

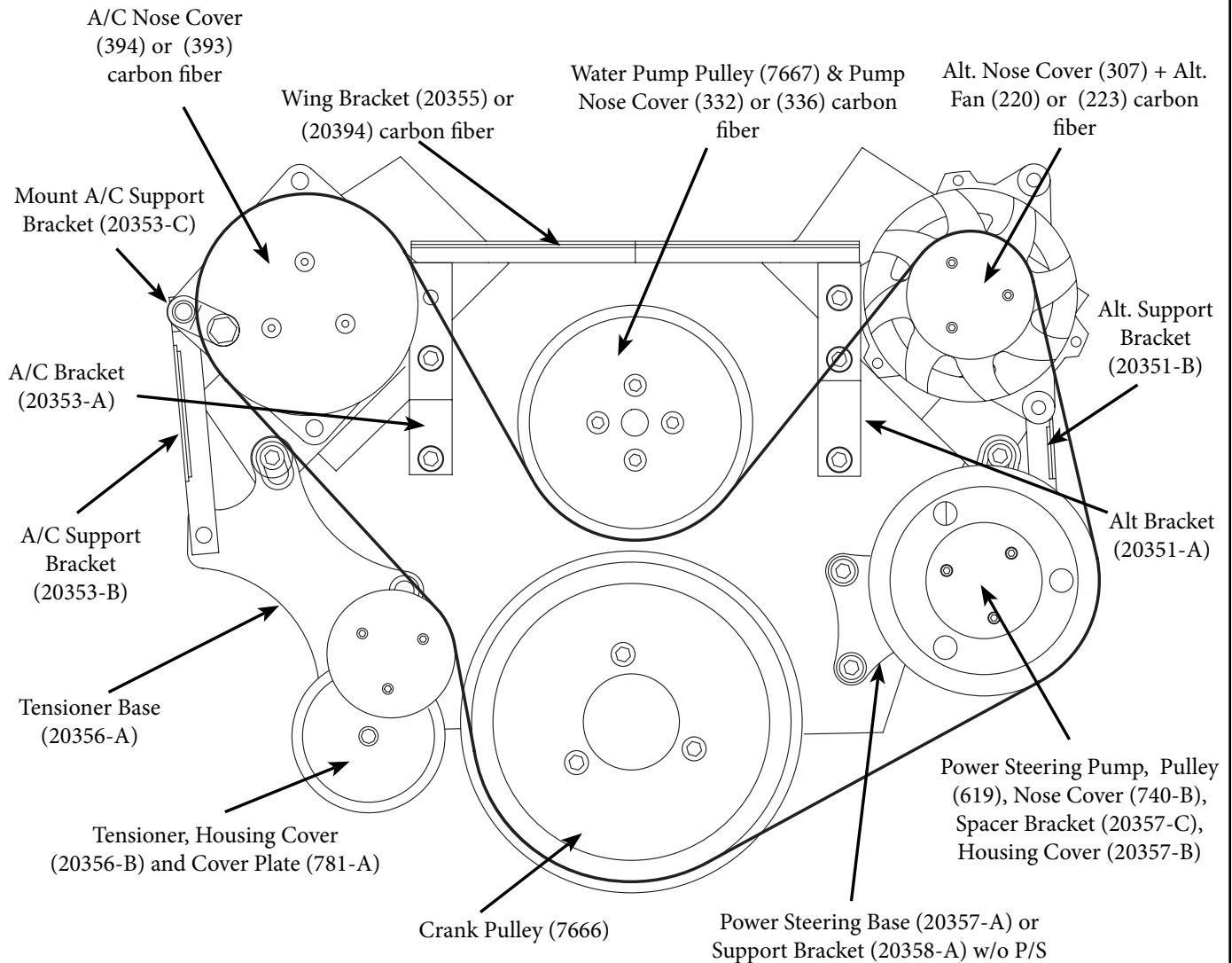
Chevy Big Block Front Mount Kit

Installation Instructions

*Kits #20350, #20360, #20370,
#20380 #20375, #20385*



Included Parts List



66" Serpentine Belt

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
 1/4" 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

