



## FM1320PC SBC Top Mount A/C Bracket

Tools Required: 9/16" Open-end wrench  
5/32" Allen wrench Anti-seize  
1/4" Allen wrench  
3/16" Allen wrench  
5/16" Allen wrench  
1/2" Open-end wrench

Recommended Belt: Goodyear Poly-V 6 Rib #4060555 (55.5") or Dayco #5060555 (55.5")

- 1) Disconnect Battery; remove all existing accessory drive brackets and components from motor.
- 2) Place the idler stand-off into the compressor bracket. Note: Idler stand off has an oval key that fits into like receptacle on bracket. Thread the 3/8-16 x 2-1/4" socket head cap screw through the back of the compressor bracket into the idler stand off bracket and tighten. This fastener will be torqued following the next step.
- 3) Attach the compressor bracket to the driver side cylinder head by threading a 3/8-16 x 3/4" socket head cap screw through the bottom left hole in compressor bracket and into cylinder head. Next thread a 3/8-16 x 3/4" socket head cap screw through the right hole in compressor bracket and into the cylinder head. Tighten both firmly (46ft/lbs each). At this time tighten the idler stand off bolt from step 2 (46 ft/lbs).
- 4) Attach the turnbuckle assembly to the remaining hole in compressor bracket by threading a 3/8-16 x 1-3/4" socket head cap screw through the turnbuckle assembly and 3/16" load washer and compressor bracket and into the cylinder head. Tighten firmly (46 ft/lbs). Swing turnbuckle to rest on water pump.
- 5) At this time remove the top 3/8-16 X 3/4 socket head cap screw from the power steering bracket and set aside.
- 6) Install the compressor by aligning the compressor bosses with the compressor bracket, thread the 3/8-16 x 5" socket head cap screw through the compressor and bracket. Thread the 3/8-16 nut and 3/8" lock washer onto the back and finger tighten.
- 7) Thread the 3/8-16 x 1" socket head cap screw through the front compressor ear (see figure) and into the 1-3/4" long front spacer nut and tighten. Swing the compressor up to match up the front spacer nut with the turnbuckle assembly, thread the 3/8-16 x 2-1/2" socket head cap screw through the rear compressor ear (see figure) and through the 1-1/16 spacer and turnbuckle assembly into the front spacer nut and tighten.

Works with the following Billet Specialties part numbers;  
FM 2111PC & FM2112PC SBC Top Mount - Alternator & Power Steering Kit.  
FM 2121PC & FM2122PC SBC Mid Mount - Alternator & Power Steering Kit.

If you do not have either of the above kits - Do Not Attempt to Install

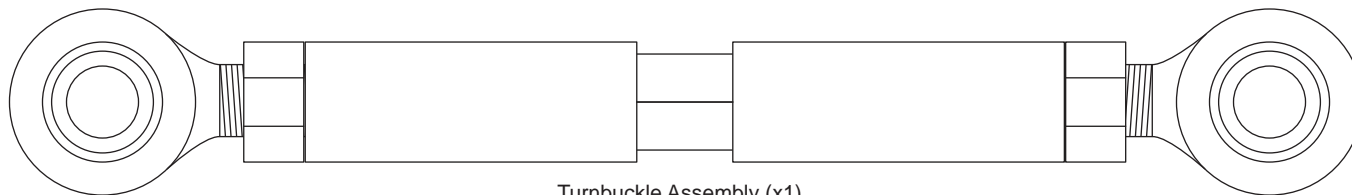
- 8) Place the stainless bearing sleeve into one of the 2-1/2" diameter idler pulleys (long end of the sleeve goes into the bearing from the backside of the pulley). Insert assembly into the upper hole of the power steering bracket. Thread the 3/8-16 x 2-1/2" socket head cap screw with 3/8" x 7/8" OD stainless washer through the pulley and sleeve into the power steering bracket and tighten. Install the pulley cover with three #10-32 x 1/2" socket head cap screws and tighten. Install the compressor cover with three 1/4-20 x 3/4" socket head cap screws and tighten
- 9) Route belt as seen in figure 2. Place stainless bearing sleeve into 2-1/4" dia. idler pulley (long end of the sleeve goes into the bearing from backside of pulley). Place idler pulley on belt and push belt and pulley into position to line up with compressor bracket boss. Thread 3/8-16 x 2-1/4 socket head cap screw with a 3/8" x 7/8" OD stainless washer through the pulley and sleeve into the 1-1/2" aluminum idler stand off. Tighten firmly (46 ft/lbs). Install pulley cover with three #10-32 x 1/2" socket head cap screws and tighten.
- 10) Adjust belt tension by twisting the two turnbuckle assemblies by hand until proper belt tension is achieved. Do not over-tighten belt! Serious damage may occur to the accessory drive bearings resulting in premature wear. Tighten jam nuts on turnbuckle; tighten alternator socket head cap screws (46 ft/lbs). Tighten compressor socket head screws (46 ft/lbs) and compressor swivel bolt and nut with lock washer firmly. Re-check belt tension.
- 11) Reconnect electrical and install A/C lines and fittings. Caution: Do not connect A/C compressor electrical until system is properly charged. Test run motor and re-check belt tension adjust if necessary. Re-check belt tension after 100 miles.





