frac{3}{8}\)" SHCS
2. - S150 ............\(\frac{3}{16}\) - 18 x 1\(\frac{1}{2}\)" SHCS
1. - S155 ............\(\frac{3}{16}\) - 18 x 2" SHCS
2. - S174 ............\(\frac{3}{16}\) - 18 x 5\(\frac{1}{4}\)" SHCS
3. - S209 ............\(\frac{3}{16}\) - 18 x 3\(\frac{1}{4}\)" STUD
2. - S551 ............M8 - 1.25 x 25mm SHCS
2. - S553 ............M8 - 1.25 x 35mm SHCS
2. - S616 ............\(\frac{3}{16}\)" Lock Washer
5. - S660 ............\(\frac{3}{16}\)" Flat Washer
3. - S769 ..........Threaded Stainless Spacer

**Alternator Rear Support PN 30412**
1. - 30412-A......Alt Rear Support Body
1. - S248 ............\(\frac{3}{8}\) - 16 x 1" SHCS
1. - S278 ............\(\frac{3}{8}\) - 16 x 5" SHCS
1. - S344 ............\(\frac{3}{16}\) - 14 x 1" SHCS
1. - S450 ............\(\frac{3}{16}\) - 18 x 1\(\frac{1}{4}\)" Set Screw
1. - S672 ............\(\frac{3}{16}\)" Flat Washer SAE

**A/C Rear Support PN 30413**
1. - 30413-A......A/C Rear Support Body
1. - S150 ............\(\frac{3}{16}\) - 18 x 1\(\frac{1}{4}\)" SHCS
1. - S312 ............\(\frac{3}{16}\) - 14 x 1" Hex Head Bolt
1. - S385 ............\(\frac{3}{16}\) - 14 x 1" Hex Head Bolt
1. - S672 ............\(\frac{3}{16}\)" Flat Washer SAE

**Power Steering Bracket PN 30414 (for kit # 30420)**
1. - 30414-A......Front Power Steering Bracket Body
1. - 30414-B......Rear Power Steering Bracket Body
1. - 30019-C......Timing Pointer
2. - S160 ............\(\frac{3}{16}\) x 2\(\frac{3}{4}\)" SHCS
2. - S550 ............M8 - 1.25 x 20mm SHCS

**Pulleys Kits PN 2280-206**
1. - 2281-A......Crank Pulley Body
1. - 2282-A......Water Pump Pulley Body
1. - 221..............Alt Fan
1. - 206-A......Alt Pulley Body
1. - 306-A......Alt Pulley Cap Body
1. - 322-A......Water Pump Pulley Cap Body
1. - 394-A......A/C Pulley Cover Body
3. - S028 ............\(\frac{3}{16}\) x 1" SHCS
3. - S520 ............\(\frac{1}{2}\) - 1.0 x 16mm Button Head Bolts
4. - S186 ............\(\frac{1}{16}\) - 24 x \(\frac{3}{4}\)" SHCS
4. - S248 ............\(\frac{3}{16}\) - 16 x 1" SHCS
1. - S685 ............\(\frac{1}{16}\)" Alt Lock Washer
1. - 618-A......Power Steering Pulley (for kit # 30420)
1. - 302-A......Power Steering Pulley Cap (for kit # 30420)
3. - S022 ............\(\frac{3}{16}\) x \(\frac{3}{8}\)" SHCS (for kit # 30420)

**Belt Tensioner Tool**
1. - MM101......RH Aluminum Rod End
1. - MM102......LH Aluminum Rod End
1. - MM105......Threaded Rod Aluminum 13" Long

**Timing Pointer Bracket PN 30417 (for Kit 30410)**
1. - 30019-A......Pointer Bracket Body
2. - TP3-650.....Spacer Tube
2. - S144 ............\(\frac{3}{16}\) - 18 x \(\frac{3}{8}\)" SHCS
2. - S158 ............\(\frac{3}{16}\) - 18 x 2\(\frac{1}{4}\)" SHCS
1. - S616 ............\(\frac{3}{16}\) x 18 Nylon Lock Nut

**Accessories**
1. - P412..........Sanden A/C Compressor (chrome)
1. - P500..........Ford Water Pump with Front Cover
1. - P417..........A/C Line Kit
1. - P572..........Alternator Chrome Alum
1. - P315..........Remote Power Steering Pump (for kit # 30420)

### Required Tools and Materials

- RTV Silicone
- Loc-Tite® Thread Locker
- Gasket Scraper, Steel Wool or Sandpaper to clean gasket surfaces
- \(\frac{3}{16}\)" Allen Head Driver
- \(\frac{5}{16}\)" Allen Head Driver
- \(\frac{1}{4}\)" Allen Head Driver
- 6mm Allen Head Driver
- \(\frac{3}{16}\)" Combo Wrench
- \(\frac{5}{16}\)" Combo Wrench
- \(\frac{1}{4}\)" Combo Wrench

- \(\frac{3}{16}\)" Combo Wrench
- Socket Wrench & Extension
- 10mm 12pt. socket
- 12mm 12pt. socket
- 1994 to 1995 SVO Timing cover Gasket Set

- Serpentine Belt
  - Dayco #5060595 59\(\frac{1}{2}\)" 6 Rib Belt, for Kits With Power Steering
  - Dayco #5060575 57\(\frac{1}{2}\)" 6 Rib Belt, for Kits Without Power Steering
**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
- Remove the existing alternator, air conditioning compressor and associated brackets.
- Remove all pulleys and water pump.
- Remove all traces of old gasket and sealer with gasket scraper and steel wool pad.
- Clean threads in block by chasing with appropriate thread chasers.