66" Serpentine Belt

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

Photo-1 Hold the tensioner body in a vise to remove the bolt and washer from the tensioner pulley (**Note Bolt is left Handed Thread**) Remove and discard washer. Place the Tensioner Cover Plate (781-A) on the tensioner body then mount the Tensioner Nose Cover Adapter (780-A) on the tensioner pulley and replace the O.E.M Pulley as shown.



Photo-3 Mount the Tensioner Base Plate (20356-A) to the Engine Block using (2) $\frac{7}{16}$ -14 x 1" SHCS in the bottom two holes and a $\frac{7}{16}$ x 1 $\frac{1}{2}$ " SHCS in the Upper slot (**NOTE some upper head bolts are $\frac{3}{8}$ so use the provided $\frac{3}{8}$ x 1 $\frac{1}{2}$ " SHCS**). Between the head and upper bolt use (1) AC3-.500 Spacer.



Photo-2 Mount the Tensioner to the tensioner housing cover (20356-B) using a $\frac{3}{8}$ x 3" SHCS .

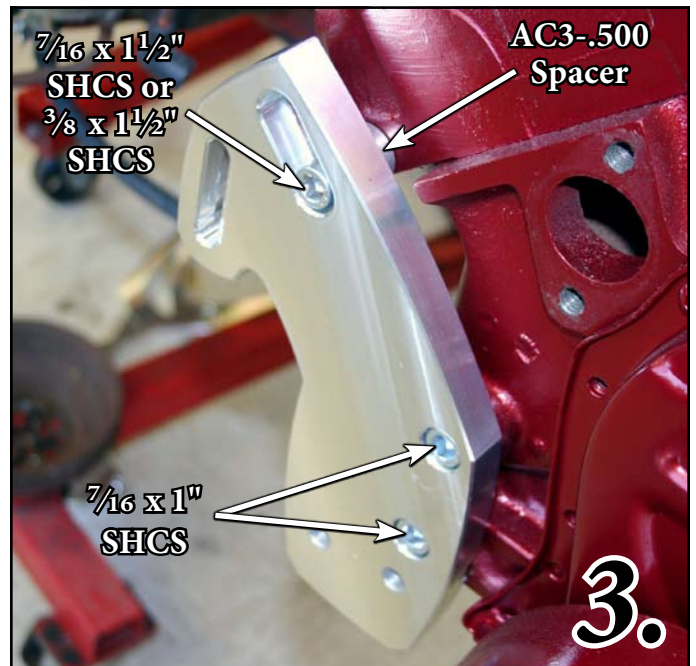


Photo-4 Mount the Tensioner And housing cover to the Base Plate using (2) $\frac{3}{8}$ x 1" SHCS as shown.



(FOR KITS WITH POWER STEERING)

Photo-5 Mount the power steering Spacer Bracket (20357-B) & Power Steering Housing Cover (20357-C) and the power Steering pump together using (2) M8 x 1.25 x $\frac{3}{4}$ " SHCS.

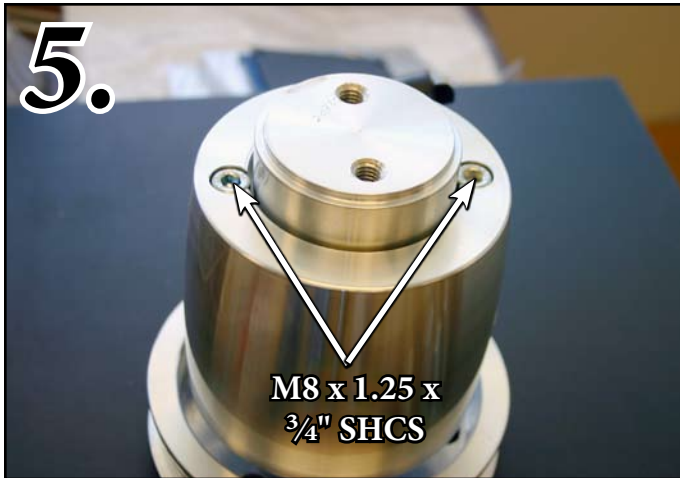


Photo-6 Mount the power Steering base (20357-A) to the power steering cover using (2) $\frac{3}{8}$ x 1" SHCS.

