ALUMINUM PULLEY INSTALLATION INSTRUCTIONS

1. With belts still in place, remove center nut from alternator pulley. For best results, use an air impact.

2. Loosen water pump bolts and crankshaft bolts. DO NOT REMOVE.

3. Loosen accessories and remove all belts.

4. Remove pulleys, replace with new underdrive pulleys, no pullers should be necessary. If new bolts are supplied with your kit, use these instead of your original bolts. Use your original nut when installing alternator. Place lock washer between pulley and outer nut. Use Locktite 242 or equivalent on all nuts and bolts. When tightening use equal tension on all bolts.

5. To measure for new belts. select from your old belts the longest one and cut this belt in half. Start with your first accessories and place it near the front of its adjuster. Find where the two ends overlap and make a mark on the belt. Do this for all your accessories. When you are done, measure from the end of the belt up to the marks. Write the measurements down. They are your new belt lengths.

6. Install new belts an adjust for proper belt tension.

7. With all belts in place re-tighten all bolts on water pump and crankshaft. Use an air impact to re-tighten alternator nut.

8. Start motor momentarily, then stop. Recheck for proper tension and tracking.

CAUTION: Before installing new pulleys and with old pulleys removed from vehicle, measure to make sure the pulleys will line-up. (The easiest way to do this is get (2) equal height pop cans and place both water pump pulleys on them. With groove end down, set next to each other and eyeball the groove. A small misalignment of up to 1/16” is permissible.) It is Important that these measurements be taken to insure accurate alignment, Scratched or damaged pulleys are not returnable. Use non-abrasive cleaners (glass cleaner) on pulleys and brackets.

Note: While at an idle the amp meter needle may fluctuate depending on age of the vehicle, size of the alternator and amount of accessories being used at the time. This is normal for any underdrive pulley system. Setting idle speed a little higher will help. If while driving the needle goes in the red, this signals a problem.
ALWAYS MATCH PULLEYS BEFORE REPLACEMENT ON ENGINE
Scratched or damaged pulleys are NOT RETURNABLE

Matching Water Pump Pulleys
Please use this system to check pulleys for correct alignment before placing on engine. This system will work for V-groove and serpentine systems, and will prevent damage to new pulleys.

Use (2) equal height soda cans or equal height objects to set water pump pulley on. Check centerline of groove for alignment. If alignment is off more than 1/8" or the thickness of (2) quarters, do not use. Water pump pulley spacers are available ask your dealer.

Match Crank & Water Pump Pulley Hole Alignment
Place new pulley on top of old Pulley (end to end) to check bolt hole alignment.

Match Alternator Pulleys
Check for alignment on flat surface. Some factory pulleys are 2 pieces. Make sure you stack sleeve and pulley when matching with new pulley.

Cooling Systems
By slowing down the pump speed, the coolant has more time in the radiator, usually cooling as good, if not better, than before pulley installation

Charging Systems
AMP Meter needles will fluctuate depending on age of car and size of alternator. This is normal however, needle in the red area signals a problem.

Large Stereo Systems
If you have a larger than stock stereo system, DO NOT USE underdrive pulleys. You will incur charging problems.

Belt Throwing
Underdrives help prevent belts from being thrown off by reducing the speed in which your belts travel.
Example: 25% Underdrive Crank
6,000 RPM - 25% = 4,500 RPM
At 6,000 RPM’s, your system will he running the equivalent of only 4,500 RPM’s

Start-Up
After installation is complete, start and stop engine quickly. Then check to make sure all belts are on properly before driving

Matching Crank Pulleys
When checking crank pulleys, set pulleys on (2) equal size cups or rings and check center line of grooves for alignment. If alignment is off more than 1/8" or the thickness of (2) quarters, DO NOT USE,

Caution: Because an aluminum pulley must be made thicker than a steel pulley, the center shaft on the water pump may not protrude through the pulley to properly support a fan. March pulleys have been, engineered to fit properly. In some rare cases, if the center shaft of the water pump does not reach into the center hole of the fan, do not use it in conjunction with the March Performance aluminum pulley. In this situation, we recommend using a remote electric fan for cooling in place of the original fan.

*NOTE: NOT LEGAL TO USE IN CALIFORNIA ON POLLUTION CONTROLLED VEHICLES