**Installing the Kit**

FIG. 1. Ensure the sealing face of the coolant outlets are clean, flat and free of old gasket material. Assemble Water Pump to Timing Cover along with proper gaskets and a thin coat of RTV silicone sealant. Use the appropriate fasteners in locations A, B, and C, shown in the water pump drawing.
Fig-2: Ensure that the gasket sealing face on the engine block, oil pan and timing cover are clean, flat and free of old gasket material. Install Three (S209) $\frac{3}{16} \times 3\frac{1}{2}''$ studs into block at the locations shown.

Fig-3: Apply a thin coat of RTV silicone sealant to a new timing cover gasket and oil pan to timing cover gaskets. Install timing cover and (P500) water pump to block. Secure using the Three Threaded Stainless Spacer (S769) as shown in Fig-3. Add water pump and timing cover bolts in locations D, E, and F, (See Fig 1 for proper placement and bolt sizes.) Do not forget to reinstall the four factory bolts through the oil pan and into timing cover.

Fig-4: Mount the A/C unit Rear support Bracket (30413-A) to the lower passenger side head using a (S385) $\frac{7}{64}$ or (S312) $\frac{7}{32}$ x 1” Hex Head Bolt depending on tapped hole in head. Include a (S672) SAE Flat washer (Leave loose at this time).

Mount the Alternator Rear Support (30412-A) to the Drivers side head use a (S344) $\frac{7}{64}$ or (S248) $\frac{7}{32}$ x 1” SHCS depending on tapped hole in head Note position and leave loose at this time.

Install Threaded Bushing (S450) into rear Alternator bracket as shown.

Install the Rear Power Steering Bracket (30414-B) and timing mark. Mount the Timing Pointer (30019-C) over the Rear Power Steering Bracket and install with Two (S160) $\frac{5}{16}$ x 2$\frac{3}{4}$” SHCS Screws (leave loose at this time). NOTE: For kits without Power steering use Two (TP3-.650) Spacers in place of the Rear Power Steering Bracket to support the timing pointer.
**Fig-5:** Secure the Front Main Bracket (30411-A) using Two (S174) \( \frac{3}{16} \times 5\frac{1}{2} " \) SHCS along with Two (TP3-1.100) Spacers Between the Main bracket and the water pump. Install Three (S144) \( \frac{5}{16} \times 18 \times 3/8" \) SHCS through the Front Main Bracket and into the Three Threaded Stainless Spacer (S769).

**Fig-6:** Install (P572) Alternator, Line up (30412-A) Rear Alternator support with front main bracket installation hole. Use a (S278) \( \frac{3}{4} \times 5" \) SHCS, adjust Threaded Bushing (S450) to take up any slack between Alternator Lower Mount and brackets. Leave loose at this time but tighten rear alternator support bracket to block. In the top alternator hole use a (MM100) bushing and a (S553) M8 x 35mm SHCS (leave loose).

**Fig-7:** Place the compressor clutch cover (394-A) onto the compressor clutch and align. Thread the three (S520) M6 - 1.0 x 16mm button head bolt through the cover and into the clutch and tighten. **Caution – Do not overtighten!** Install (P412) A/C unit. Through the front main bracket install (S551) One M8 x 25 mm SHCS into the compressor lower mounting ear and One (S553) M8 x 35 mm into the upper mounting ear along with One (MM100) bushing, (leave both loose at this time).

**Fig-7a:** Secure the compressors rear mounting ear to the (30413-A) A/C Rear Lower Support using One (S150) \( \frac{3}{16} \times 1\frac{1}{2} " \) SHCS, leave loose. Tighten rear A/C support bracket to the block at this time with a \( \frac{3}{8} " \) wrench.
Fig-8: Apply Loc-Tite to the threads of Three (S550) M8 x 20 mm SHCS, Mount the Power Steering Pump (P315) to the Front power steering bracket (30414-A).

Fig-9: Install the power steering bracket and pump assembly to the Main Front Bracket (30411-A) with Two (S144) \(\frac{1}{16}\)-18 x \(\frac{7}{8}\) SHCS. Also secure pump to (30414-B) Rear Power Steering Bracket using One (S550) M8 x 20 mm SHCS. Tighten all front and rear support and timing pointer bolts. For kits without Power steering use Two (S616) \(\frac{1}{16}\)" nuts along with the (S144) \(\frac{1}{16}\)-18 x \(\frac{7}{8}\) SHCS to fill the holes.

Fig-10: Reinstall balancer to Proper position and Apply Loc-Tite to the threads and reinstall bolt. Apply Loc-Tite to the threads of the four (S248) \(\frac{3}{4}\)-16 x 1" SHCS. Place the crank pulley (2281-A) on damper and align holes. Thread the four bolts through pulley and into damper, tighten firmly (50 ft/lbs.)

Fig-11: Apply Loc-Tite to the threads of the four (S186) \(\frac{3}{8}\) -24 x \(\frac{7}{8}\)" SHCS. Place the water pump pulley (2282-A) and (322-A)Water Pump Cap to the water pump and thread the cap screws through pulley and into water pump pulley flange, tighten firmly (28 ft/lbs.) Install (221) Alternator Fan, (S685) Lock Washer and (206-A) Alternator Pulley.

Fig-12: Press (618-A) Power Steering Pulley on with a install tool or bolt and washer as shown. When properly installed pulley should be flush with top of shaft as shown and aligned with crank pulley.
If you are going to be installing your air conditioning hoses and charging the system at this time, remove the cover plate on top of the compressor body. Install the (P417) A/C adapter lines, hoses and connect clutch wire and charge system.

**Important:** If you are NOT installing hoses and charging the system at this time, leave cover plate on compressor. Do not connect the clutch wire or apply power to clutch wire without the hoses connected and the system charged – Serious damage will occur to compressor.
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