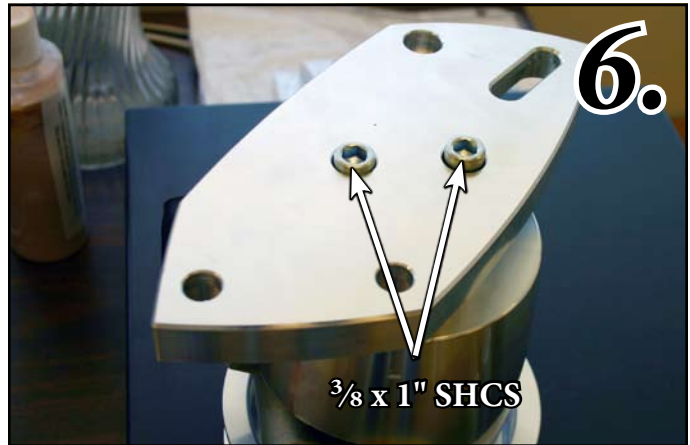


Photo-7 Install the Power Steering unit to the Engine block using (2) $\frac{7}{16}$ x 1" SHCS in the lower holes and (1) $\frac{3}{8}$ x $\frac{3}{4}$ " SHCS in the upper head Bolt or a $\frac{7}{16}$ x $\frac{3}{4}$ " (NOTE we have already installed the P/S pulley this can be done now or at a later time). For kits without power steering mount the main plate the same way as above skipping installing the Power Steering unit itself.

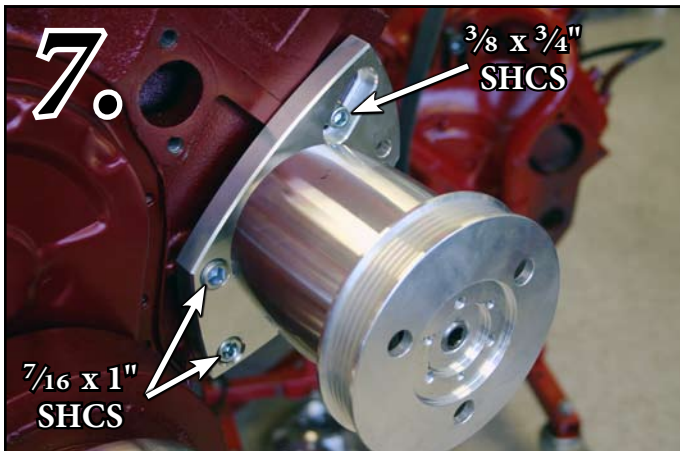


Photo-8 Installing the Alternator Bracket (20351-A) to the alternator, use a $\frac{3}{8}$ x $3\frac{1}{2}$ " SHCS thru the front of the bracket in the rear bore of the bracket use a positive positioning bushing (shown) and a $\frac{3}{8}$ " lock nut.