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Tools Required:  
 5/32" Allen wrench  
 1/4" Allen wrench  
 3/16" Allen wrench  
 5/16" Allen wrench  
 1/2" Open-end wrench  
 9/16" Open-end wrench  
 Anti-seize

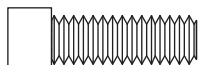


Turnbuckle Assembly (x1)

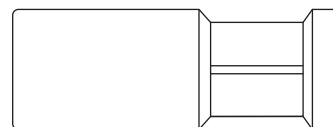
Recommended Belt: Goodyear Poly-V 6 Rib #4060555 (55.5")



#10-32 x 1/2" Socket Head Cap Screw (x6)



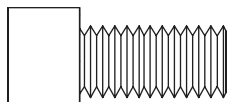
1/4-20 x 3/4" Socket Head Cap Screw (x3)



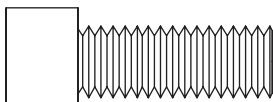
1-3/4" Front Spacer (x1)



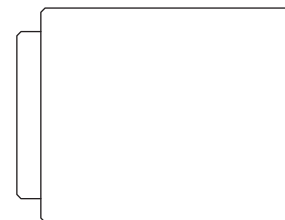
1-1/16" Rear Spacer (x1)



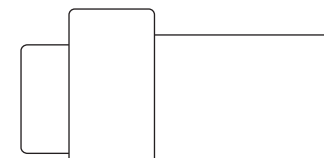
3/8-16 x 3/4" Socket Head Cap Screw (x2)



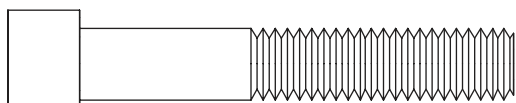
3/8-16 x 1" Socket Head Cap Screw (x1)



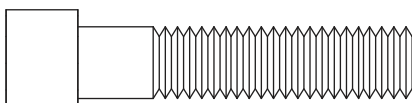
Idler Stand-Off (x1)



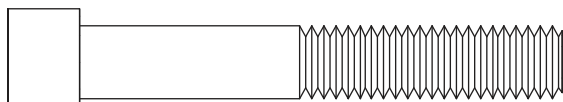
Bearing Sleeve (x2)



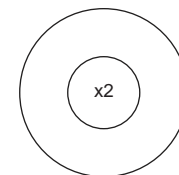
3/8-16 x 2-1/4" Socket Head Cap Screw (x2)



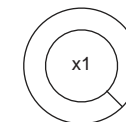
3/8-16 x 1-3/4" Socket Head Cap Screw (x1)



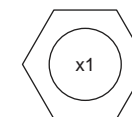
3/8-16 x 2-1/2" Socket Head Cap Screw (x2)



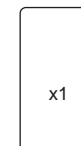
3/8 x 7/8" Flat Washer



3/8" Lock Washer



3/8"-16 Hex Nut



3/16" Load Washer



3/8-16 x 5" Socket Head Cap Screw (x1)





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