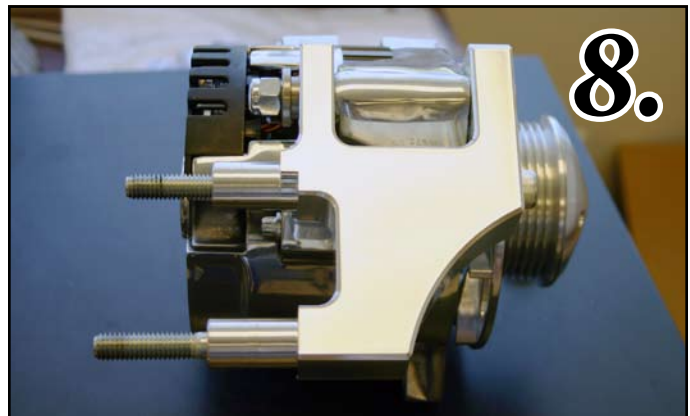
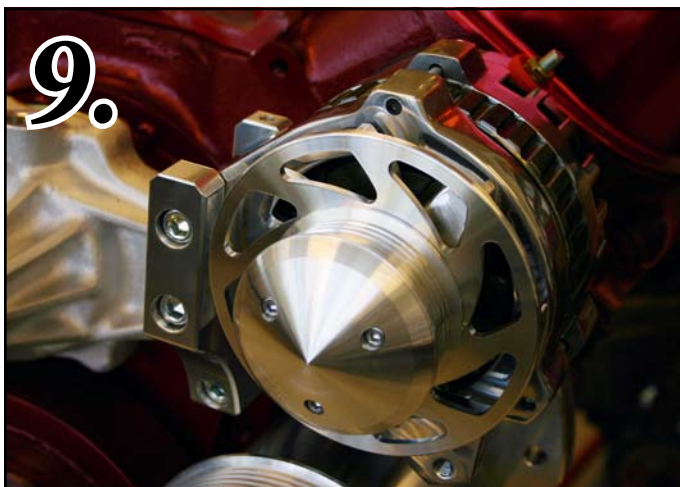


Photo-9 Installing the Alternator Bracket, use a $\frac{3}{8}$ x $3\frac{3}{4}$ " SHCS (Lower Hole) and a $\frac{3}{8}$ x $5\frac{1}{2}$ " (upper hole) thru the water pump. And into the block as Shown.



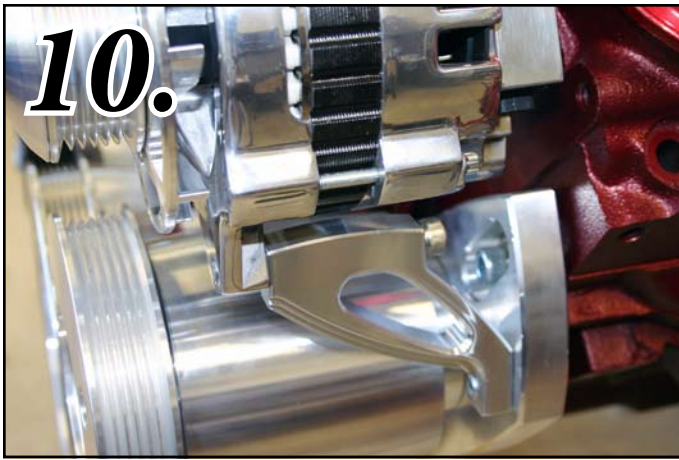


Photo-10 Install the Alternator Support Bracket (20351-B) to the Alternator using a 8mm x 1.25 x 70 mm SHCS. Noting the bolt mounts from the rear of the bracket. Then in the lower hole use a $\frac{3}{8}$ x 1" SHCS thru the support plate on the block into the lower Support hole. Install the Alt Fan ,Alt pulley, and Alt. Cap at this time ,

Photo -11 Installing the A/C unit to the A/C mounting bracket, Use a 8mm x 100 mm Hex bolt thru the rear of the A/C unit Noting the A/C unit mounts to the left side of the bracket.

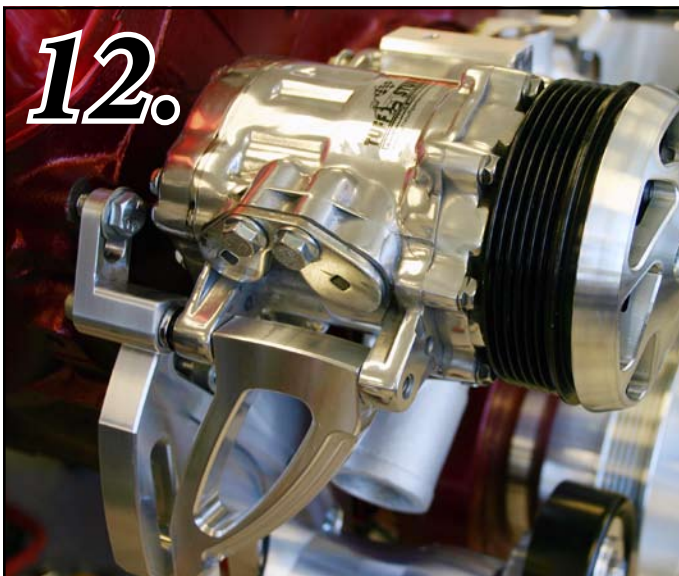
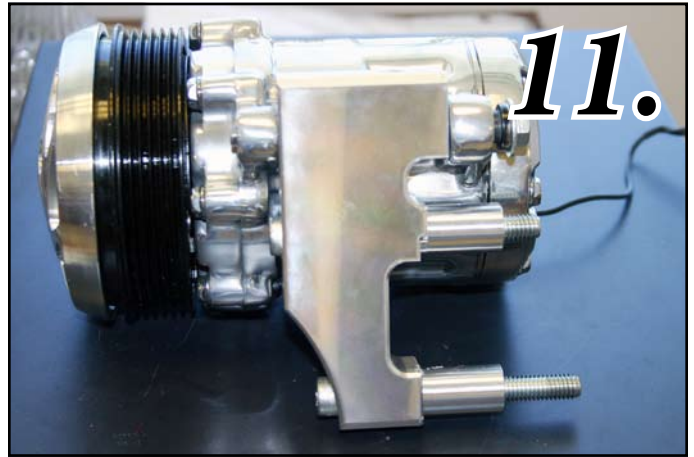


Photo-13 Installing the wing Support use the two $\frac{1}{4}$ x $\frac{3}{4}$ flat heads , if the holes are not inline loosen the A/C and Alt main brackets a bit .

Photo-12 Its important to look at this photo! Mount the A/C support Bracket (20353-B) and A/C support Bracket (20353-C) using (1) 8 mm x 120 mm long SHCS thru the Rear support (mounting to the head) thru the rear A/C ear then thru the A/C side support bracket into the Front A/C ear.

The Rear Support Bracket mounting to the head uses a $\frac{3}{8}$ or $\frac{7}{16}$ x 1" Hex bolt. Leaving the two front $\frac{3}{8}$ x $3\frac{1}{2}$ " SHCS loose that mount the A/C bracket thru the water pump until you have install the side supports as shown. Snug the two A/C bracket mounting bolts. And the rear support hex bolt. In the lower A/C side support bracket you will use a $\frac{3}{8}$ x 1" SHCS. Leave loose for now for later belt installation,

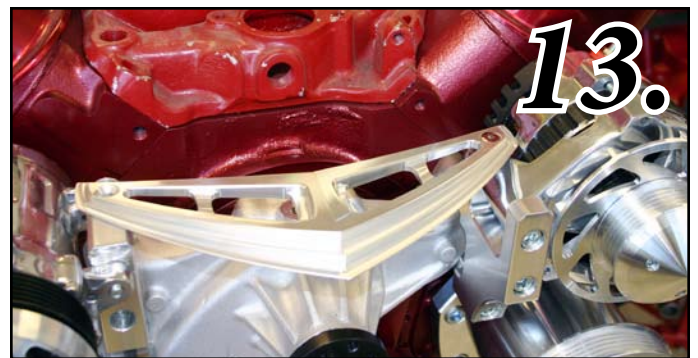
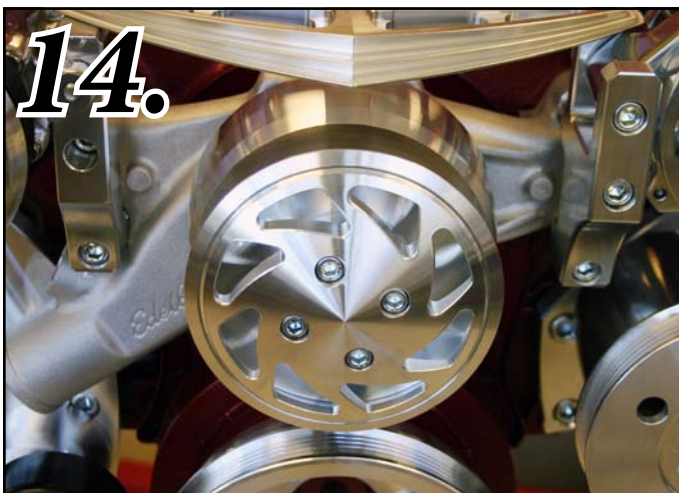


Photo-14 . Mount Water Pump Pulley (7667) & Water Pump Nose Cover (332) to Water Pump using four (4) $\frac{5}{16}$ "-24 x 1 $\frac{1}{2}$ " socket head cap screws. Also install the A/C cover .

Photo-15. Apply Loc-Tite to the threads of the three (S248) 3/8"-16 x 1" SHCS. Place the crank pulley (7666-A) on damper and align holes. Thread the (3) screws through pulley and into damper, tighten firmly (50 ft/lbs.)

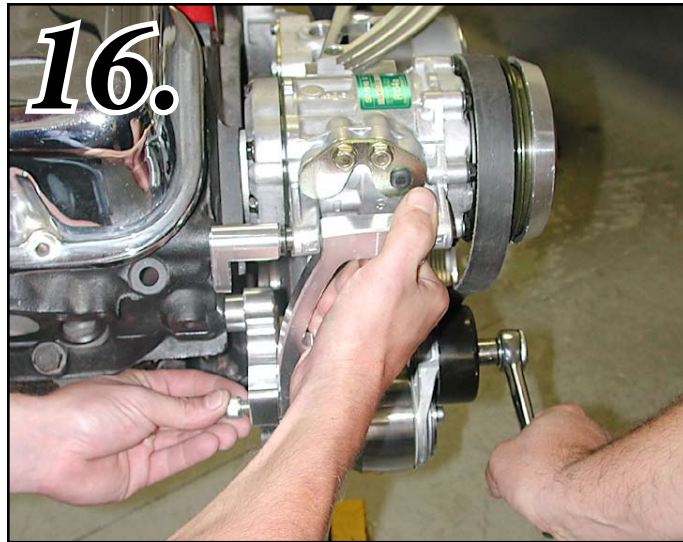


Photo-16 INSTALLING THE BELT

The belt Size for this kit is a 66" Remove or loosen the lower A/C support bracket bolt to allow the A/C to drop down. Pull the tensioner over with a ratchet and install the belt while its still in the loaded position raise the A/C up and reinstall the 3/8"-16 x 1" socket head cap screw.

Tighten A/C Support Bracket (20353-B) to A/C Compressor. Tighten A/C Bracket (20353-A) to A/C Compressor (release tensioner load).

Mount Tensioner Nose Cover (307) to Tensioner Nose Cover Retainer (780-A) using three (3) 8/32"- 5/8" socket head cap screws.



Check and tighten all bracket bolts and alternator and A/C 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.

Final Assembly

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.*

**MARCH PERFORMANCE, INC. • 16160 PERFORMANCE WAY • NAPLES, FLORIDA 34110
LIMITED WARRANTY**

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.

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

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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:
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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.
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 reshelvable 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 ****